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MEMORY UPGRADE FOR FADAL MACHINES

The installation of Fadal memory expansion is a simple procedure when following the enclosed instructions.

INSTALLATION PROCEDURE

STEP 1 – RECORD ALL PARAMETERS IN THE CNC CONTROL.

Use the form to record your current parameters settings BEFORE installing the new memory board.

At the CNC prompt ENTER NEXT COMMAND

Enter the command SETP to display the parameter tables and record each setting. After installing the memory board you will need to reenter all the CNC parameters.

LAST HOME POSITION X _____ Y _____ Z _____		
X-AXIS BACKLASH _____		
Y-AXIS BACKLASH _____		
Z-AXIS BACKLASH _____		
A-AXIS BACKLASH _____		
B-AXIS BACKLASH _____		
BACKLASH settings		
PARAMETER settings – Page 1		
FORMAT: _____	BAUD RATE: _____	SPINDLE AFTER M6: _____
AXES: _____	TRAVEL: _____	PENDANT: _____
DEFAULT: _____	A-AXIS RATIO: _____	M60/A-AXIS BRAKE: _____
DEFAULT: _____	B-AXIS RATIO: _____	M60/B-AXIS BRAKE: _____
DEFAULT: _____	TOOL CHANGER CAP: _____	IMM FIXED CYCLE: _____
RPM FACTOR: _____	SPINDLE TYPE: _____	ORIENTATION FACTOR: _____
PARAMETER settings – Page 2		
DEFAULT: _____	M8: _____ M7: _____	3 PHASE > 5% LOW: _____
PU FORMAT: _____	N-WORDS ORDERED: _____	TOOL TABLE: _____
CRC MODE: _____	BINARY BUFFERS: _____	HIGH TORQUE: _____
SPINDLE OFF: _____	TURRET FACTOR: _____	CMD MENU: _____
PALLET: _____	GAIN: _____	RAMP: _____
ASPECT: _____	TIMERS: _____	OVERLOAD: _____
PARAMETER settings – Page 3		
SCREW: _____	IPM: _____	XYZ RAMP: _____
Z TAP GAIN: _____	VECTOR: _____	AXIS DISPLAY: _____
AUTO BRAKE: _____	A-PALLET: _____	B-PALLET: _____
5-AXIS HEAD: _____	G0 DETAIL: _____	FEEDBACK: _____

STEP 2 – INSTALL MEMORY EXPANSION BOARD.

Power OFF the machine, remove the 1400 CPU board and attach the expanded memory board.

STEP 3 – CLEAR AND FORMAT THE MEMORY.

Power ON the machine.

Enter CNC Diagnostics – Enter the command DI then type G0 3000 Note: use zero not the letter O
Select ZERO MEMORY
Select Y (to lose all programs) Power
Off CNC, wait 10 seconds.
Power ON

Reinitialize the memory for the CNC format:

At ENTER NEXT COMMAND

Enter command RI

Y

Y

Y

(control restarts)

AT ENTER NEXT COMMAND

Enter SETTO command to set the current tool in the tool turret as number 1

Enter BL command and set original backlash values

Enter SETP and set all parameter values to the recorded values from the work sheet in step 1.

Press MANUAL to exit parameter menu

Power OFF the CNC and restore power after 10 seconds.

STEP 4 – TESTING THE MEMORY.

AT ENTER NEXT COMMAND

Enter DT command - All values should be zero

Enter the ME command to verify the new memory capacity.

IMPORTANT NOTE: The machine is ready to run. Caution needs to be taken since the CNC parameters have been changed and the possibility of incorrectly setting a parameter could affect the machines operation. It is recommend that you “Dry-Run” the machine and verify correct operation of the machine before machining parts.

If you have any questions, call us at 888-949-2939 Ex 2 or email support@nxgencnc.com.