

TO: All interested parties.
 FROM: Anilam Electronics Corp., Applications Eng.
 REF: DNC (continuous download) on CRU M and CRU II mills.
 DATE: 25 July 89

- a) The structure of the program to be down-loaded from offline must be correct.
- b) The first and last character of the program must be a % sign. Each section or 'cluster' of program must begin AND end with the % character, with the first and all intermediate sections also containing M2000 and a Z+ move as the last two lines of that section (excluding the %).

ALSO:

EXAMPLE:

%	beginning % sign
data	
~~~~~	
M2000	continuous path off
G0 Z1.	Z move away from part
%	end of cluster sign
%	begin cluster sign
G1 Z_____	Z move back to previous pos'n
M1000	continuous path back on
data	
~~~~~	
M2000	continuous path off
G0 Z1.	Z move away from part
G29E	program end
%	DNC end

① CUTTER COMP. MUST BE TURNED OFF BEFORE DOWNLOAD THEN ON AGAIN IN THE NEXT DATA BLOCKS.

The program must be structured in this manner. If M1000 is off to start with, the M codes in the above example can be omitted.

- c) At the Crusader control, the following parameters must be set. They can be tailored to match the offline system.
 1. Go to MANUAL mode.
 2. Key in following AUX codes, pressing MANUAL, AUX code, START for each individual code.

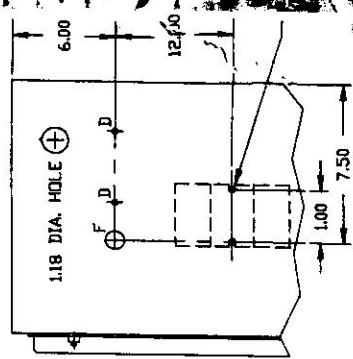
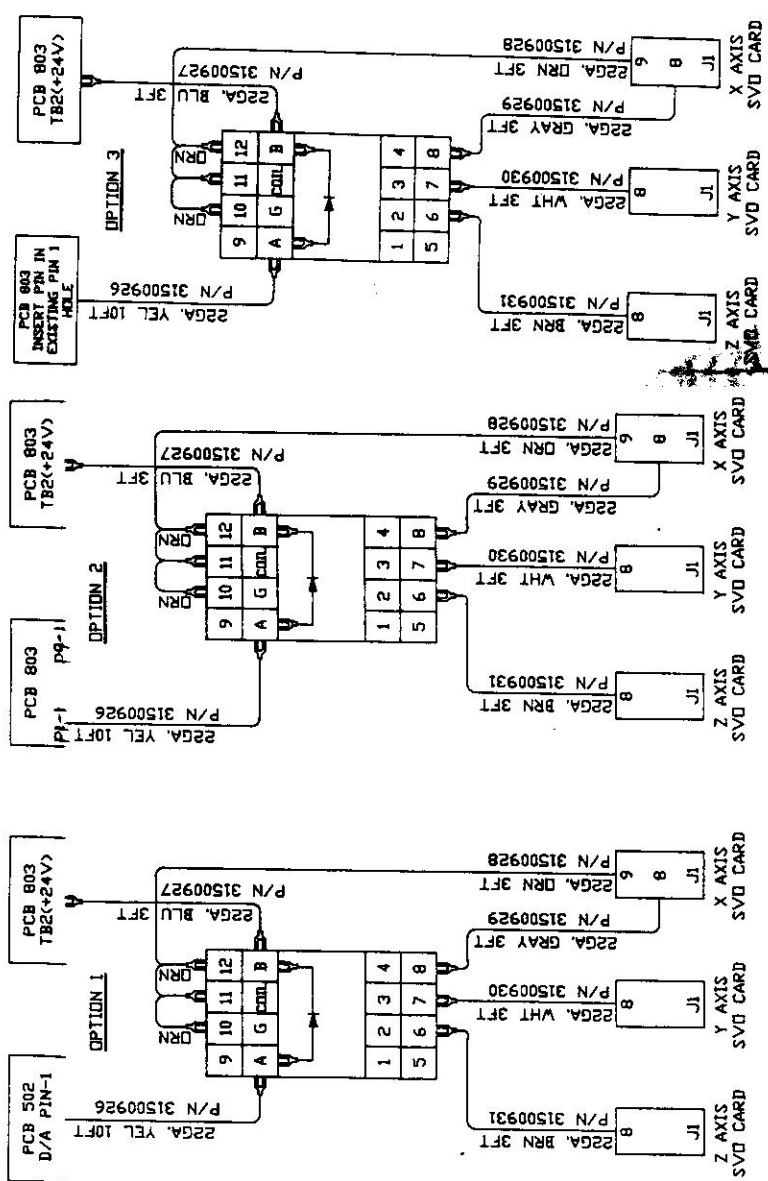
AUX 2768 (8 bpc)
 AUX 2770 (no parity)
 AUX 2787 (4800 baud)
 AUX 2758 (ascii code)
 AUX 2791 (sftwr handshake)

3. Go to program enter mode via program check.
4. Clear the memory.
5. Enter AUX 2711 as the first event.
6. Go to AUTO mode.
7. Press 1, SEARCH, START.
8. Go to offline system and begin transmission.

- d) No DO loops are allowed. The Crusader will terminate the program when it reaches G29E.

GENERAL NOTES

REV. 1	DATE	DESCRIPTION	BY
		ANILAM ELECTRONICS MIAMI, FLORIDA U.S.A.	
WIRING DIAGRAM, CONTINUOUS DOWNLOAD, CR M			
SCALE	NONE	CHECK BY	DATE
DRAWN BY	EDD	DATE	11/6/90
TRAINING NO.	30100201	SHT	1 OF 1



RELAY BASE LDC,
IN SERVO AMP ENCLOSURE