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How to load the PLC program on an HMC 500

- Turn the machine off
- Connect a full size keyboard to the MMI control
- Turn the machine back on and boot normally either in MS-DOS or Windows
- !! Remove any chuck or toolholder from the A-axis, or at least support the parts with something soft. The default setting of a PLC program is unclamped !!

DOS Controls

- When the control is booted up, close all errors and windows with F10
- On the black screen choose F3 for DOS
- Type "T" to get to the command prompt (C:\st002)
- Type "cd.." and enter" to get to the prompt C:\
- Type "A400-RUN and enter" to start the PLC Software

Windows Controls

- When the control is booted up, close Walter Windows Mode or Tool Studio
- Open the Windows Start menu
- Select the folder HMC 500 Power
- Select PLC Programming to start the PLC Software

With all controls continue as follows

- After the PLC Software page is opened
- Push F3 to load a program
- Select "PLC-****" (take the latest with the highest number for example PLC-LV31 or PLC-SV15) and push enter (never select BTL**** this is only a test program)
- Program will be loaded in the PLC software
- Hold the "ctrl" button down and push "F9" to download the program
- The user name is "a" and the password is "a"

- Confirm the change of the variables with "OK"
- Program will be loaded
- After the download is finished, hold the "alt" key and press "X" to close the page
- Hold "ctrl" and push "c" to close the PLC software.
- Turn the control off and after 10 seconds back on.
- PLC program should be OK now.