6.18 External Memory Program Operation (Option)

The external memory operation means to call and execute the program located in the CF card. This is controlled by NC memory.
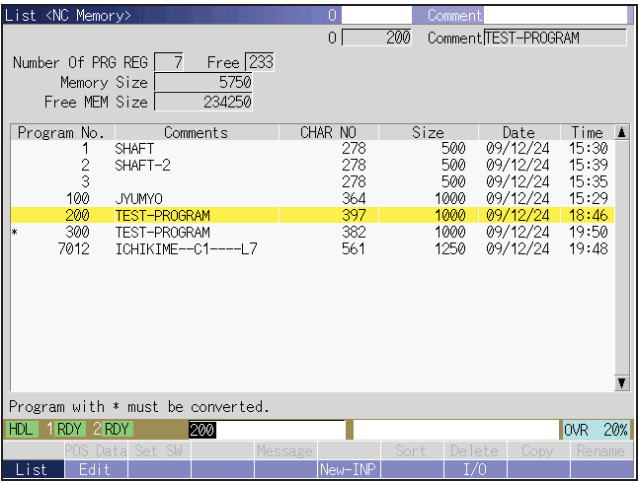
See the Programmer's Manual for calling a program.

To execute the program, store it in the program folder in the CF card prepared for execution. The program in the size up to 1 GB can be executed.

To convert the program in the CF card to the program folder for execution, use following procedure.

Procedure

1. Press the Edit key ![EDIT key].

   The previously selected screen appears.

2. Press the menu key [List].
   The programs in the NC memory are listed.
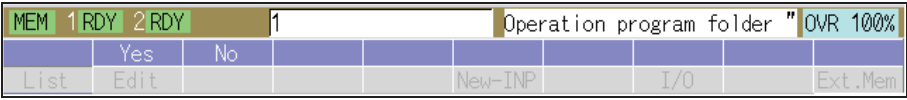
3. Set the CF card that includes the program to be executed.

4. Press the menu key [Ext.Mem].

   The message "Operation program folder "prg" is created in the external memory. Are you sure?" is displayed and menu keys [Yes] and [No] are displayed in the upper menu.


Notes

- When an external memory program is registered in the CF card
  The programs in the external memory are listed. Go to step 7.
- When the folder "prg" (same as the program folder for execution) exists
  The message ""prg" folder exists. Please change the folder name." is displayed, and the operation halts.

5. Press the menu key [Yes].

An external memory folder for execution "prg" is created in the CF card automatically.
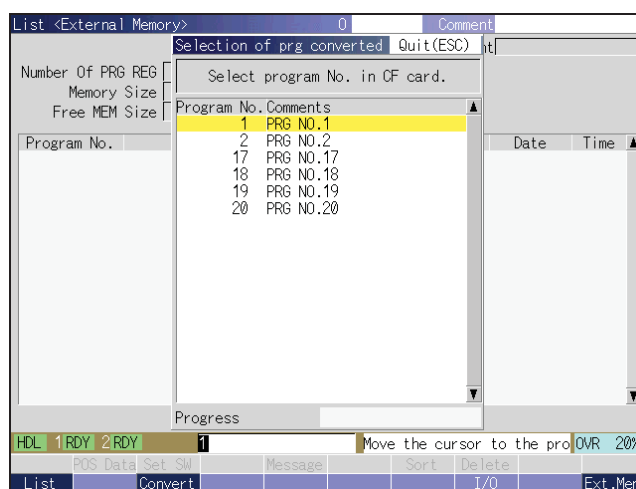The message "Press [Convert] menu to convert the program into operation program and transmit it to the "prg" folder." is displayed.
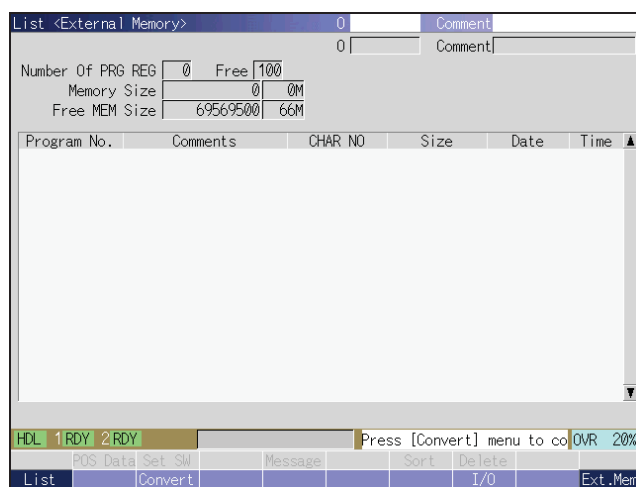

6. Press the menu key [Convert].

The source program selection sub-window appears.
The list of programs in the CF card appears and the message "Move the cursor to the program to be converted and press INPUT key." is displayed.

7. Use the arrow keys [↑] [↓] to move the cursor to the program to be converted and press the Input key [INPUT].

The conversion starts automatically. The progress of conversion is displayed on the progress bar.
The message "Please wait. Do not remove the card during conversion." is displayed during the conversion. An input by key and the screen transition cannot be executed.
To quit the conversion, press the menu key [Cancel].
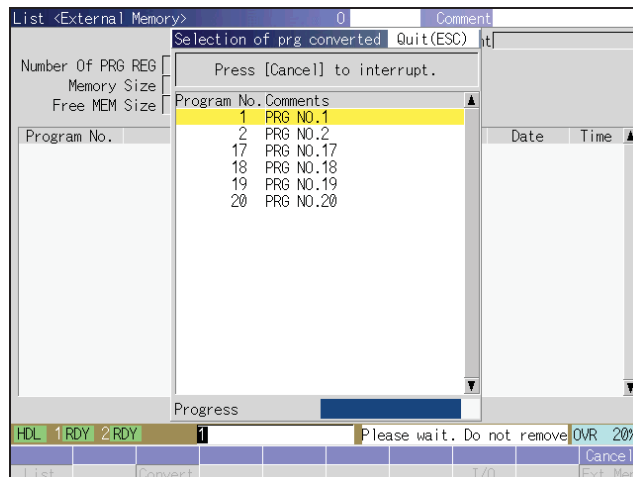
8. The converted programs are listed.

When the conversion is finished, the sub-window closes automatically and the message "Conversion and transmission are completed. The program can be used as an external memory program." is displayed.
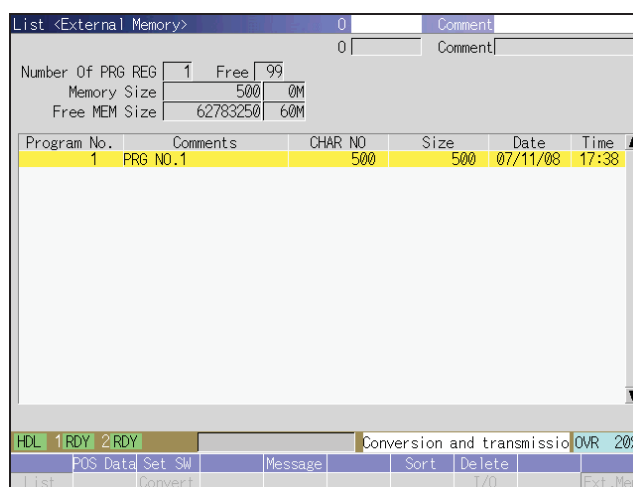
Notes

- When the conversion fails because of the size
  The sub-window does not close and the message "Memory capacity will be exceeded." is displayed.

- When the conversion is canceled
  The sub-window does not close and the message "Processing has been interrupted." is displayed.

- To use as a sub program, the machining data in the main program is used.
- Only the programs located in the root directly of the CF card can be converted.
  (The programs located in a folder cannot be converted.)
- To transfer the program, the same capacity of the source program is required.
- The programs located in the program folder for execution are used as external programs regardless of the size. Up to 100 programs can be stored. These cannot be edited.
- The conversion takes time. The conversion time varied according to the kind of the CF card.
  See the table below to know the general time for conversion.

Program size (MByte)	Conversion time (sec.)
0.5	6
1	8
5	48
10	93
30	276
50	460

- If cycle time is longer than 30 min. due to large program size, enter the check mark for the setting switch of "13 Cycle Time ALM. OFF". For setting switches, see <6.8.6 Setting switches>. By checking the setting switch "13 Cycle Time ALM. OFF", operation stop mode at the occurrence of an alarm is changed from 1 cycle stop to immediate stop. This change applies to the following alarms.

Alarm No.	Symptom
EX202	Lubrication oil empty alarm.
EX203	Coolant oil alarm. Supply the oil.
EX204	Oil-air lub alarm. Lub oil level is low.