

**Procedure Name.**

Resetting PMAC and loading machine control software. (Variform enabled machines).

**Procedure Description.**

As above.

**Supplementary Documentation.**

None.

**Procedure Details.**

Note: Before re-loading machine control software, it should be determined if the problem is atypical of machine control failure, or from a programming error. First run the data file (Job file or Mini file) on another machine, if the symptom is the same, then it is probably not the machine control software, and the data file should be checked. If the problem is the same, compare the settings of the "Variform" section of the CUSTOMER.CNF file (found in the Optoform directory, and normally accessed by typing CUSTEDIT at the dos prompt) with another machine.

**Re-Setting PMAC.**

1. Power up lathe, and return to DOS from the main menu.
2. Change to the PMAC directory. Start PMAC by typing PE, then press enter. If a blue screen comes up, and "Found PMAC at Specified Address" is seen, continue from step 8 below. If "No PMAC Found" message appears continue below.
3. Exit PMAC and power down the lathe.
4. Locate and insert the jumper at position E51 on the PMAC board.
5. Power on the lathe, let the machine stand for one minute, then power down.
6. Remove the E51 jumper and power back up.
7. Go to step 2 above.
8. Type \$\$\$\*\*\* and press enter.
9. Type P0 . . 1023=0 and press enter.
10. Type Q0 . . 1023=0 and press enter.
11. Type M0 . . 1023->\* and press enter.
12. Type UNDEFINE ALL and press enter.
13. Type WX:\$786,\$D,\$45 and press enter.

14. Type `SAVE` and press enter.
15. Type `$$$` and press enter.
16. Type `I3=1` and press enter.
17. Type `I5=3` and press enter.
18. Type `SAVE` and press enter. (Wait until the cursor moves to the next line down).
19. Exit PMAC (Press Escape then Y)
20. Follow “machine control software installation” instructions.

### **Machine Control Software Installation (from disk).**

Note: If any changes to the “MACHINE.CNF” file have been made, the software must be re-loaded from the installation disk. If no changes were made, it is quicker to re-load the software using the batch file located in the C:\PMAC directory, shown below.

1. Insert the MCS installation disk in to the A:\ drive.
2. From the A:\ prompt type `INSTALL` and press enter.
3. When prompted to replace the `AUTOEXEC.BAT` file press N.
4. When prompted to replace the `CONFIG.SYS` file press N.
5. When the installation is complete, power down the machine for at least 30 seconds then power back up.

### **Machine Control Software Installation (from batch file).**

Note: If any changes to the “MACHINE.CNF” file have been made, the software must be re-loaded from the installation disk, shown above. This procedure may only be used for software versions later than MCS V3.07 and any version of “Selectable Tools”. Other versions must be loaded from the original disk.

1. From the C:\ prompt type `CD\PMAC` and press enter.
2. Type `LOADPMAC` and press enter.
3. When the installation is complete, power down the machine for at least 30 seconds then power back up.