

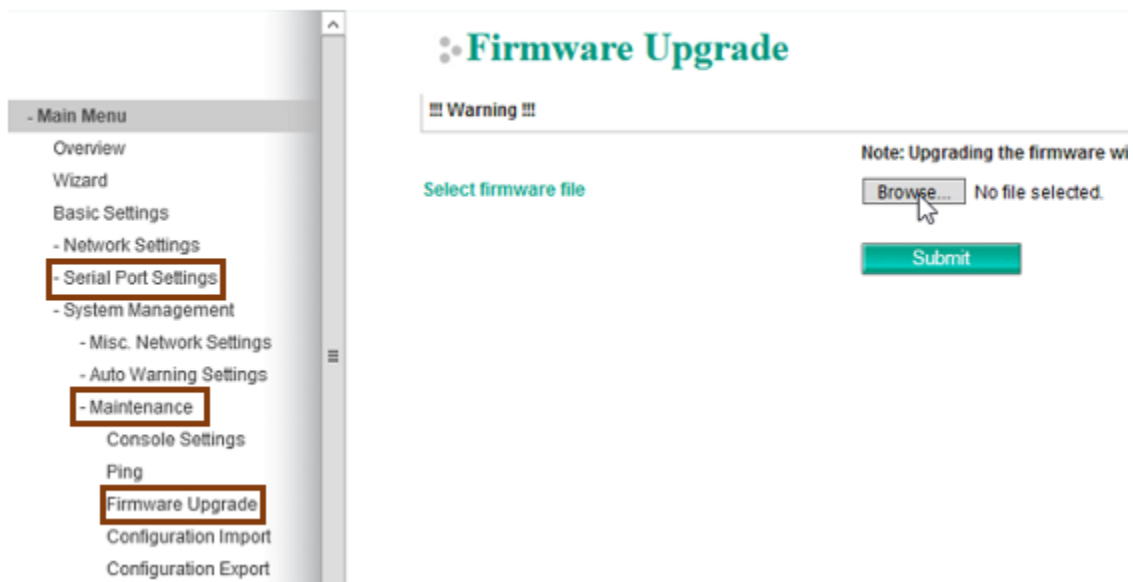
How to Cutover a Moxa Unit to Progressive DNC

1. Navigate to the Moxa unit's web interface and login.

Account

Password

2. Upload the appropriate BTS custom firmware under Serial Port Settings -> Maintenance -> Firmware Upgrade



Firmware Upgrade

!!! Warning !!!

Note: Upgrading the firmware will...

Select firmware file

No file selected.

3. Using the machine's DB printout from the old database, Enter in the settings shown

Old DB PDF:

*** PARAMETERS ***

Com Port: 10
Baud Rate: 4800
Parity: Even
Data Bits: 7
Stop Bits: 1
XON/XOFF: ON
XON/XOFF Start: OFF
XON Char: ASCII 17
XOFF Char: ASCII 19
RTS/CTS: OFF
DTR/DSR: OFF
Force Uploads: OFF
Protocol: User
Protcol Start: Off
Translation: None

Moxa Serial Port Setting Interface

Serial Port Settings -> Communication Parameters. **Always disable FIFO**

Port	Alias	Baud rate	Parity	Data bit	Stop bit	Flow control	XON/XOFF default state	FIFO	Interface
1		4800	Even	7	1	XON/XOFF	XOFF	Disable	RS-232

4. Navigate to Serial Port Settings -> Operation Mode. Change the Operation mode to “TCP Server” and Max connection to 4. At this point, the Moxa will stop communicating with the old system and start communicating with Progressive DNC.

Port	1
Operation mode	TCP Server
TCP alive check time	7 (0 - 99 min)
Inactivity time	0 (0 - 65535 ms)
Max connection	4
Ignore jammed IP	Disable
Allow driver control	Disable
TCP port	4001
Cmd port	966
Connection goes down	RTS <input type="radio"/> always low <input checked="" type="radio"/> always high DTR <input type="radio"/> always low <input checked="" type="radio"/> always high

Data Packing	
Packet length	0 (0 - 1024)
Delimiter 1	00 (HEX) <input type="checkbox"/> Enable
Delimiter 2	00 (HEX) <input type="checkbox"/> Enable
Delimiter process	Do Nothing (Processed only when packet length is 0)
Force transmit	0 (0 - 65535 ms)