



FASTechnologies, Corp.

your drill & rout technology experts

BTR Behind-the-Reader CNC Interface

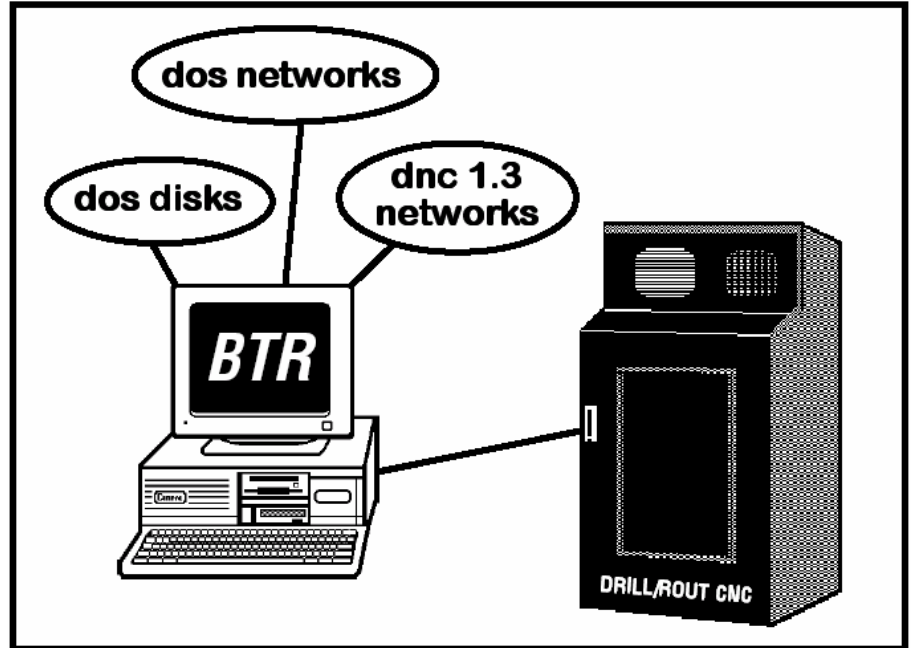
NEW technology
Means lowest cost
Easy installation!

Eliminate paper tapes

installs in minutes

Works with DOS disks,
DOS networks,
DNC network

ClickDrill option speeds
broken-bit recovery



The FASTechnologies BTR interface allows you to eliminate paper tapes, by using a PC to replace your SloSyn paper tape reader. With BTR, your drill or rout controller just loads its part programs directly from the PC.

BTR is simple and inexpensive because it needs no quirky, custom-made interface boards. Installing the BTR is easy: Just plug the supplied cable into your PC's printer port, plug the other end into your CNC's reader interface, and your BTR is "on the air," ready to load your CNC's operating system and part programs with no more paper tapes.

Once you've plugged in the BTR cable, your CNC can load its part programs from any standard DOS diskettes. If you connect BTR's PC to an office network like Novell, Lantastic, or PC-NFS, your CNC can load files directly from your Ethernet, too. There's even a DNC 1.3 network interface to let you connect your BTR-equipped CNC to a DNC 1.3 fileserver, just like the newest controllers.

BTR's optional "ClickDrill" feature is a real time-saver. With ClickDrill, you can forget about the slow "skip" functions on your CNC when you break a tool. ClickDrill displays the panel on the screen, and you use a mouse to click on the hole where you broke the drill bit. In seconds, ClickDrill creates a "makeup" part program containing only the missing holes. When you press your CNC's Start button, it immediately begins drilling the missing holes.

Smart drilling and routing from FASTechnologies

BTR

program specifications

Interface

The BTR package consists of software and a special cable which enable a user-supplied PC to simulate a SloSyn paper tape reader, loading tape images of up to 160 kilobytes (equal to about 1/4 mile of paper tape), using the PC's standard parallel printer port. The supplied interface cable is equipped with a male DB-25 connector which mates to the reader interface connector in Excellon CNC-2, 4, and 6 controllers. If the user's CNC lacks the appropriate connector, an optional adapter with the SloSyn's standard 24-pin Amphenol connector is available.

Text editor

BTR includes a part-program text editor capable of editing files of up to 160 kilobytes in length. If desired, access to this editor may be disabled.

Patch editor

BTR includes an editor capable of modifying the system parameters located at the end of some CNC systems programs. This capability is used by service personnel for modifying the CNC system's leadscrew compensation tables and related parameters.

Tape reader

BTR includes the software capability of using the customer's SloSyn tape reader to transfer data files from punched tape to MS-DOS disk files. In order to use this function, the user must purchase (or construct) a reader interface cable. Schematic diagrams for the optional reader cables are included in the BTR system documentation.

DNC 1.3 interface

BTR includes the software capability of interfacing a DNC fileserver using the Excellon DNC 1.3 network protocol. This allows part program files on the DNC server to be downloaded to the CNC.

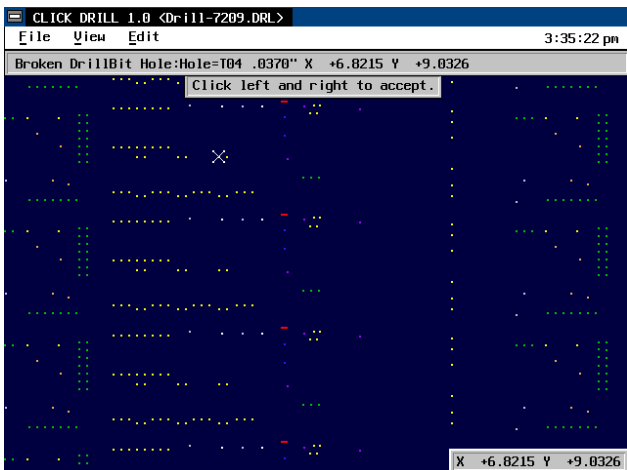
System requirements

A PC compatible computer with an 80286-12Mhz or faster CPU, running MS-DOS 3.0 or greater, with 640K RAM, one megabyte of available hard disk space, and any CRT display. (The ClickDrill option requires a minimum of 4Meg RAM, a VGA or SVGA color display, a mouse with installed software driver, and ten megabytes of available hard disk drive space).

ClickDrill

The optional ClickDrill feature is capable of loading standard Excellon Format-2 drill programs in any axis version. It provides a graphic display of the drill pattern, allowing the user to select a specific hole from which drilling is to begin. ClickDrill creates a temporary drill program, containing only the selected and subsequent holes remaining on that tool. This temporary program is automatically fed to the CNC, allowing the operator to quickly drill holes missed due to a broken tool.

Note: BTR is incompatible with memory-resident programs and drivers. Network interface boards to be used with BTR must be configured to hardware interrupt number eight or higher.



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