

<b>Siemens Programmer PG615U with PG615 adapter and power pack</b>	
Interface S5 PLC	Interface PLC
Cable Order No.: 6FC9 340-8G	Cable Order No.: 6FC9 340-8H.
<b>Device Data</b>	
Interface:	20 mA current loop
Transfer rate:	9600 baud
Character format:	1 Start bit, 8 Data bits, 1 Parity bit (even parity), 2 Stop bits
<b>Operating conditions</b>	
For PLC programming the PG685/675/670 Programmer should be connected directly to Interface 1 (20 mA current loop interface) on the SINUMERIK 810.	
<b>Siemens Programmer PG675</b>	
Interface Printer	
Cable Order No.: 6FC9 344-1A.	
<b>Device data</b>	
Interface	R5232 (V. 24)
Transfer rate	1200 baud
Character format	1 Start bit 8 Data bits 2 Stop bits
<b>Operating conditions</b>	
Archiving of NC cycles and programs onto disk, and the transfer to and from the NC and the creation of programs is possible with the PG675. For data transfer, the PG675 should be connected from the printer interface to an R5232 (V.24) interface on the SINUMERIK.	

Siemens page printer PT80

Cable Order No.:

6FC9 340-8C  
R5232 (V. 24)  
6FC9 340-8T  
(20mA)

Device data

Transfer rate:

300 baud

Character format

1 Start bit  
8 Data bits  
2 Stop bits

Order No. for PT80 to SINUMERIK specification:

Type. R5232 (V. 24) :

L22751-A80-D442  
(Interface module  
STT104)

Type. 20mA :

L22751-A80-D441  
(Interface module  
STT104 +  
LAT101)

Additional cable for terminal connection:

6FC9340-4KA

An NC-controlled read operation (start /stop). is possible on the device with a 20mA interface.

Siemens printer PT88

Cable Order No.:

6FC9 340-8D.

Device data

Interface adaptation SAP-S2 (R5232 (V. 24))

Setting of the operating mode switches

Switch S1

1

2

3

4

5

6

ON

ON

ON

OFF

OFF

OFF

(with this setting, the printer has a transfer rate of 9600 baud)

Switch S2

1

2

3

4

5

6

OFF

ON

OFF

ON

OFF

ON

(this setting denotes:  
BUSY (X2.10) line is switched to BUSY (X1.25) line, with negative potential)