

**3.12.9.11 MUPS-011 Pass number is out of sequence**

**Cause:** Pass number is not in sequence

**Remedy:** Use correct pass number

**3.12.9.12 MUPS-012 Last pass was incomplete**

**Cause:** Last pass was not welded to completion

**Remedy:** Use correct pass number

**3.12.9.13 MUPS-013 Invalid Leader OFFSET MODE**

**Cause:** Leader Offset requires CD Move

**Remedy:**Add CD Move.

**3.13 N****3.13.1 NCBN Alarm Code****3.13.1.1 NCBN-001 NC Command too long %s**

**Cause:** NC command length too long

**Remedy:** Correct the command syntax and load the program again

**3.13.1.2 NCBN-002 Syntax Error %s%s LN#%d**

**Cause:** NC command syntax error

**Remedy:** Correct the command syntax and load the program again

**3.13.1.3 NCBN-003 Unknown command**

**Cause:** Invalid or undefined command was used

**Remedy:** Correct the command syntax and load the program again

**3.13.1.4 NCBN-004 Multiple N-code LN#%d**

**Cause:** Multiple N-code in one line

**Remedy:** Correct the command syntax and load the program again

**3.13.1.5 NCBN-005 N-code missing LN#%d**

**Cause:** A line must start with N-code

**Remedy:** Correct the command syntax and load the program again

**3.13.1.6 NCBN-006 Config data expected LN#%d**

**Cause:** Config command should be followed by config string data expressed as comment string

**Remedy:** Correct the command syntax and load the program again

**3.13.1.7 NCBN-007 O-Code missing LN#%d**

**Cause:** A program should begin with O-code i.e. program name

**Remedy:** Correct the command syntax and load the program again

**3.13.1.8 NCBN-008 Word too long**

**Cause:** Specified Program name too long

**Remedy:** Correct the command syntax and load the program again

**3.13.1.9 NCBN-009 NO M-code allowed here**

**Cause:** M-code is not allowed in this context

**Remedy:** Correct the command syntax and load the program again

**3.13.1.10 NCBN-010 Unexpected code (%s%s) LN#%d**

**Cause:** Commands are not placed in right order

**Remedy:** Correct the command syntax and load the program again

**3.13.1.11 NCBN-011 Only one M-code allowed each line**

**Cause:** Only one M-code per line is allowed

**Remedy:** Correct the command syntax and load the program again

**3.13.1.12 NCBN-012 T-code expected**

**Cause:** A T-code is expected for this M-code

**Remedy:** Correct the command syntax and load the program again

**3.13.1.13 NCBN-013 NC conversion feature NOT loaded**

**Cause:** NC conversion software is required to process this file type

**Remedy:** Please purchase proper software option

**3.13.1.14 NCBN-014 NC prog (%s) NOT loaded**

**Cause:** Specified program was not loaded due to error this file type

**Remedy:** Look at the cause code on the 2nd line of the screen, and fix the error