#### Maintenance Manual

#### Communications Troubleshooting

For communication problems several factors must be examined. Review the environment, then check the file, the VMC, the cables, the computer, and finally the computer's communications software. Any one of these systems can propagate a communication problem.

#### Environment

In areas where lightning strikes are common, communications can be interrupted when or

after lightning has struck a power line. The lightning may affect the memory of the CNC control, which would then have to be zeroed from the DI mode. It is suggested to call a service person or see the maintenance manual for this zeroing procedure.

 An RS-232 surge suppressor adds protection in this kind of environment.

#### Figure 1

- Has the file ever successfully been transmitted to the VMC before? If the file
  has been transmitted before, has it recently been edited and has
  something been introduced into the file? Use an editor or word processor
  which will show hidden characters. If hidden characters are present in the
  file, remove them.
- If the file has not been successfully transmitted, use an editor or word processor which will show hidden characters. If hidden characters are present in the file, remove them.
  - a. The only accepted characters allowed before the initial percent sign are DNC, DNCX, or TA, 1. In addition, no O words are allowed in DNC mode. Example:

DNC

- b. A two-second dwell is required between the DNC command and the first percent symbol (%), if the software being used to transmit the program cannot support this dwell time, remove the DNC, DNCX, or TA.1 command from the file and type the command at the VMC before starting file transmission.
- When a file is posted for a paper tape, or when a paper tape is read and placed on a disk, it may have leader characters before the initial percent sign — they need to be removed.
- If some of the file can be transmitted, but some of it cannot, check for syntax errors.
  - a) Examine the area in the file for syntax errors and repair them.
    For example, double motion words or missing words are syntax errors.

# **19chevy Struck Manual**

J. "Kelly" Flory, Jr.

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