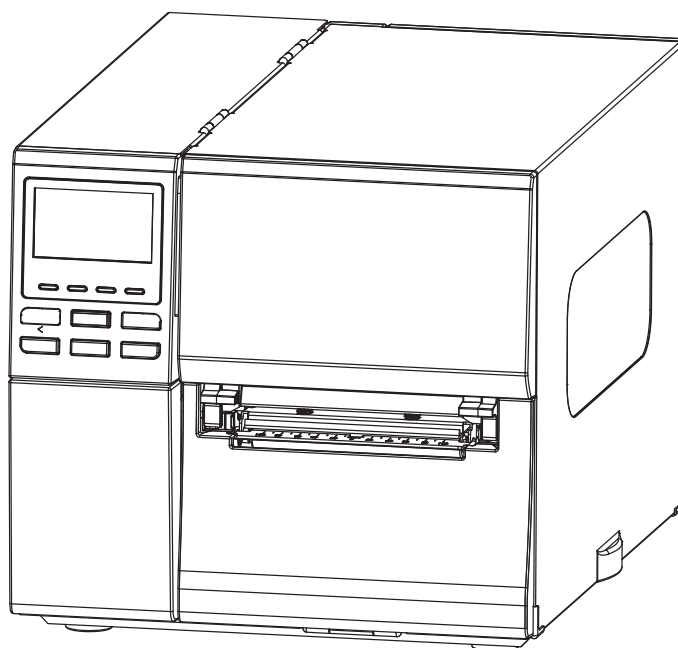


# N-mark

## V Series

# User Manual

2021-04-01



深圳艾维码科技有限公司  
SHENZHEN TDBARCODE TECHNOLOGY CO.,LTD.

## Preface

Thank you for choosing SHENZHEN TDBARCODE TECHNOLOGY CO.,LTD. V series barcode label printer. This user manual includes installation, debugging and printing test information. Please read this manual carefully to achieve the best performance and longest lifespan of this printer. The manual should be kept within reach for daily reference.

For more detailed information, please contact the agent of SHENZHEN TDBARCODE TECHNOLOGY CO.,LTD.

### Note!

1. Without the written consent of SHENZHEN TDBARCODE TECHNOLOGY CO.,LTD. it is not allowed to copy all or part of this manual.
2. The content of this manual may be changed, please pay attention to the company's official website.
3. For questions related to this manual, please consult our company.

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# 1. Product Description

1.1 Features This printer has the following features:

## Various Interfaces

- USB
- Serial Port
- Network Port
- IO Interface

## Simple mechanical structure

The simple printing mechanism makes operation and maintenance simple and easy.

## Outstanding hardware

Model	V420T/V430T/V460T
Performance	
Resolution	203DPI/300DPI/600DPI
Printing speed	203 mm/s(203DPI)/152 mm/s(300DPI)/ 76 mm/s(600DPI)

## 1.2 Unboxing

1. Open the packing box and check whether the printer is damaged. Please note that if you find any damage, please contact the agent or ShenZhen Tdbarcode Technology CO., LTD. for help immediately.

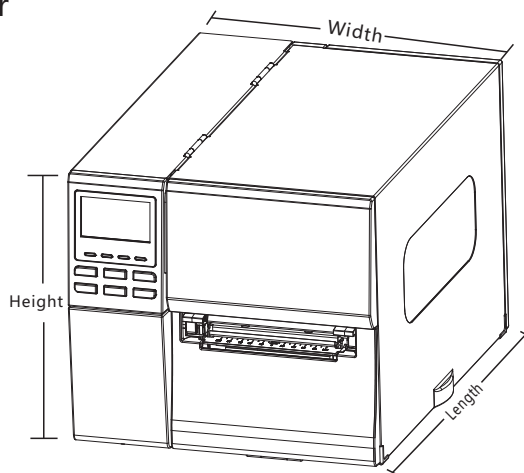
2. Save the box and liner for future transportation of the printer.

1.3 Accessories When unpacking the printer box, please check the accessories provided with the printer:

- Power cord
- USB communication line
- Product manual

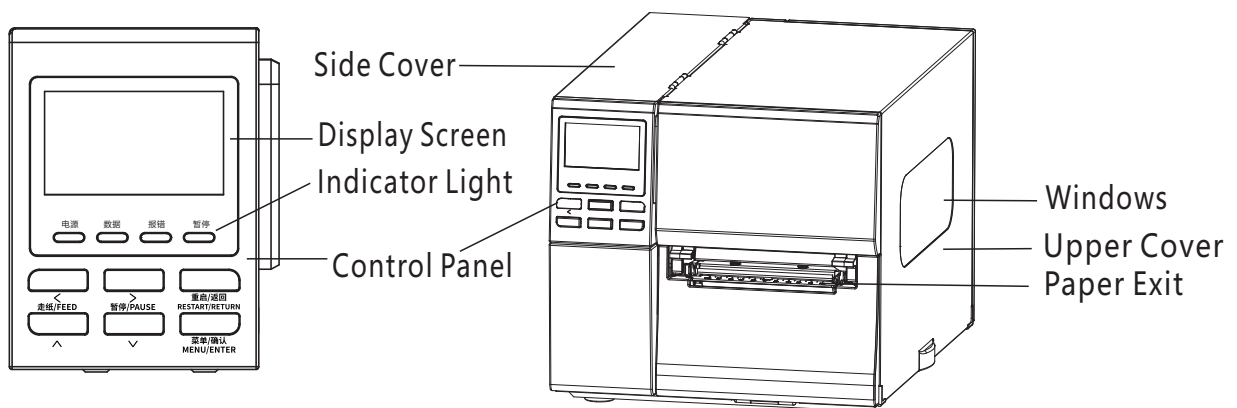
## 1.4 Exterior

### 1.4.1 Size

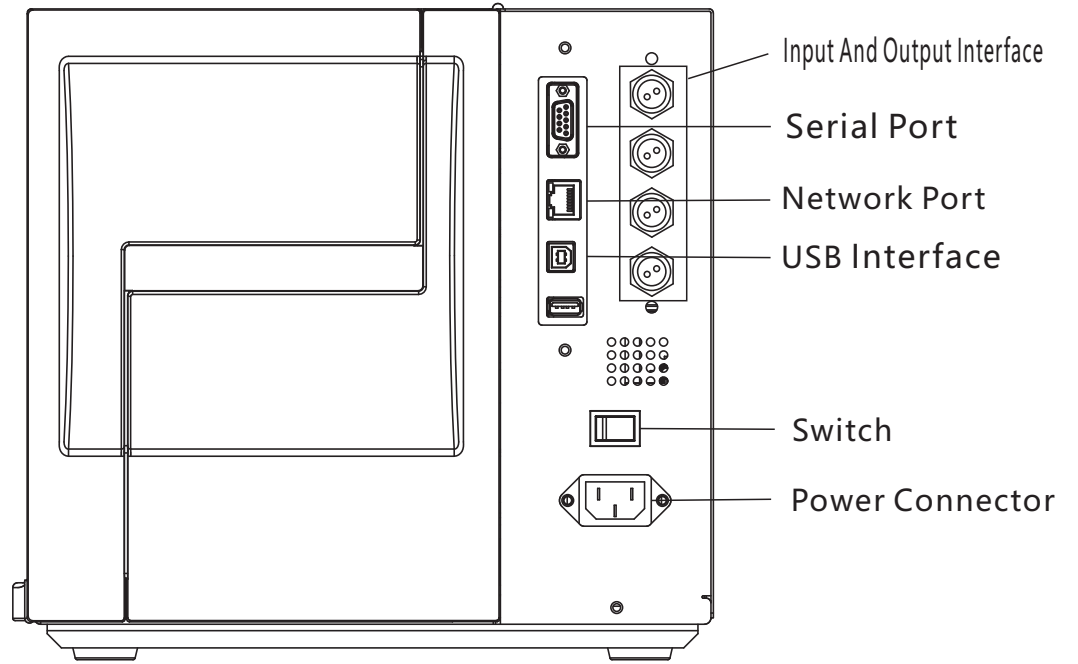


Length: 435mm × Width: 290mm × Height: 275mm

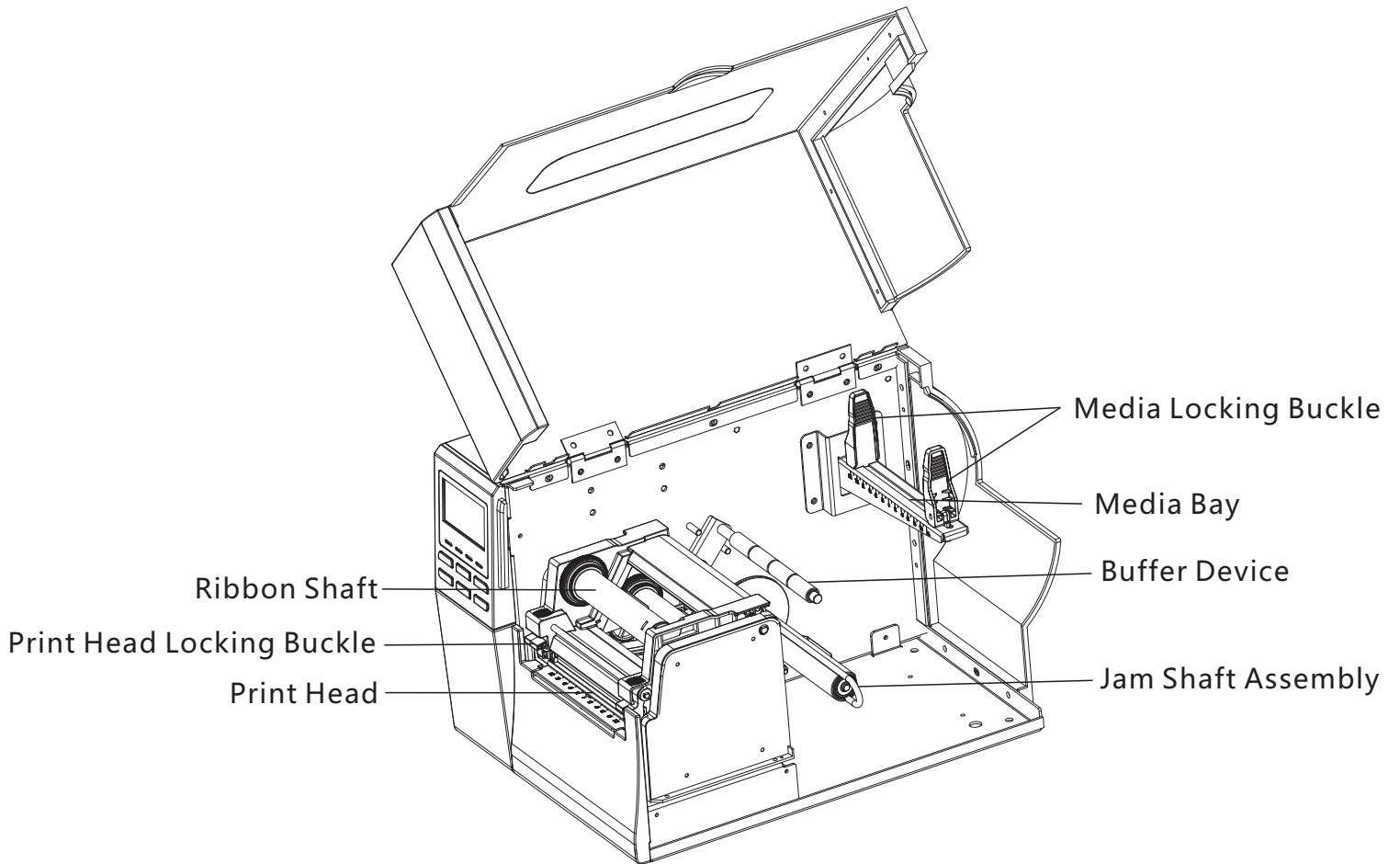
### 1.4.2 Front View



### 1.4.3 Rear View



### 1.4.4 Internal Structure



### 1.4.5 Key Function

Paper feed/FEED	When the printer is in an error state, press this key to restore the normal printing state.
Pause/PAUSE	Press this button during printing, the printer will stop printing after finishing the current label and press this button again to resume printing.
重启/返回 RESTART/RETURN	Restart: Restart in menu mode. Back: Back in menu mode
菜单/确认 MENU/ENTER	Menu: Enter the menu mode. Confirm: Confirm in menu mode.
^ v < >	Arrow keys up, down, left and right (used in menu mode)

## 2. Printer installation

### 2.1 Precautions

This section outlines the necessary installation steps before operating the printer.

This section includes precautions, connection of communication lines, installation of accessories, loading media, and printing test.

To ensure the best operating environment and ensure the safety of operators and equipment, please observe the following precautions.

1. When operating the inside of the printer or cleaning the printer, be sure to turn off the power and unplug the power adapter from the printer.
2. Please store the print media according to the instructions in the manual.
3. This printer contains many high-voltage components. Do not remove any cover of the machine to avoid electric shock. In addition, the printer also contains many precision components, which may be damaged if contacted by unauthorized operators.
4. The outside of the printer must be wiped with a dry and clean cloth or a cloth slightly with a mild detergent solution.
5. During the printing process, if an abnormality is found in the printer, turn off the printer as soon as possible and get in touch with the manufacturer or agent.
6. Do not use the printer in places exposed to strong light (for example: direct sunlight, direct sunlight). These direct light may affect the operation of the printer sensor and cause malfunctions.
7. Remember not to touch the print head directly with your hands to prevent burns or static electricity from damaging the print head due to overheating.

## 2.2 Operation Preparation

This section outlines the printer installation process.

1. Unpack the printer and all accessories.
2. Check the safety precautions in this manual and install the printer in a suitable place.
3. Confirm that the power switch is off.
4. Connect the printer to the host computer through the serial port, network port or USB port communication line.
5. Connect the power adapter to the printer, and then plug the power cord into the correct grounded power socket.
6. Load the print media.
7. Adjust the position of the sensor to suit the media being used.
8. Turn on the power switch.
9. Install the printer driver on the computer.

Note!

After installing the Windows driver, the print media sensor in the printer can be set through the driver. At the same time, the printer can be controlled through the Barlabel program and program commands. For details, please contact the authorized agent of ShenZhen Tdbarcode Technology CO.,LTD.

### 2.3. Turn the printer on/off

Turn on the printer

1. As shown in Figure 1, if the printer has been connected to the computer, press the power switch as shown in the figure to turn on the printer.  
Note (-) is the open side of the switch.

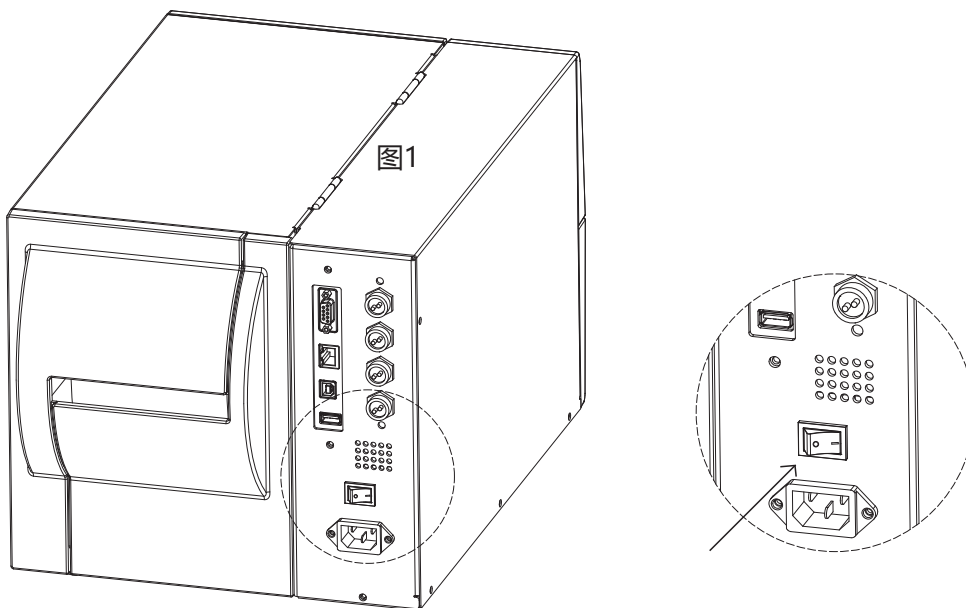


Figure 1

2. The power switch should be used to turn on/off the printer. If the printer is turned on or off by unplugging and plugging the power source, it may cause fire, electric shock or damage to the printer.
3. If the printer cannot enter the normal standby state, please refer to the troubleshooting guide.

## 2.4 Communication line connection

This section outlines how to connect the printer to the host computer through the communication line, and explains how to use communication lines to connect with other equipment. Depending on the printing software you are using, there are three possible solutions for connecting the printer to the host. as follows:

1. Connect the USB communication cable between the USB port of the printer and a USB port of the host computer.
2. Use the network port to connect, one side is connected to the network port of the printer, and the other side is connected to the network port of the computer host.
3. Use a serial cable to connect between the printer serial port and a COM port on the host computer.

### Note!

1. When disconnecting the USB connection with the host, please follow the "Safely Remove Hardware" message displayed on the host.
2. Please use a standard USB cable and type B connectors at both ends.
3. When connecting the USB cable, serial port cable, and network cable, please make sure that the printer and host power are turned off. Otherwise, the motor may be broken or the printer may be damaged.

## 2.5 Power adapter connection

1. Make sure the printer power switch is off.
2. As shown in Figure 4, insert the power adapter plug into the power socket at the back of the printer.

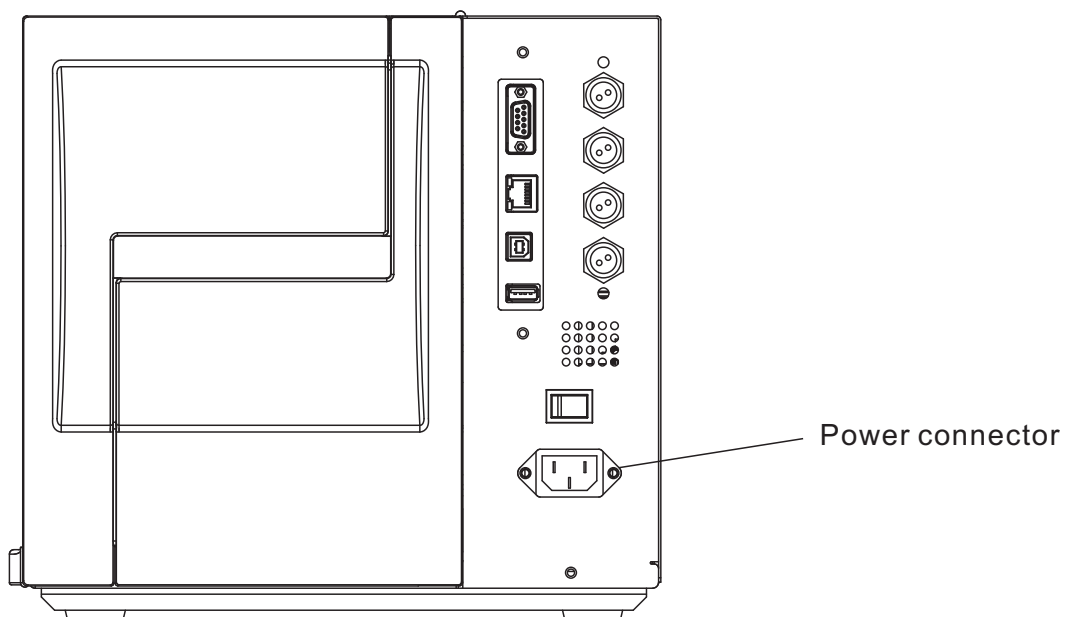


Figure 4

### Note!

Make sure that the printer switch is turned off, otherwise there may be a risk of electric shock.

## 2.6. Open/close the top cover as shown in Figure 5 and Figure 6

Open the top cover

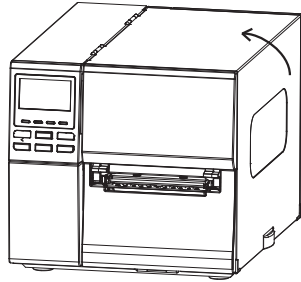


Figure5

Close the top cover

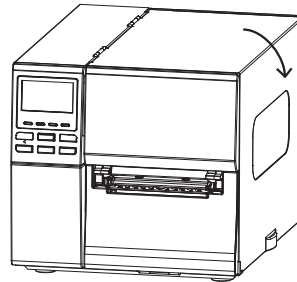


Figure6

### Note!

1. When opening the top cover, please be careful not to touch the print head, otherwise it will damage the print head components due to static electricity, or burn the print head due to overheating.
2. Be sure to close the top cover completely.

## 2.7 Load print media

This section describes how to load print media. This printer accepts labels, tags, and thermal paper media. Please use the media approved by ShenZhen Tdbarcode Technology CO.,LTD.

1. The media sizes that can be loaded into the printer are as follows:

Outer diameter: up to 200 mm

Inner diameter: 40~76 mm

Width: 15~115mm

2. As shown in Figure 7, some media rolls are externally rolled, and some are internally rolled. As shown in the figure below, both types of media need to be loaded with the printing side facing up.

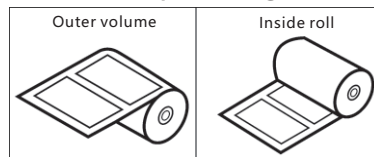


Figure 7

### Note!

1. Do not touch the parts in operation. To prevent the risk of fingers, jewelry or clothes getting caught in the moving parts, be sure to stop all parts of the printer before loading the media.
2. To avoid injury, be careful not to pinch your fingers when opening or closing the top cover.

### 2.7.1 Open the top cover.

- 2.7.2 As shown in Figure 8, move the paper support lock switch in the direction of the arrow to adjust the width of the print media.

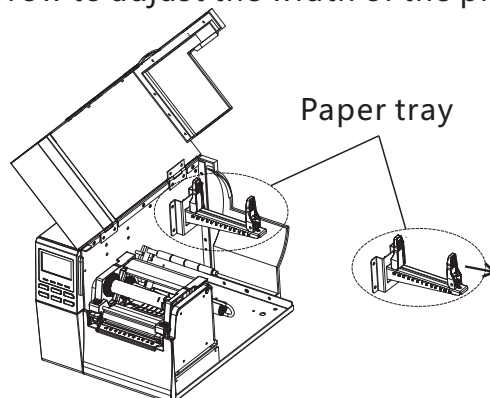


Figure8

2.7.4 As shown in Figure 9, pinch the print head locking buckles at both ends of the print head to open the print head module.

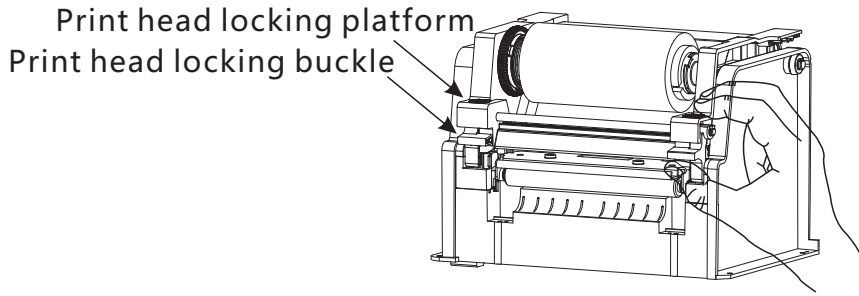


Figure9

2.7.5 As shown in Figure 10, push the media shutter lock button in the direction indicated by the arrow, and then move the media shutter left and right. Place the media in the center position of the media baffle, and then push the media baffle locking button in the direction of the arrow, while sliding the media baffle to the center position, the baffle will be automatically locked when you let go. Ensure that the media is in the center of the media baffle and will not move left or right. Do not squeeze the media with the media stopper, otherwise the media will bend and cause paper jams or paper feeding failures.

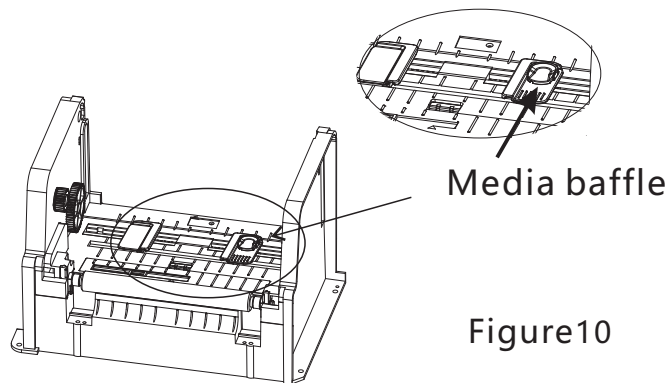


Figure10

2.7.6 As shown in Figure 11, pass the media under the media stop bar until the media reaches the front of the printer.

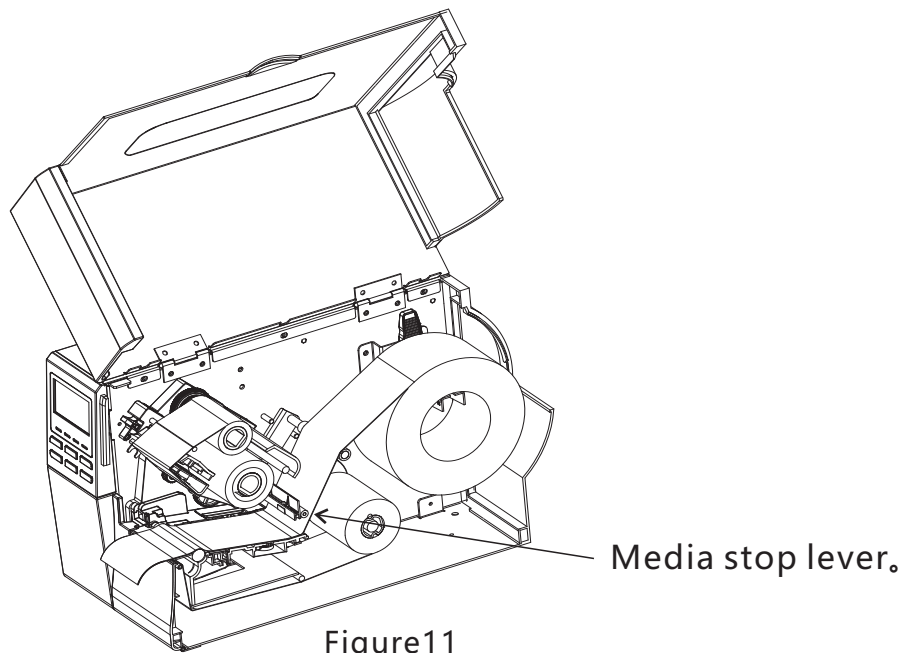


Figure11

2.7.7 As shown in Figure 15, press down firmly on the print head locking platform (as shown in the figure) to close the print head module, until you hear the print head snapping sound.

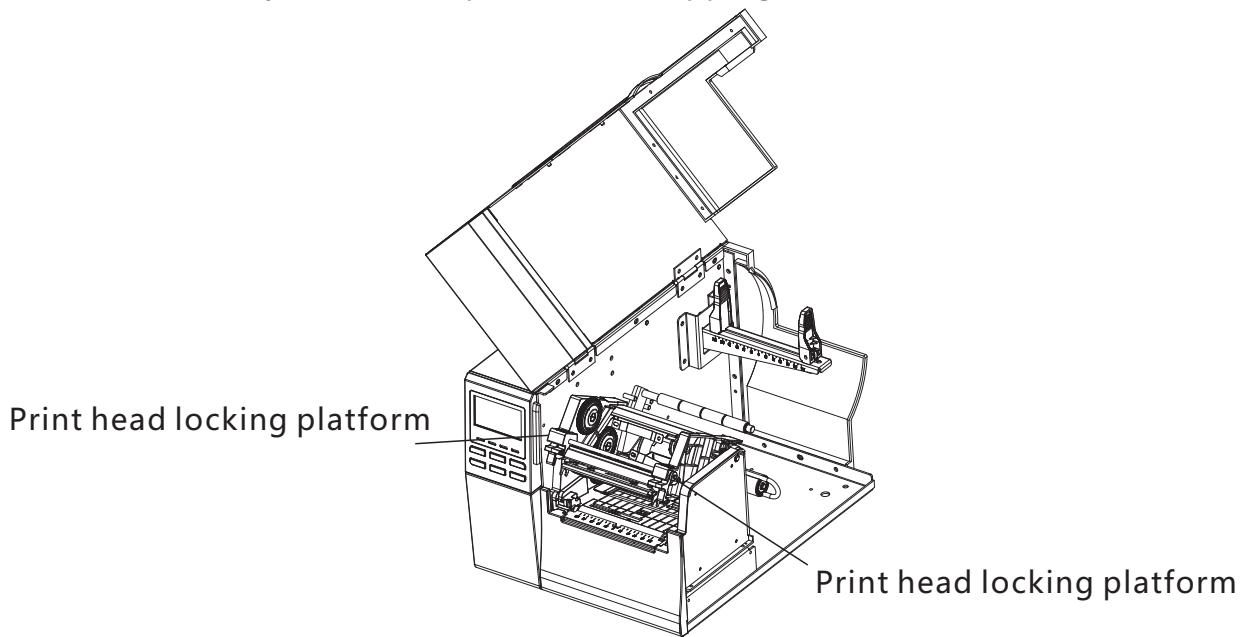


Figure15

2.8 Load the ribbon (thermal printing method, ignored here.)

The ribbon is only used in thermal transfer printing mode. This printer can only use the ribbon with the ribbon layer on the outside. You can use wax-based, hybrid-based or resin-based ribbons. The type of ribbon used should be suitable for the print media used to obtain the best print quality. The width of the ribbon should be greater than the width of the print media to protect the print head and avoid print head wear.

1. Take the ribbon out of the package. The printer comes with a set of ribbon shafts (for 25 mm inner diameter ribbon). Install the ribbon according to the installation method shown in Figure 16.
2. Open the top cover
3. Pinch the locking buckles at both ends of the print head and open the print head module.
4. Lift the print head module to expose the ribbon supply wheel.
5. Install the two ribbon shafts as follows:
  - (1) Install the supply shaft, please align the ribbon supply shaft with the square protrusion on the left side of the ribbon core, install the supply shaft on the ribbon supply wheel, and then insert the right side of the supply shaft into the hole.
  - (2) To install the ribbon take-up shaft, please align the square protrusions on the left side of the ribbon core, and install the take-up shaft on the ribbon take-up wheel, and then insert the right side of the take-up shaft into the hole

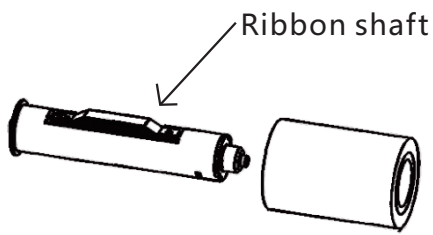


Figure16

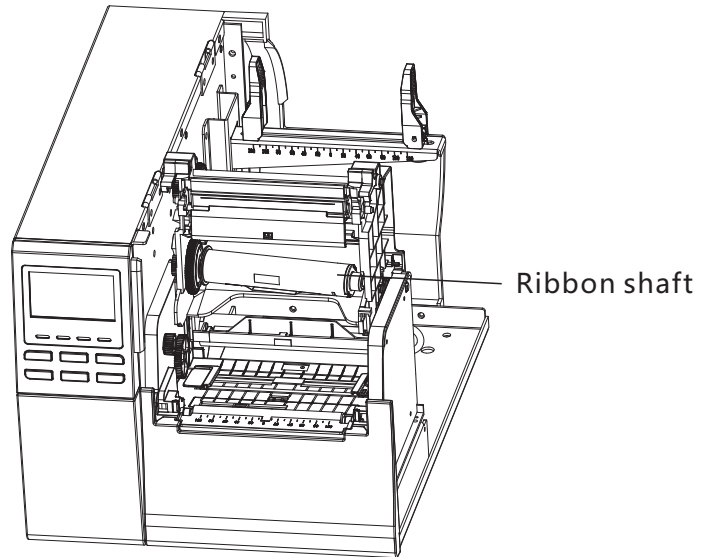


Figure17

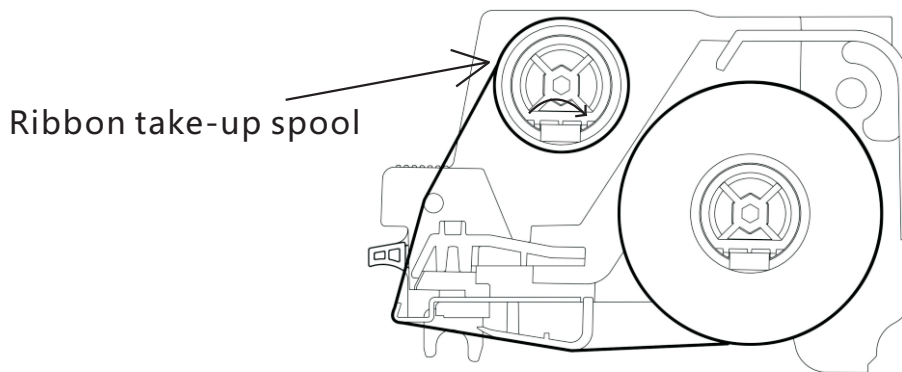


Figure18

6. As shown in Figure 18, rotate the ribbon rewinding wheel to tighten the ribbon and reduce wrinkles.
7. Press down on the print head locking platform at both ends to close the print head module until you hear the print head locking buckle make a sound.

Note!

1. In the direction of the ribbon coating, the coated side of the ribbon must face outward.
2. When using thermal paper, please do not load the ribbon.
3. Make sure that the coated surface of the loaded ribbon corresponds to the printing surface of the media. If the coated surface of the ribbon is loaded upside down, nothing will be printed, and the toner will be transferred to the print head, and the print head needs to be cleaned. If the print head is damaged, it needs to be replaced.
4. As the ribbon is very thin, please do not pull the ribbon forcibly, otherwise it may stretch or damage the ribbon.

### 3.Maintain

This chapter describes how to perform routine maintenance. In order to ensure that the printer can continue to work with high quality, routine maintenance should be carried out regularly. If the printer is used frequently, it should be maintained daily; If the printer is used less frequently, it can be maintained once a week.

#### Note!

1. Make sure to perform maintenance with the power turned off, otherwise it may cause electric shock.
2. Avoid getting your hands caught when opening and closing the top cover of the printer or the print head baffle to avoid injury.
3. The print head will become very hot after work, so let the machine cool down before maintenance.
4. Do not sprinkle water directly on the printer.

#### 3.1 Clean

In order to maintain the printer performance and print quality, please clean the printer regularly or after replacing the print media.

##### 3.1.1 Clean the print head

1. Turn off the printer power.
2. Open the upper cover.
3. As shown in Figure 20, clean the print head with a cotton swab moistened with absolute alcohol or a soft cotton cloth.
4. After the alcohol has completely evaporated, the printer can continue to be used.

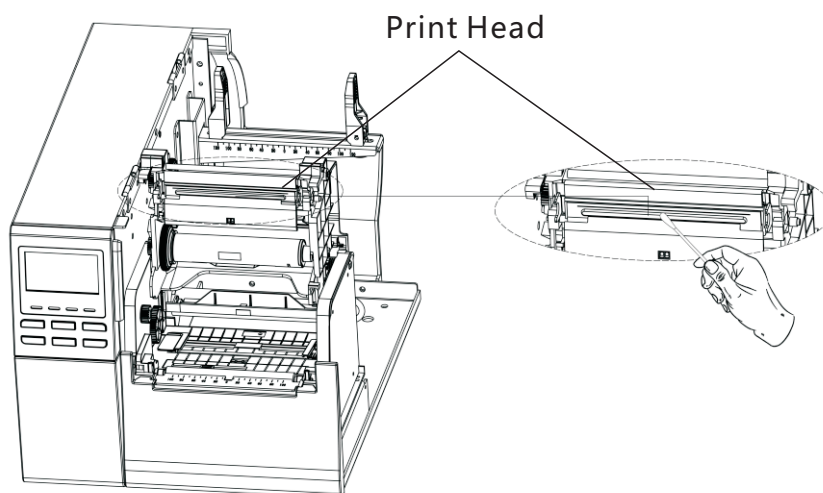


Figure 20

#### Note!

1. Do not touch the print head with any hard objects to avoid damage to it.
2. Do not use any volatile solution including thinner and benzene solution to avoid discoloration of the cover, printing failure or damage to the printer.
3. Do not directly touch the thermal unit of the print head with your hands to avoid burns and static electricity to damage the print head.

### 3.1.2 Clean The Rubber Roller/Sensor

1. Turn off the printer power.
2. As shown in Figure 21, use a soft cloth dipped in absolute alcohol to wipe the cleaning rubber roller.
3. Use a dry soft cloth to wipe the dust or paper debris on the black mark sensor and gap sensor.
4. Do not touch the rubber roller or sensor with any hard objects to avoid damage.

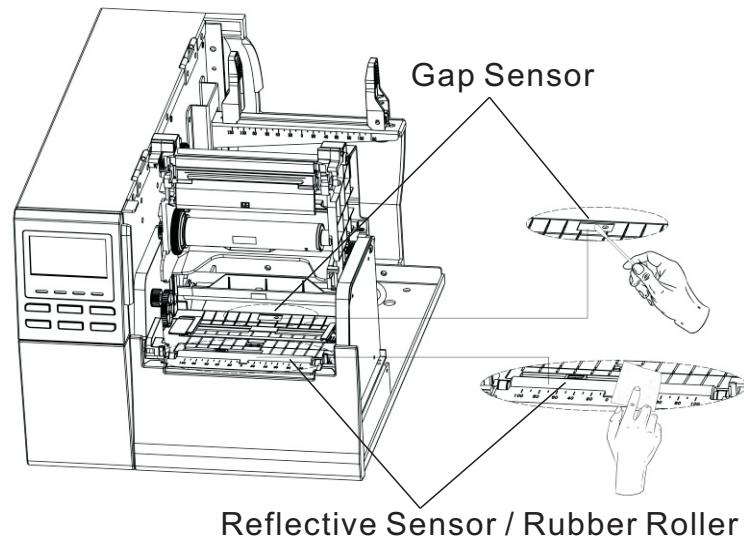


Figure21

### 3.1.3 Clean The Cabinet

1. Turn off the printer.
2. Use a dry soft cloth to clean the top case, or use a small amount of mild detergent to wipe off the dirt.

### 3.2 Maintenance/handling of print media

- The storage time of the media should not exceed the storage period recommended by the manufacturer.
- Do not store the consumables in an uneven place, otherwise they may deform and affect the print quality.
- Store the media in a plastic bag and re-seal it every time you open it, otherwise the attached dust or dirt will wear the print head.
- Store the print media in a cool and dry place, and avoid storing in direct sunlight, high temperature, high humidity, dust and exhaust air.

#### Note!

1. Using non-designated print media will shorten the life of the print head and cause barcode readability issues or print quality issues. All media should be handled carefully to avoid damage to the print media or the printer.
2. During transportation, never put the ribbon and print media inside the printer, otherwise the internal parts of the printer will be damaged.

## 4. Service

If the problem you encounter cannot be solved by the methods provided in this chapter, please do not try to repair the printer yourself, please turn off the printer power and unplug the power cord, and get in touch with the agent authorized by Shenzhen Aiweima Technology Co., Ltd. for help.

### 4.1 Troubleshooting guide

Problem	The Reason	Solution
The power cord is plugged into the AC outlet, but the power light of the power adapter fails to turn on	The power cord is not connected to the power adapter	Disconnect the power cord from the AC outlet, connect the power cord to the power adapter, and then connect it to the AC outlet
	There is a power supply failure, or there is no power in the socket	Replace the power outlet.
The power indicator of the power adapter is on, but the printer indicator is off.	The power plug of the power adapter is not connected to the power hole of the printer	Insert the power plug of the power adapter into the power jack of the printer
	The motherboard power interface is damaged	If it is determined that the motherboard power jack is damaged, please contact your service agent.
Can't print normally	Print data not sent	Send data through printing software or printing commands
	Failed to load the media correctly	Load the media correctly
	The USB communication cable is not properly connected	Correctly connect the USB communication line or replace the USB communication line.
	The bidirectional support function in the driver is turned on	In the device manager, select the driver, right-click, printer properties, and cancel the bidirectional support check in the lower left corner of the port interface.
	The media sensor is dusty	Clean the media sensor
Poor printing	The printing density is not suitable or the printing speed is not suitable	Adjust print density or print speed
	Vendor approved media is not used	Please replace the media approved by the manufacturer
	Dirty print head	Clean the print head
Point missing	Dirty print head	Clean the print head
	Damaged print head	Turn off the power of the printer and contact the agent authorized by Shenzhen Aiweima Technology Co., Ltd. to replace the print head
Media clogged	Failed to load the media correctly	Load the media correctly
Other abnormalities in the printer	The printer is abnormal	Turn off the printer and contact Shenzhen Aiweima Technology Co., Ltd. or an authorized agent.

## 5. Safety

### 5.1 Security Overview

This manual contains information about preparations and reminders for operation. You should read and understand these warnings and reminders before operating and maintaining the machine. Do not repair or modify the machine by yourself. If a malfunction occurs and the methods in the manual cannot be solved, please turn off the printer, unplug the power supply, and contact the authorized agent of Shenzhen Aiweima Technology Co., Ltd.

#### Caveat!

The following instructions indicate that if the machine is operated improperly contrary to the instructions, it may cause serious injury or death.

- It is forbidden to use a voltage that is inconsistent with that on the nameplate of the machine, otherwise it may cause fire or electric shock.
- Do not plug or unplug the power plug with wet hands, otherwise you may get an electric shock.
- If this device and other power-consuming devices use the same socket, it will cause large fluctuations in current. Be sure to provide a separate socket for this device, otherwise it may cause a fire or electric shock.
- Do not place metal objects or containers with liquids on the equipment. If metal objects or liquids enter the equipment, it may cause fire or electric shock.
- Do not scratch, damage or modify the power cord. Do not place heavy objects on the power cord, and do not pull or bend the power cord too much to avoid fire or electric shock.
- If the machine is in an abnormal state, such as smoking or peculiar smell, continued use may cause fire or electric shock. At this time, unplug the power supply immediately and contact Shenzhen Aiweima Technology Co., Ltd. for help.
- When unplugging the power cord, be sure to hold the plug part and pull it out. If you hold the cord part and pull it, the metal wire inside may be broken or exposed, causing fire or electric shock.
- Do not open the machine for maintenance or modification without authorization. The high-pressure and hot parts or sharp edges in the machine may cause injuries. Ensure that the equipment is connected to the ground wire and the cable should also be grounded. If the grounding method is improper, it may cause fire or electric shock.

### 5.2 Precaution

- The following reminders will help you ensure the continuous and normal operation of the machine.
- To avoid the machine in the following unfavorable state :

The temperature is out of specification	Direct light	Excessive Vibration
Sharing power with other devices	High Dust/Gas	High Humidity
- Do not store consumables in direct sunlight, high temperature, high humidity, dust, and gas.
- When a printing failure occurs, all data stored in the machine's memory may be lost.
- Try to avoid using a common power supply with high-voltage equipment or equipment that is likely to cause power interference.
- When you are handling or cleaning the inside of the machine, please unplug the power source to keep your working environment free of static electricity interference.
- Do not place heavy objects on the machine, otherwise it will cause an imbalance and fall, which may injure people.
- Do not block the ventilation holes of the machine, otherwise it will heat up the inside and cause a fire.
- Do not lean your body against the machine to avoid damage caused by falling.
- Please unplug the power cord if you do not use the machine for a long time.

## 6. Appendix

### 6.1 Printer parameters

Project	V420T/V430T/V460T
Power Adapter	Input: AC 100V to 240V, 50/60Hz Output: DC 24V, 2.5A
Operating Temperature	5°C to 40°C (40°F to 140°F)
Storage Temperature	-20°C to 60°C (-40°F to 140°F)
Relative Humidity	25% to 85%RH (Non-Condensing State)
Storage Humidity	10% to 90% RH (Non-Condensing State)
Storage Ventilation Status	An environment with free air circulation
Resolution	203DPI/300DPI/600DPI
Printing Method	Direct Thermal/Thermal Transfer
Task Processing Mode	Batch/Single
Media Sensor	REFL./TRANS.
Printing Speed	200DPI:25mm/s,51mm/s,76mm/s,102mm/s,127mm/s,152mm/s,178mm/s,203mm/s 300DPI:25mm/s,51mm/s,76mm/s,102mm/s,127mm/s,152mm/s, 600DPI:25mm/s,51mm/s,76mm/s,
Media Width	15mm-115mm
Print Width	104mm
Ribbon Length	300m
Ribbon Width	25mm-115mm
Size	435mmX290mmX275mm
Weight	10kg
Available Barcode Types	CODE39, CODE128, CODE39Ext, TIF25, CODE25, MATRIX25, EAN8/13, UPCA/E, CODABAR, CODE93, CODE ONE, CODE49, CODE 16K
Available QR codes	QR code, Data Matrix, PDF417, Maxicode, MicroPDF417
Available Fonts	Arial, LetterGothic, Times Roman, OCR-A/B, Courier, PrestigeElite, 黑体 NMARK0, NMARK1, NMARK2, NMARK3, NMARK4, NMARK5
Rotation Angle	0°, 90°, 180°, 270°
Standard Interface	USB, Serial Port (Optional), Network Port (Optional)

## 6.2 Media Parameter

### 6.2.1 Media Index

Unit: mm

Project \ Model	V420T/V430T/V460T
Media Width	25-115
Media Height	10-2000
Gap Height	2.0-3.0
Black Mark Width	≥5.0
Media Thickness	0.06-0.19
Media Outer Diameter	φ 200
Curl Direction	Outer Volume
Inner Hole Diameter	40-76

### 6.2.2 Carbon Band Index

Types Of	Reel
Width	25-115mm
Length	≤300m
Maximum Outer Diameter	φ 65mm
Inner Diameter Of Shaft Core	25.6mm
Ribbon Curling Direction	Outer Carbon

#### Note!

1. In order to ensure the printing quality and the life of the print head, please use only the approved ones by SHENZHEN TDBARCODE TECHNOLOGY CO.,LTD. Printing supplies.
2. If the width difference between the printing media and the ribbon is too large, it may cause the ribbon to wrinkle. In order to avoid the ribbon For wrinkles, please use a ribbon that meets the correct printing width. It is strictly forbidden to use ribbons narrower than the media.
3. When discarding the ribbon, please follow the local regulations.

### 6.3 Interface

In order to prevent radiation and electronic noise, the interface communication line must meet the following requirements.

1. Fully shielded and with metal or metalized plug shell.
2. The shorter the communication line, the better (depending on the situation).
3. It cannot be bundled with the power cord.

## 6.4 Glossary

The Term	Interpretation Of Terms
Printing Speed	The speed of printing. The speed is expressed in IPS (inches per second) units.
Batch Mode	A continuous printing media processing task mode, this working mode is printing. It will not stop until the required quantity is completed.
Black Label	The black mark is a black mark printed on the printing media. The printer accurately locates the starting position of the printing media by detecting the mark to ensure that the printing position remains unchanged.
Black Mark Sensor	This is a reflective sensor that finds the starting position of printing by detecting the color depth on the back of the printing paper.
Direct Thermal Printing Method	The printing method does not use ribbon, but the thermal media will become hot. The thermal print head directly heats the media, and as a result, the image is printed on the media.
Thermal Transfer Printing Method	In this way, the thermal print head simultaneously heats and pressurizes the ribbon to transfer the ink or toner on the ribbon to the printing media to achieve the purpose of printing.
DPI	The number of dots printed per inch. A unit used to identify print density or resolution.
IPS	Print inches per second, a unit used to identify printing speed.
Gap Sensor	It finds the printing start position of the label by detecting the light transmittance of the label paper.
Print Media	Materials that allow the printer to print images on its surface, such as labels, label paper, signs, etc.
Printer Driver	A software program that converts an application's print request into a language that can be understood by the printer.
Print Head Element	The thermal print head is composed of small and durable thermal elements arranged in a line. When the current passes through, the print head will heat up, leaving a small burning spot on the thermal paper, or the thermal ribbon. A small dot of ink is transferred to ordinary printing paper.
Resolution	Indicates how clear the image is displayed. The smallest unit that composes an image is a pixel. If the resolution increases, the number of pixels increases, and the display result becomes clearer.
Ribbon	A film with ink is used to transfer the image to the media. In the thermal transfer mode, the print head is heated to transfer the ink on the ribbon to the media.

### 6.5 Industrial machine connection PLC application case:

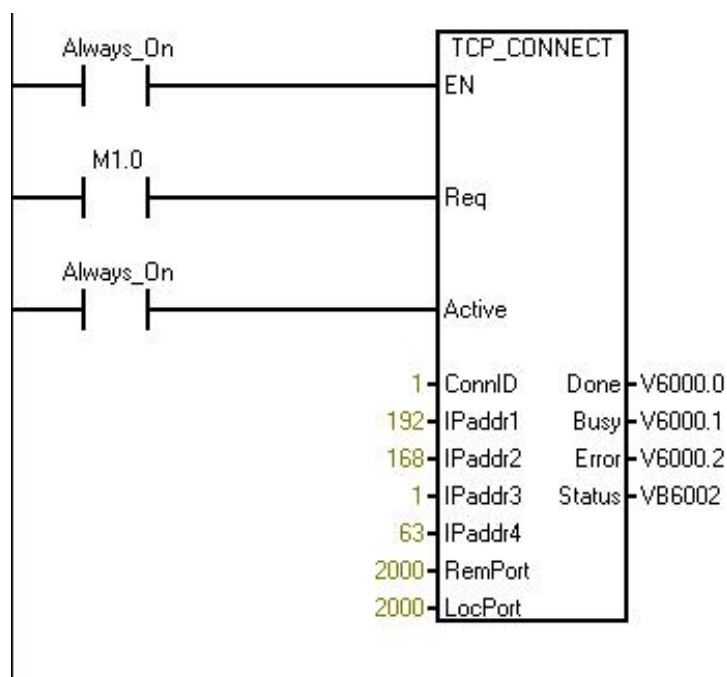
This case uses Siemens S7-200 SMART type PLC as an illustration. The industrial machine is equipped with a network interface and connected to the PLC to realize data communication.

#### 1. Establish a hardware connection:

Use a standard network interface cable to connect the RJ45 interface on the rear panel of the industrial machine with the PLC Ethernet interface.

#### 2. PLC software calls connection instructions

Use STEP 7-Micro/WIN SMART editing software, call the "Open User Communication" category in the instruction library, and establish a network connection with the TCP\_CONNECT instruction.



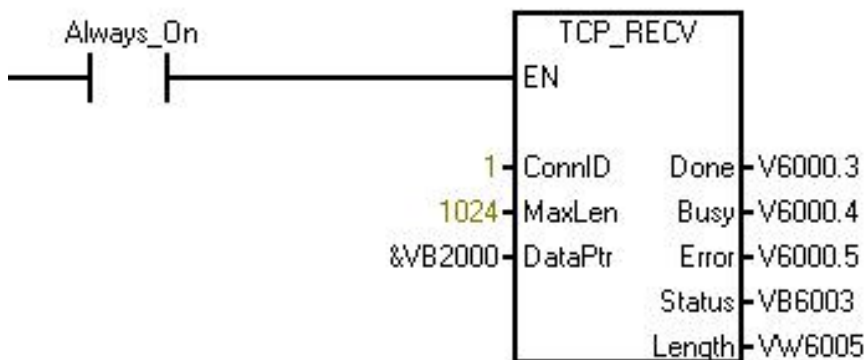
EN	Enable input
----	--------------

Req	The CPU starts the connect operation if Req = TRUE. If Req = FALSE, then the outputs show the current status of the connection.
Active	TRUE = active connection    FALSE =passive connection
ConnID	The CPU uses the Connection ID (ConnID) number to identify this connection for the other instructions. The possible ConnID range is 0 to 65534.
IPAddr1---4	These are the four IP address octets. IPAddr1 is the most significant byte and IPAddr4 is the least significant byte of the IP address.
RemPort	The RemPort is the port number on the remote device. The remote port number range is 1 to 49151. Use zero for passive connections.
LocPort	The LocPort is the port number on the local device. The local port number range is 1 to 49151 with some restrictions. Refer to the LocPort definition in " <a href="#">Parameters common to the OUC library instructions</a> ".

Industrial machine (default)IP: 192.168.1.69    Port: 9100

1. PLC software calls and receives instructions

Use STEP 7-Micro/WIN SMART editing software, call the "Open User Communication" category in the instruction library, and establish the received data with the TCP\_RECV instruction.

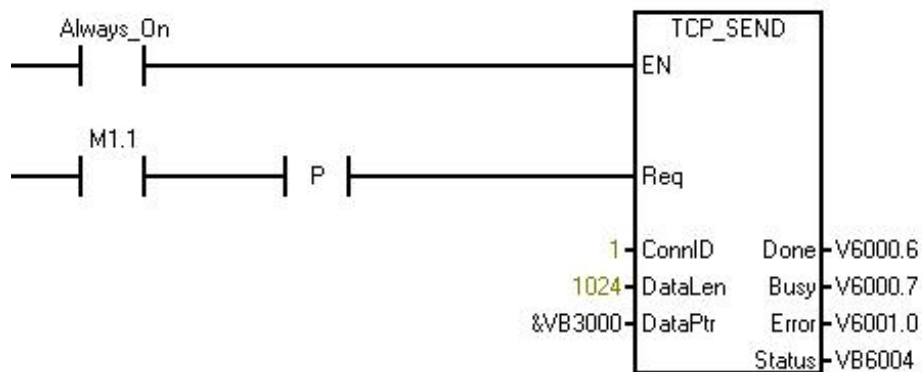


EN	Enable input
ConnID	The Connection ID (ConnID) is the number of the connection for this receive operation (defined during the connect process).
MaxLen	The MaxLen is the maximum number of bytes to accept (for example, the size of the buffer at DataPtr (1 to 1024)).

DataPtr	The DataPtr is the pointer to where the receive data should be stored. This is an S7-200 SMART pointer to I, Q, M, or V memory (for example, &VB100).
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1. PLC software call to send instructions

Use STEP 7-Micro/WIN SMART editing software, call the "Open User Communication" category in the instruction library, and use the TCP\_SEND instruction to establish sending data.



EN	Enable input
Req	The CPU starts the send operation if Req = TRUE. If Req = FALSE, then the outputs show the current status of the send operation.
ConnID	The Connection ID (ConnID) is the number of the connection for this send operation. Use the ConnID that you selected for the TCP_CONNECT operation.
DataLen	The DataLen is the number of bytes to transmit (1 to 1024).
DataPtr	The DataPtr is the pointer to the data to be sent. This is an S7-200 SMART pointer to I, Q, M, or V memory (for example, &VB100).

After establishing the above instructions, you can realize the network interface interconnection with the industrial machine, and carry out data transmission according to the data protocol format.

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