



## Using CCL to Upload and Download from your CNC Console Mitsubishi 50L

### ***To Get a File from the DNC System***

1. Edit the 'CCL Command Program' program, 1111, stored in your CNC memory as follows:
  - Press EDIT/MDI.
  - Press softkey EDIT.
  - Press softkey SEARCH.
  - Type 1111 and press INPUT/CALC.
  - Modify Xvalue where 'value' is the name of the file exactly as it is stored on the DNC system.
2. Transmit program 1111 to the DNC system as follows:
  - Press DIAG/IN/OUT.
  - Press softkey OUTPUT.
  - Type 1 and press <right arrow>.
  - Type O1111.
  - Press INPUT/CALC.
  - When the punching is complete wait 30 seconds.
3. Get the file you requested:
  - Press softkey INPUT>
  - Type 1 and press <right arrow>.
  - Press INPUT/CALC.
4. Check 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 rather than the file you requested. 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.
5. If you got a response file delete it now:
  - Press DIAGN/IN/OUT.
  - Press softkey MENU until you see the menu item, ERASE.
  - Type 1 and press <right arrow>.
  - Type 2222 and press INPUT/CALC.

## **To Send a File to the DNC System**

1. Edit the 'CCL Command Program' program, 1111, stored in your CNC memory as follows:
  - Press EDIT/MDI. Press softkey EDIT. Press softkey SEARCH.
  - Type 1111 and press INPUT/CALC.
  - Modify Yvalue where 'value' is the name of the file exactly as you want it named on the DNC system. If you prefer using the automatic naming function for new files then make 'value' = 0. For example, Y0.
2. Transmit program 1111 to the DNC system as follows:
  - Press DIAG/IN/OUT. Press softkey OUTPUT.
  - Type 1 and press <right arrow>.
  - Type 1111. Press INPUT/CALC.
  - When the punching is complete wait 30 seconds.
3. Input the response file telling you that the DNC system is ready to receive the tape file you want to save:
  - Press DIAGN/IN/OUT. Press softkey INPUT.
  - Enter 1 and then press INPUT/CALC.
  - Program 2222 should be stored in memory. It should have the code, N1, in the first line. This means the DNC system is ready to receive the tape file you want to save.
4. Delete 2222 from CNC memory:
  - Press DIAGN/IN/OUT. Press softkey MENU until you see the menu item, ERASE.
  - Type 1 and press <right arrow>. Type 2222 and press INPUT/CALC.
5. Transmit the tape file you want to save:
  - Press DIAG/IN/OUT. Press softkey OUTPUT.
  - Type 1 and press <right arrow>.
  - Type 'program number.' Press INPUT/CALC.
  - When the punching is complete wait 45 seconds.
6. Input the response file telling you that your file was received and stored in the DNC database successfully.
  - Press DIAGN/IN/OUT. Press softkey INPUT.
  - Enter 1 and then press INPUT/CALC.
  - Program 2222 should be stored in memory. It should have the code, N2, in the first line. This means the DNC system successfully saved your file.
7. Delete 2222 from CNC memory:
  - Press DIAGN/IN/OUT.
  - Press softkey MENU until you see the menu item, ERASE.
  - Type 1 and press <right arrow>. Type 2222 and press INPUT/CALC.