

## Technical Note

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# Configuring Mitsubishi FX3U PLC for KEPServerEX®

The FX3U PLC needs to be configured to communicate with KEPServerEX (and the Mitsubishi suite of drivers offered by Kepware) through the MELSOFT Series GX Works2.

To configure the FX3U PLC through MELSOFT Series GX Works2, follow the steps below:

1. Launch the GX Works2 software application.
2. From the Navigation pane, go to **Project | Parameter | PLC Parameter**.
3. Access the **PLC System(2)** tab, and enable **Operate Communication Setting**.
4. Set the parameters per the table below. Once entered, select **End** to save.

<b>Protocol</b>	Dedicated protocol
<b>Data length</b>	7bit
<b>H/W type</b>	Regular / RS-232C
<b>Parity</b>	Odd
<b>Control mode</b>	Invalid
<b>Stop bit</b>	1bit
<b>Sum check</b>	Enabled
<b>Transmission speed</b>	9600 bps
<b>Transmission control procedure</b>	Form1 (without CR,LF)
<b>Header</b>	Disable
<b>Station number setting</b>	00H
<b>Terminator</b>	Disable
<b>Time out judge time</b>	1 x 10ms

5. From the Navigation pane, go to **Online | Write to PLC**.
6. Select **Clear PLC Memory**.
  - ☀ *It is important to clear the PLC memory before writing the new settings to the PLC. If the PLC memory isn't cleared, the new settings will not take effect.*
7. Select **Execute** to write these settings to the PLC.
8. Cycle the power on the PLC so it is ready to communicate with KEPServerEX.

9. Run KEPServerEX and create a channel for Mitsubishi FX Net.
10. Configure the channel and device properties to communicate with the PLC with the parameters from step 4.