

TB258 (Rev1) - How to troubleshoot Custom PLC 9XXX Error Messages in your CNC11 PLC Program

Purpose: To teach you how to look at your CNC11 PLC program and figure out what is causing your custom PLC 9XXX error message. So you can fix the problem and get your system up and running.

Example:

You have a T400 with a tool turret and you are getting a "9104 ATC TIMEOUT" error message.

How to determine what is causing the Error:

- 1.) Locate your PLC source file in the CNCM (mill) or CNCT (lathe) and open in your text editor.
- 2.) At the beginning of the program you will find the "Constant Definitions" this is where your custom PLC messages are defined. In our example we had 9104, so look for the last 3 digits (104). To find the line in the program that says " ATC_TIMEOUT IS 26625; (1 + 256*104)".
- 3.) Now highlight "ATC_TIMEOUT" and search the PLC program. To find the code that is causing the error.

Note: If your displayed message does not match the error defined the PLC program you have the wrong plcmgs.txt file or it has not been modified to match your PLC program.

Document History

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