



Using CCL to Upload and Download from your CNC Console Allen-Bradley 73xx

To Get a File from the DNC System

1. Edit the 'CCL Command Program' program, 1111, stored in your CNC memory as follows:
 - Put the CNC in MDI or Keyboard mode
 - Type CS,RN,1111 [transmit] to make 1111 the active program.
 - Turn on the Edit Key Switch
 - If the X line of the program is not the top line visible, use the TAPE RDR FWD/REV switch(es) to place it there.
 - Modify Xvalue where value is the name of the tape file exactly as it is stored on the DNC system.
 - Turn off the Edit Key Switch.

NOTE! If 1111 does not exist type CS,KB,1111[TRANSMIT]. Enter M30 EOB [TRANSMIT]. Now insert the X line as described above.

2. Transmit program 1111 to the DNC system as follows:
 - Type CS,CY,1111 [transmit].
 - When the above command disappears from the screen wait 15 seconds.
3. Get the file you requested: (**Turn Tape/Memory switch to Tape if necessary.**)
 - Type CS,TA,name where 'name' is the name you want to call the program in the CNC memory. If you get a 'READR NOT RDY' message that lasts more than one minute, press the Reader Reset button and repeat the CS,TA command.
 - When the CS,TA command disappears from the screen program 'name' will be stored in the CNC memory.
4. Check for your program and make sure there were no problems. If the DNC system had a problem locating the requested file or if that file was not assigned to your machine, instead of the program you requested you will get a response file with a coded error message. For example, an N6 response means that the program could not be found in the DNC database. Make sure that you spelled it correctly in 'CCL Command Program' program 1111. An N12 response means that the program exists in the database but it is not assigned to your machine.
 - To get a directory of programs stored type CS,TT [transmit].
 - To view a program stored in CNC memory type CS,TT,name [transmit].
 - To delete a program stored in CNC memory type CS,CN,name [transmit].

Programming Note: The file must have no text before the initial % and the last block must be an M02. (M30 will cause a READER NOT RDY error message to appear on the CNC, however, the file will be stored in memory ok. Just press Tape Reader Reset.)

To Send a File to the DNC System

1. Edit the 'CCL Command Program' program, 1112, stored in your CNC memory as follows:
 - Put the CNC in MDI or Keyboard mode
 - Type CS,RN,1112 [transmit] to make 1112 the active program.
 - Turn on the Edit Key Switch.
 - If the Y line of the program is not the top line visible, use the TAPE RDR FWD/REV switch(es) to place it there.
 - Modify Yvalue where value is the name of the tape file exactly as you want it stored on the DNC system.
 - Turn off the Edit Key Switch.

NOTE! If 1112 does not exist type CS,KB,1112[TRANSMIT]. Enter M30 EOB [TRANSMIT]. Now insert the Y line as described above.

2. Transmit program 1112 to the DNC system as follows:
 - Type CS,CY,1112 [transmit].
 - When the above command disappears from the screen wait 15 seconds.
3. Input the response file telling you that the DNC system is ready to receive the tape file you want to save:
 - Type CS,TA,2222 [transmit]. If you get a 'READR NOT RDY' error message that lasts more than a minute press the Reader Reset button on the CNC and try again.
 - When the CS,TA command disappears from the screen, read the contents of 2222 by typing CS,TT,2222 [transmit]. It should have the code, N1, in the first line. This means that the DNC system is ready to receive the tape file you want to save. If you get any other N number, refer to the CCL error message chart and take proper action.
4. Delete 2222 from CNC memory:
 - Type CS,CN,2222 [transmit].
5. Transmit the tape file you want to save:
 - Type CS,CY,name [transmit] where name is the name of the tape file in the CNC memory that you want to save.
 - After transmission is complete (the CS,CY command disappears from the screen), wait 15 seconds.
6. Input the response file telling you that your file was received and stored in the DNC database successfully Type.
 - Type CS,TA,7999 [transmit]. If you get a 'READR NOT RDY' error message that lasts more than one minute press the Reader Reset button on the CNC and try again.
 - When the CS,TA command disappears from the screen, read the contents of 2222 by typing CS,TT,2222 [transmit]. It should have the code, N2, in the first line. This means that the DNC successfully received the tape file you wanted to save. If you get any other N number, refer to the CCL error message chart and take proper action.
 - Delete 2222 from CNC memory: Type CS,CN,2222 [transmit].