

## 8025/30 Series control with PLCI

(Procedure to save and restore PLC program and machine parameters, decoded M-functions, and leadscrew error compensation table for O.E.M's)

When the machine is ready to ship to the customer, it is important to save the PLC program, the machine parameters, decoded M-functions, and leadscrew error compensation table to the EEPROM. The 8025/30 800 Series with PLCI has this feature available.

1) Save machine parameters, decoded M-functions, and leadscrew error compensation table to EEPROM.

**[op-mode], [6 - editing], [F7 lock/unlock]**, enter code: **PKJIY** (for M,GP controls)  
or  
**PKAI1** (for T controls)

2) Save PLC program to EEPROM.

First make sure that the PLC program is stopped.

**[op-mode], [9 - special mode], [F2 execution], [F4 stop]**

Now to save PLC program.

**[op-mode], [9 - special mode], [F3 utilities], [F2 save]**

After the PLC program is saved, remember to run the PLC program.

**[op-mode], [9 - special mode], [F2 execution], [F3 run]**

***Note:** The PLC messages, ( P99998), are **not saved** by the EEPROM. It is recommend also to save the PLC Program, PLC messages, Machine parameters, decoded M-functions, and leadscrew error table compensation onto a disk or have a paper copy.*

By following this procedure, the machine parameters and PLC program are saved to the EEPROM. The EEPROM can also physically be taken out and placed into another control with PLCI.

1) To restore machine parameters, decoded M-functions, and leadscrew error compensation table to control from EEPROM.

**[op-mode], [6 - editing], [F7 lock/unlock]**, enter code: **PKJIN** (for M,GP controls)  
or  
**PKAI0** (for T controls)

2) To restore PLC program from EEPROM.

First make sure that the PLC program is stopped.

**[op-mode], [9 - special mode], [F2 execution], [F4 stop]**

Now restore PLC program.

**[op-mode], [9 - special mode], [F3 utilities], [F3 restore]**

After the PLC program is restored, remember to run the PLC program.

**[op-mode], [9 - special mode], [F2 execution], [F3 run].**