To ring out cables from CNC to PLC

14 pin

Connector on cable
(Male pins toward you)

CNC / PLC Cabinet / DIN

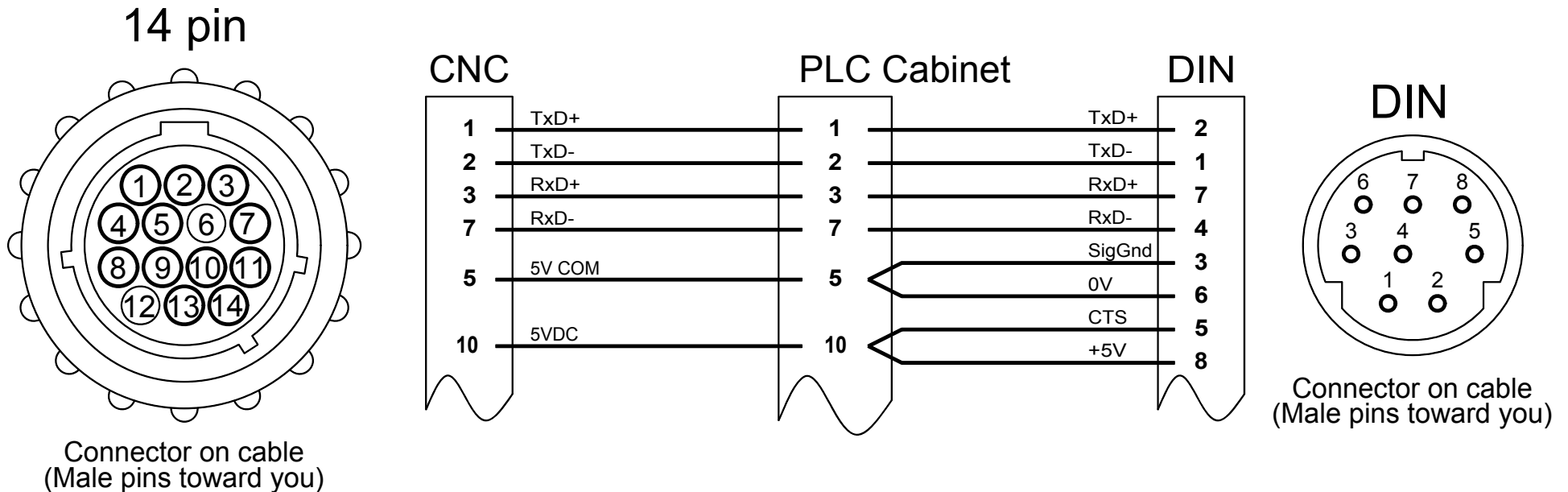| CNC		PLC Cabinet		DIN	
1	TxD+	1	TxD+	2	
2	TxD-	2	TxD-	1	
3	RxD+	3	RxD+	7	
7	RxD-	7	RxD-	4	
			SigGnd	3	
5	5V COM	5	0V	6	
			CTS	5	
10	5VDC	10	+5V	8	

DIN

Connector on cable
(Male pins toward you)

If porttest passes at the PLC output of the CNC, then the issue is downstream, toward the PLC.

If DIN loop-back connector is not available, the cables can be rung out ('beeped') with a continuity tester or ohmmeter.

The illustration above shows the wires that run between the 14 pin circular connector that connects to the CNC, and the 8 pin DIN connector that connects to the PLC.