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TO USE MEMORY CARD ON FANUC CONTROLS

- **CAUTION! NEVER REMOVE THE ATA CARD WHILE A FILE IS BEING READ OR TRANSFERRED!!!!**
- CHANGE PARAMETER #0020 I/O CHANNEL TO 4
- INSERT MEMORY CARD WITH TOP LABEL FACING CRT
- TO LOAD TO MEMORY CARD
 - 1) PRESS **EDIT** KEY → PRESS **PROGRAM** KEY → PRESS **▶** SOFT KEY → PRESS **CARD** SOFT KEY → PRESS **OPRT** SOFT KEY → PRESS **PUNCH** SOFT KEY → TYPE PROGRAM NUMBER E.G. 8500 (NO "O") → PRESS **O SET** SOFT KEY → PRESS **EXEC** SOFT KEY.
- TO LOAD FROM MEMORY CARD TO NC
 - 1) PRESS **EDIT** KEY → PRESS **PROGRAM** KEY → PRESS **▶** SOFT KEY → PRESS **CARD** SOFT KEY → PRESS **OPRT** SOFT KEY → PRESS **F READ** SOFT KEY → TYPE FILE NUMBER E.G. 1 → PRESS **F SET** SOFT KEY → TYPE PROGRAM NUMBER E.G. 8555 (NO "O") → PRESS **O SET** SOFT KEY → PRESS **EXEC** SOFT KEY.
F SET = FILE NUMBER
O SET = PROGRAM NUMBER
- CHANGE PARAMETER #0020 I/O CHANNEL BACK TO ORIGINAL SETTING
- REMOVE MEMORY CARD
- TO DELETE A FILE FROM THE CARD PRESS THE **EDIT** KEY → PRESS THE **PROGRAM** KEY → PRESS **▶** SOFT KEY → PRESS **CARD** SOFT KEY → PRESS **OPRT** SOFT KEY → PRESS **DELETE** SOFT KEY → TYPE FILE NUMBER NOT FILE NAME → PRESS **F SET** SOFT KEY → PRESS THE **EXEC** SOFT KEY.
- PRESSING THE **DIR** + SOFT KEY WILL SWITCH THE SCREEN VIEW BETWEEN FILE SIZE, DATE AND FILE COMMENTS E.G. (ROUGH POCKET)
- TO CALL A SUB PROGRAM FROM THE ATA CARD MAKE SURE PARAMETER #138.7 IS SET TO (1), I/O CHANNEL IS SET TO (4), AND THEN USE M198PXXXX FORMAT TO CALL SUB PROGRAM. **(MAKE SURE THE PXXXX IS THE PROGRAM NUMBER NOT FILE NUMBER)**.
- TO RUN A PROGRAM DIRECTLY FROM THE ATA CARD MAKE SURE PARAMETER #138.7 IS SET TO (1), I/O CHANNEL IS SET TO (4). WITH THE ATA CARD INSERTED PRESS **REMOTE** KEY → PRESS **PROGRAM** KEY → PRESS **▶** SOFT KEY UNTIL **DNC-CD** APPEARS ON SCREEN → PRESS **DNC-CD** SOFT KEY → TYPE IN THE FILE NUMBER YOU WANT TO RUN **(MAKE SURE YOU TYPE IN FILE NUMBER NOT PROGRAM NUMBER)** → PRESS **DNC-ST** SOFT KEY (SCREEN WILL DISPLAY DNC FILE NAME: 01000) → PRESS **PROGRAM** BUTTON → PRESS **CYCLE START** TO RUN PROGRAM.