810 / 820 Service Course

How to reload your NC?

Reloading your Control

- If you power up your control and it is either visibly corrupted, power up in German or the screen does not power up at all; you then need to follow the procedure below to reload your control from your backup.
- Firstly you need to power up your control with the eveball key pressed .Power the control off

  the press the EYEBALL key on the control then power the control on while keeping the Eyeball key pressed.
- When your control has powered up it should be in INITAIL CLEAR MODE. This mode allows you to clear out all the corrupted data.
- If your control has powered up in German press MACH-DATEN (forth soft key) if it's in English press MACHINE DATA.
- Starting with the first soft key on the left press four soft-keys in total. You should see small ticks appear against options on the screen.
- Press the RECALL Button to go back to the screen you powered up in.
- Press PLC INITIAL, this is the same in German and English (third soft key).
- Press the first two soft-keys from the left. Again ticks will appear against the options.
- Press the RECALL Button to go back to the screen you powered up in.
- If in German press NC DATEN in English it will be NC DATA (second soft key).
- Press the first three soft-keys from the left. Ticks again will appear against the options.
- Press the RECALL Button to go back to the screen you powered up in.
- You have now cleared out all the corrupted data. If the control is in German it is preferable to change the language to English. To do this follow the steps below.

How to select English.

- After you have carried out the above steps you need to do the following to make to control display English.
- Press INBETR ENDE (last soft key).
- The control will now power off and then back up again normal running mode.
- Press DIAGNOSE (if Diagnose is not present press and the option should then appear)
- Then press the RIGHT SCROLL Button so that you see NC MD and press the soft key.
- Type 250 then the search button this will highlight the Machine Data. Machine Data

  250 is for either a Milling machine or a Lathe and Machine Data 199 for either a Grinder or a Nibbling machine and is for Language Selection.
- Now press the EYEBALL Button.
- Type 1111
- Press the ENTER Button

- Type 1 and press ENTER Button accept the setting.
- Press the EYEBALL Button
- Press the first soft key on the Left.
- The control should now power off and back on again in INITIAL CLEAR Mode but this time in English.

Reloading Your Data.

- Once the control has powered back up you can now reload your data.
- Press MACHINE DATA (forth soft key).
- Starting with the first soft key on the left press four soft-keys in total. You should see small ticks appear against options on the screen. This will clear any machine data and load Standard machine data for both the NC & PLC.
- Press the RECALL Button to go back to the screen you powered up in.
- Press PLC INITIAL (third soft key).
- Press the first two soft-keys from the left. Again ticks will appear against the options. This will clear the PLC Program and also clear any Retentive Flags from the PLC memory.
- Press the RECALL Button to go back to the screen you powered up in.
- Press NC DATA (second soft key).
- Press the first three soft-keys from the left. Ticks again will appear against the options. This will Format the USER Data, Clear the Part Program & Clear the Alarm Text.
- Press the RECALL Button to go back to the screen you powered up in.
- Now press DATA IN/OUT (first soft key).
- You will now see the Setting Data page. You now need to input the correct port settings for data transfer using PCIN.
- The settings are as follows:-

  5010 = 00000000 - This sets the device as RTS
  5011 = 11000111 - This sets 2 Stop Bits, 7 Data Bits & 9600 Baud
  5016 = 00101000 - This sets Data Transmission details.
- You now need get your PC / PG ready for transmission.

Starting Pcin:

Double click on the *pcin* icon on the desktop

Pcin Settings:

When Pcin has loaded up, use the your cursor keys to highlight V24_INI.

When highlighted press ENTER.
Use your up & down cursors to highlight the settings and then your left & right cursors to select the correct settings.

Following settings should be used: -
COM NUMBER 1
BAUDRATE 9600
PARITY EVEN
STOPBITS 2
DATABITS 7
TIMEOUT 4s
BINFILE OFF

Once you have completed your settings press ENTER & then press Y for SAVE INPUT. This will then set your port settings for data transmission.

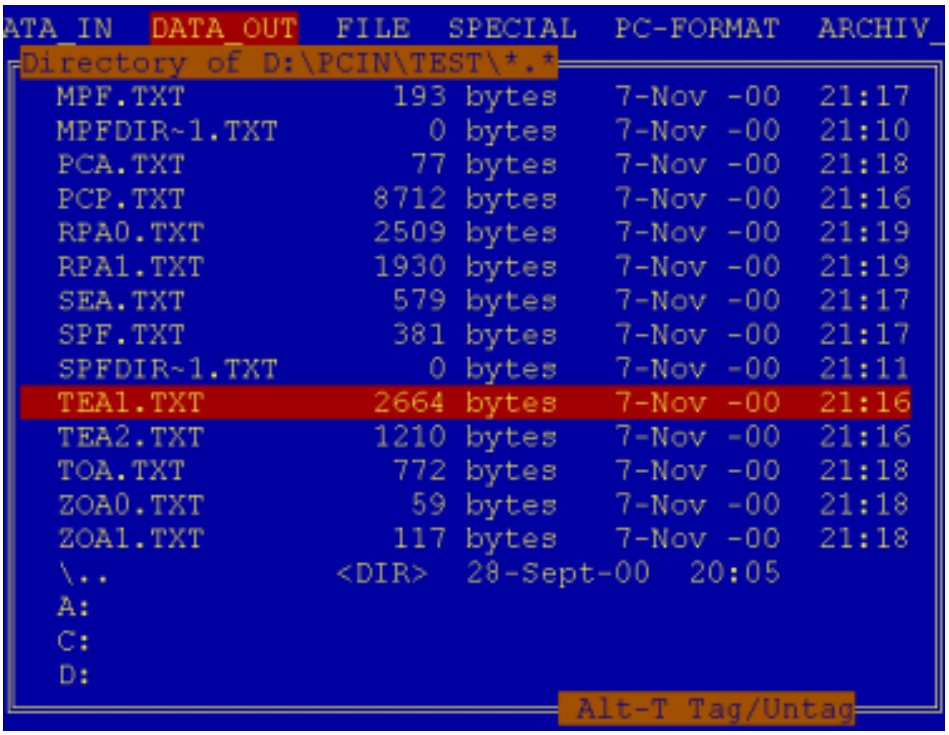
Changing into the directory you have created

Once you have created a directory, you must now change directory so that all the data is saved in it.

- Highlight FILE using your cursors.
- Press ENTER so that the drop down menu appears.
- Again use your cursor to highlight CHANGE DIR.
- Press ENTER on your PC.

- When the box appears showing the directory which you are in press the SPACE BAR on the PC. This will clear the box.
- Press ENTER on the PC and the window opposite will appear.
- Use your cursor to highlight the directory, which you have created.
- Press F2, this will accept the directory.

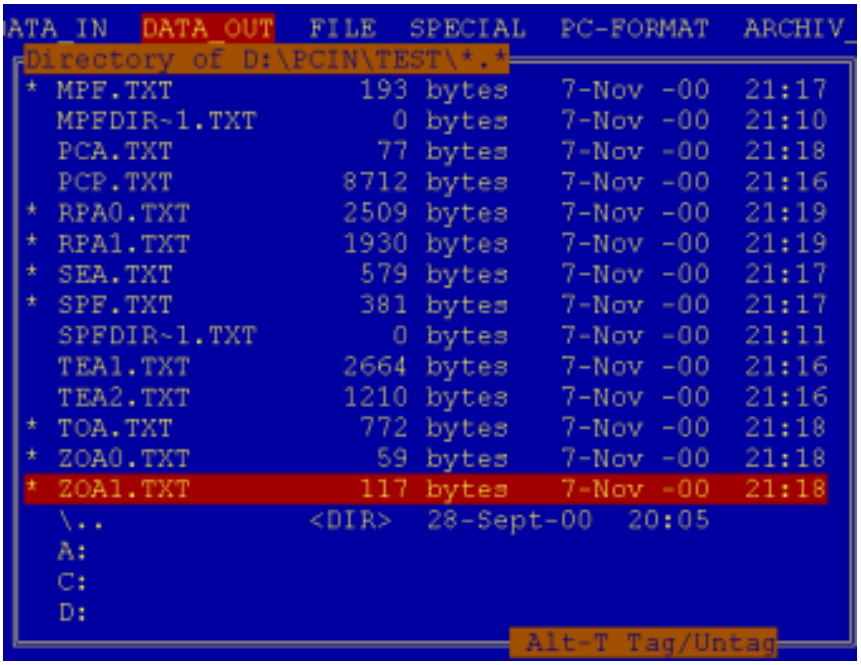
- You now need to start to reload your data from your PC to the NC in order.
- On you PC highlight DATA OUT and press your ENTER Button.
- Press your SPACE BAR on your PC to clear the contents of the window.
- Press the ENTER Button on your PC.
- Now using your cursor highlight TEA1



- Now press ENTER on the PC.
- Your PC will now wait.
- On your NC press DATA IN/OUT.
- Connect your RS232 cable COM1 of the PC & the Front interface of the NC
- Type 1 then ENTER on the NC. This will set the interface number.
- You will see the Data transfer from the PC to the NC.
- Repeat the procedure above but this time select TEA2 on the PC to transfer.
- When you have transferred TEA1 & TEA2 press on the NC.
- Press END SETUP PW (last soft key) on the right.
- When the control powers up it will be in normal running mode.
- You need to go back into INITAIL CLEAR Mode.
- Now press the EYEBALL Button.
- Type 1111
- Press the ENTER Button
- Press the EYEBALL Button
- Press the first soft key on the Left.

- The control should now power off and back on again in INITIAL CLEAR Mode.
- Press PLC INITIAL (third soft key).
- Press the first two soft-keys from the left. Again ticks will appear against the options. This will clear the PLC Program and also clear any Retentive Flags from the PLC memory.
- Press the RECALL Button to go back to the screen you powered up in.
- Press NC DATA (second soft key).
- Press the first three soft-keys from the left. Ticks again will appear against the options. This will Format the USER Data, Clear the Part Program & Clear the Alarm Text.
- Press the RECALL Button to go back to the screen you powered up in.
- Now press DATA IN/OUT (first soft key).
- You will now see the Setting Data page. You now need to input the correct port settings for data transfer using PCIN.
- The settings are as follows:-

  5010 = 00000000 - This sets the device as RTS
  5011 = 11000111 - This sets 2 Stop Bits, 7 Data Bits & 9600 Baud
  5016 = 00101000 - This sets Data Transmission details.
- Now on your PC Highlight DATA OUT.
- Press ENTER on the PC.
- Press your Space Bar to clear the window.
- Using your cursor keys highlight PCP.
- Then press Enter on your PC.
- Your PC will now wait.
- On your NC press DATA IN.
- Type 1 then ENTER on the NC. This will set the interface number.
- You will see the Data transfer from the PC to the NC.
- Repeat the procedure above but this time select PCA on the PC to transfer.
- When you have transferred PCP & PCA press on the NC.
- Press END SETUP PW (last soft key on the right.)
- On the NC press DATA IN/OUT.
- Press DATA IN START.
- On the PC Highlight DATA OUT.
- Press ENTER on the PC.
- Press the Space Bar to clear the window.
- Press ENTER on the PC.



- Using ALT T select any files which you have not already transferred. You will see an asterix appear next to each file you tag. Do not tag any file with a .DIR extension and make sure that when you have selected all your files that you leave the highlight over one of the tagged files.
- Press ENTER on the PC.
- The rest of the files will now be transferred.
- When finished press DATA STOP on the NC.
- Your NC should now be ready for operation.