Automation Consultants, Inc.

Restoring Memory on Kiwa 1200 / 4L with Fanuc 10M

1. Power up the control holding the 7 and 9 on the keyboard. (Continue to hold 7 & 9 until the screen comes on)

2. Type 99 and hit input.

3. Screen will show ---> axis? ---> Answer by typing 03 and hit input. (This is for a 3 axis machine.)

4. Screen will then show OP1 = thru OP32=

Answer:

OP1 = 07	OP9= 28	OP17= 00
OP2= 00	OP10=60	OP18=00
OP3= 2F	OP11=08	OP19= 00
OP4= 00	OP12= 19	OP20= 00
OP5= 00	OP13= 00	OP21= 01
OP6= 04	OP14= 10	The rest are 00
OP7= 60	OP15= 00	
OP8= 01	OP16= 00	

(These are the standard settings for a Kiwa VMC. Your machine may vary.   Use the settings from your Fanuc data sheet.)

5. After OP32 the machine will ask a question like: Files must be cleared.   Answer by pressing Y and hit input. (Y means yes)

6. Then you will see IPL mode again. Type 6 and hit input to end IPL.

7. Push the setting soft key twice to get settings (settings) then type 8000 and hit soft key that says INP-NO. Then push soft key that says ON=1 (Parameter #8000 will become all 1's)

8. Push soft key that says service

9.   At this point you can install all parameters starting with #0000. Install all parameters, PC Timers, Keep Relays and Pitch Error comp.

10.   Push the setting soft key again until you see setting (settings). Then type 8000 and hit soft key that says INP-NO
Then push soft key that says OFF=0

       (Parameter #8000 will then become all 0)

12.   Turn Machine completely OFF.

13.   Power the control back up holding the - & . keys. This will bring you back up in IPL mode. Chose option 4 and press the input key. When the screen displays "Check Soft- OT at power on" press the N key. The screen will return to IPL mode.

14.   Choose option 6 to end IPL. Move each axis at least two inches from the home limits. Set the machine to 25% rapid and zero reference each axis.