



**Supplemental Manual for the**  
**LANCNC-MAZ**  
**FTP LAN network data server for Mazak CNC Controls**  
**T-1, M-1, M Plus, T Plus, M-2, T-2, M32, T32, Fusion**

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## Mazatrol T-1 or M-1



Figure 1: Mazatrol T-1 Control



Figure 2: Data output options

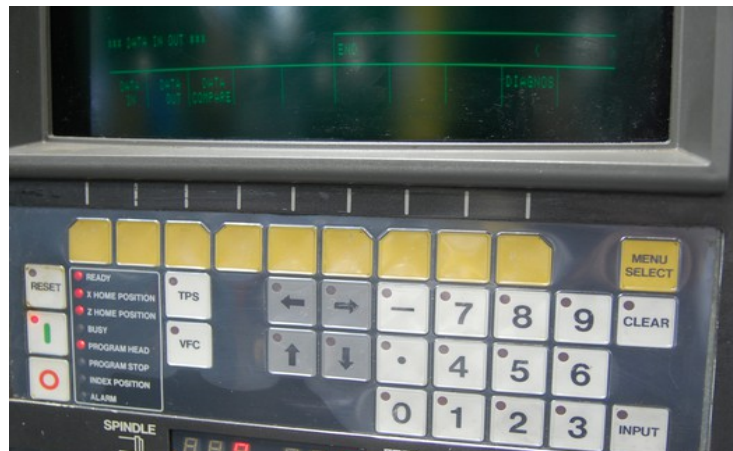


Figure 3: DATA IN and DATA OUT soft keys, INPUT hard key and the display showing END indicating the completion of DATA IN

Refer to the figures above when following the instructions to send or receive files from the Mazatrol on a M-1 or T-1 control.

### To Send CMT programs out to the LANNCNC:

*On the LANNCNC unit:*

1. Choose the CNC to File option on the LANNCNC unit
2. Press the key under Start on the LANNCNC unit (press DIR to choose a different file name to save to).

*On the Mazatrol:*

3. Press Menu Select on Mazatrol
4. Press soft key Data IN OUT on Mazatrol
5. Press soft key Data OUT on Mazatrol
6. The prompt “DATA OUT (INPUT)?” is displayed
7. Press the 1 key to send programs out to LANCNC
8. Press soft key Data OUT
9. Press the Input button
10. When it shows “END” on screen it is complete
- On the LANCNC unit:*
11. Select Done on the LANCNC unit

**To receive CMT programs into the Mazatrol from LANCNC:**

- On the LANCNC unit:*
1. Choose the File to CNC option on the LANCNC unit
2. Choose the file to be sent to the CNC
3. Press button under Start on the LANCNC unit
- On the Mazatrol:*
4. Press the key under Start on the LANCNC unit (press DIR to choose a different file name to save to). Press Menu Select on Mazatrol
5. Press soft key Data IN OUT on Mazatrol
6. Press soft key Data IN on Mazatrol
7. Press the 1 key to receive programs into LANCNC
8. Press the Input button
- On the LANCNC unit:*
12. Select Done on the LANCNC unit

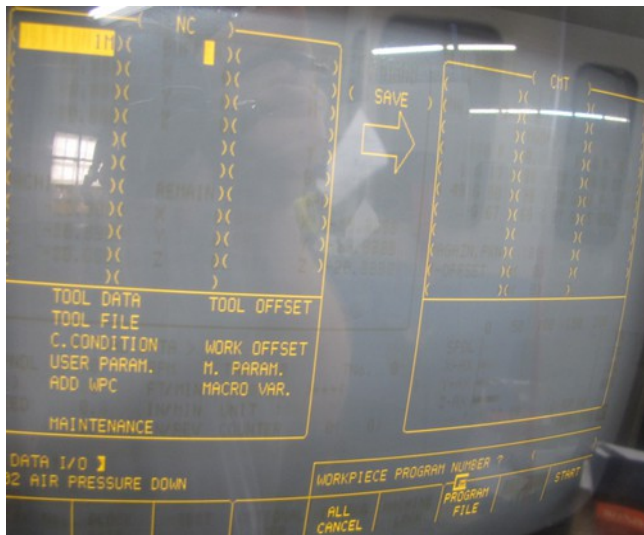
**Mazatrol T-2, M-2, M Plus or M32**



**Figure 4: Mazatrol M Plus**



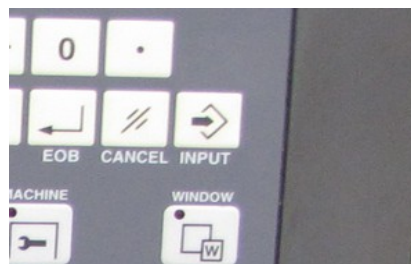
**Figure 5: LANCNC on Mazatrol M Plus**



**Figure 6: Save or Load programs on a Mazatrol M Plus control**



**Figure 7: Parameters on M Plus control**



**Figure 8: Input button the M Plus control**



Figure 10: M-2 control screen



Figure 9: Mazatrol will probably have two DB25 female connectors, the one labeled Cassette must be used to save and load Mazatrol conversational programs. Sometimes the port is label with a picture of a cassette tape. The other DB25 is used only for EIA G code programs.

Refer to the figures above when following the instructions to send or receive files from the Mazatrol on a M-2, T-2, M Plus, T Plus, M32 or T32 control.

### To Send programs out to the LANCNC:

*On the LANCNC unit:*

1. Choose the CNC to File option on the LANCNC unit
2. Press the key under Start on the LANCNC unit

*On the Mazatrol:*

3. Press DATA I/O button on Mazatrol
4. Press soft key CMT I/O on Mazatrol
5. press SAVE NC->CMT button
6. Select Program File on Mazatrol to show existing programs in memory
7. Press the 1 key then Input key on the Mazatrol
8. Shows 1 on the NC side
9. Press soft key START on the Mazatrol

*On the LANCNC unit:*

10. Select Done

### To receive programs into the Mazatrol from LANCNC:

*On the LANCNC unit:*

1. Choose the File to CNC option on the LANCNC unit
2. Choose the file to be sent to the CNC
3. Press button under Start on the LANCNC unit

*On the Mazatrol:*

4. Press DATA I/O button on Mazatrol

5. Press soft key CMT I/O on Mazatrol
6. Press soft key LOAD NC->CMT on Mazatrol
7. Enter program number(s) that are to be loaded on the CMT side of the screen
8. Press Start on the Mazatrol
9. If completed properly Mazatrol will show the program numbers on the NC side of the screen as loaded.  
*On the LANCNC unit:*
10. Select Done

**For Mazak machines that use the CMT protocol, the parameters should be set to:**

**Baud Rate:** 4800

**Data/Parity/Stop:** 8, N, 2

**Flow Control:** CMT16 (for M1 and T1 controls)

CMT Ver 1 (Typically for the older controls, if doesn't verify use Ver 2)

CMT Ver 2 (Typically for the newer controls, if doesn't verify use Ver 1)

**End of Block Delay:** No delay

**End of Block Char:** none/binary

**Start of Tx:** none

**End of Tx:** none

**Start Rx:** Automatic