

Fadal Zero-Out Memory Procedure, pg 1 of 2 (Fadal CNC)

NOTE: Save all stored programs and data to disk before completing this procedure.

At the VMC Pendant:

1. Send the VMC to the Cold Start position.
 - a. Type SETCS and press ENTER.
 - b. Type HO (home) and press ENTER.
 - c. Press the START button.
2. Display and record the BACKLASH settings:
 - a. Type BL and press ENTER.
 - b. The backlash settings will be displayed, Record the settings.
 - c. Press the MANUAL button, to return to the ENTER NEXT COMMAND screen.
3. Display and record the PARAMETER settings:
 - a. Type SETP and press ENTER.
 - b. The first page of the PARAMETERS will be displayed. Record the settings.
 - c. Press the SPACE BAR or the letter P, to go to the next page. Record the settings.
 - d. Repeat step c, until all pages have been recorded.
 - e. Press the Manual button, to return to the ENTER NEXT COMMAND screen.
4. Zero the CPU memory:
 - a. Type DI and press ENTER.
 - b. Type G0 3000 and press ENTER, to display the Diagnostics Menu.
 - c. Press the SPACE BAR, to get to the second page of the menu, and select option 5 (Zero Memory).
 - d. Answer yes to all of the questions that the control asks (Type Y). The CPU Memory is reset.
5. Power off the VMC. **Do not select option 2 (Start CNC)**
6. Wait at least 30 seconds and power on the VMC.
7. Cold Start the machine.
8. Press the MANUAL button until ENTER NEXT COMMAND is displayed.
9. Type SETP, to enter the PARAMETERS Page. Enter all of the settings on all pages.
10. Press the MANUAL button, until the ENTER NEXT COMMAND is displayed.
11. Type BL, to enter the BACKLASH settings.
12. Enter the Backlash settings on all axes.
 - a. X Axis – Type BL,1
 - b. Y Axis – Type BL,2
 - c. Z Axis – Type BL,3
 - d. A Axis – Type BL,4
 - e. B Axis – Type BL,5
13. Load the programs and offsets into the machine.
14. This Procedure is complete.

Fadal Zero-Out Memory Procedure, pg 2 of 2

Fadal Parameter Settings

FORMAT _____ BAUD RATE _____ SPINDLE AFTER M6 _____
AXES _____ TRAVEL _____ PENDANT _____
DEFAULT _____ A AXIS RATIO _____ M60/ A AXIS BRAKE _____
DEFAULT _____ B AXIS RATIO _____ M62/ B AXIS BRAKE _____
DEFAULT _____ TOOL CHANGER CAP _____ IMM. CYCLE _____
RPM FACTOR _____ SPINDLE TYPE _____ ORIENTATION FACTOR _____
DEFAULT _____ M8 _____ M7 _____ 3 PHASE 5% LOW _____
PU FILE _____ N WORDS ORDERED _____ TOOL TABLE _____
CRC MODE _____ BINARY BUFFERS _____ HI TORQUE/RIGID TAP _____
SPINDLE OFF _____ TURRET FACTOR _____ CMD MENU _____
PALLET _____ GAIN _____ RAMP _____
ASPECT _____ TIMERS _____ OVERLOAD _____
SCREW _____ IPM _____ X Y Z RAMP _____
Z TAP GAIN _____ VECTOR _____ AXIS DISPLAY _____
AUTOBRAKE _____ A-PALLET _____ B-PALLET _____
5 AXIS HEAD _____ G0 DETAIL _____ FEEDBACK _____
AT SPEED _____
X-AXIS BACKLASH _____, _____, _____
Y-AXIS BACKLASH _____, _____, _____
Z-AXIS BACKLASH _____
A-AXIS BACKLASH _____
B-AXIS BACKLASH _____