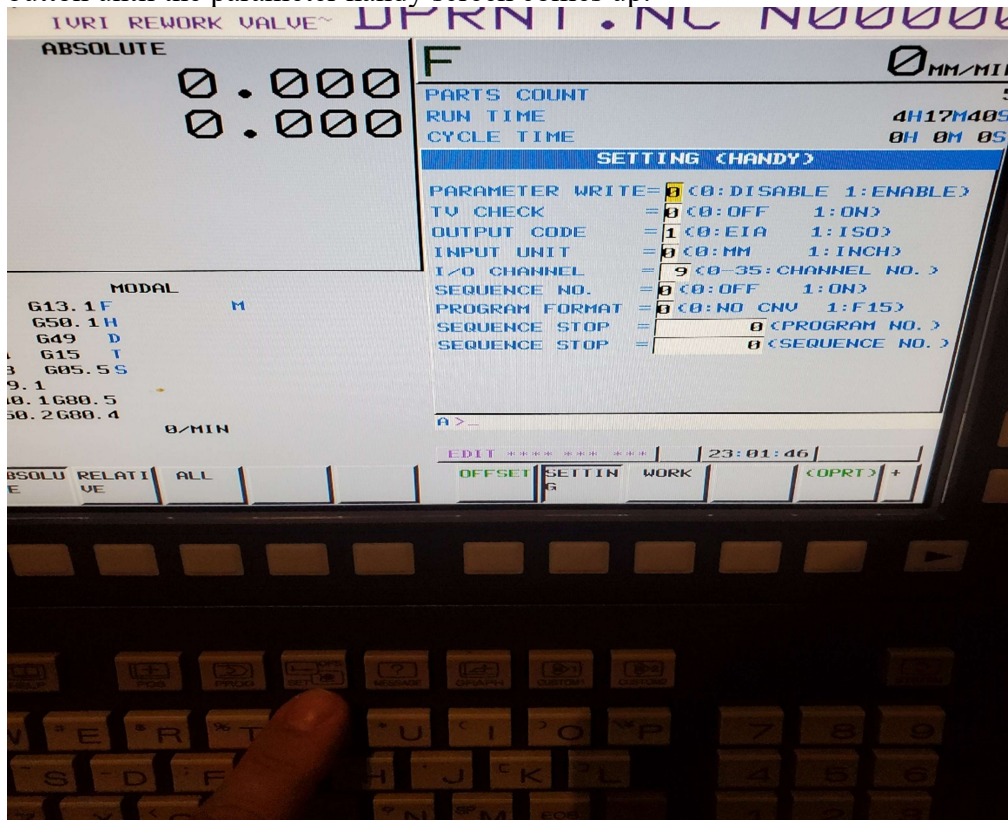


Fanuc Control – 086 Alarm Resolution.

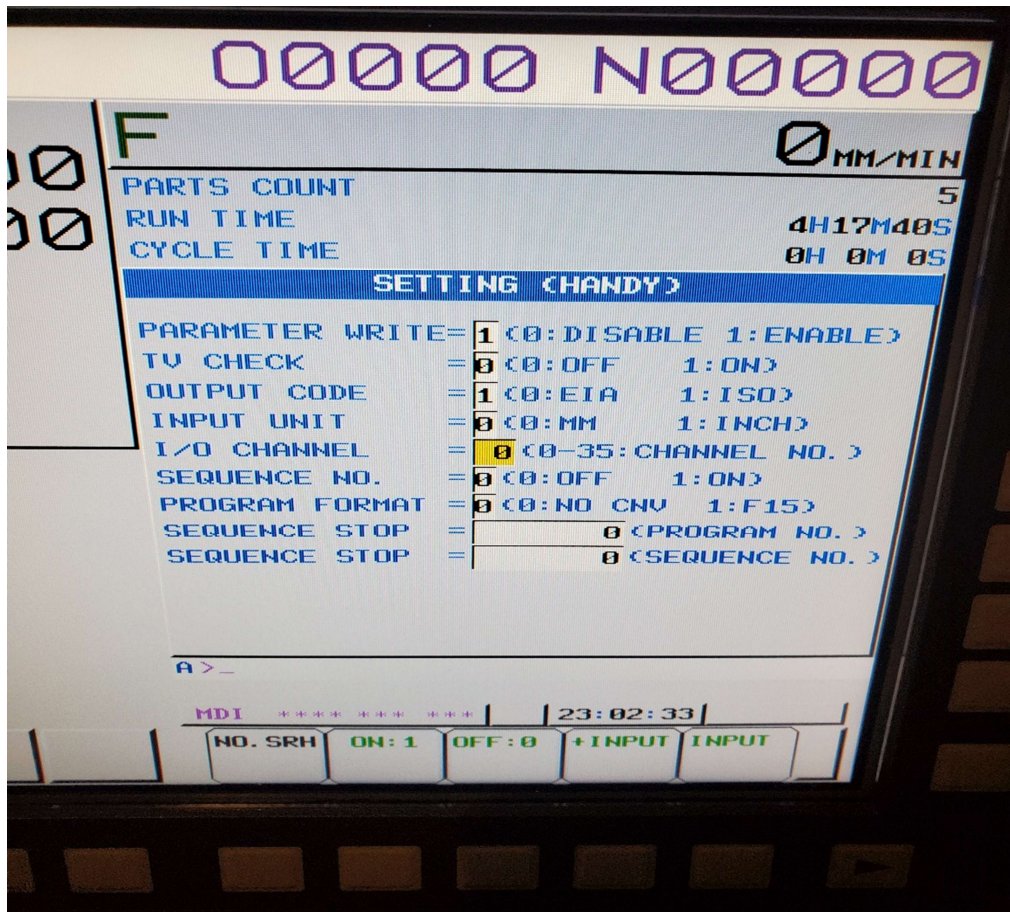
- Make sure the program edit key is not turned on. This would be a key on the control panel of the machine that you physically turn.



- Next, check the I/O parameter to make sure it is set to 0. To find this, press the offset button until the parameter handy screen comes up.



- Put the machine in MDI mode, change the first parameter to a 1 (it will give an alarm don't worry this is fine). Go back to the offset page and input a 0 for the I/O if it is not set.



- Change the first parameter back to a 0 and then press the reset key. This will clear the alarm.
- Finally, try to do a download and upload a program.
- If the above still did not help. Make sure the machine has the correct wiring. The common pinout for a moxa to machine is stated in the next line.

DB9 DB25
 1 - Shield
 2 ----- 2
 3 ----- 3
 5 ----- 7
 7 ----- 5
 8 ----- 4

Pins 6-8-20 jumped on DB25 side.

- If this still does not help, make sure the comports match between Nport driver manager and what is set in configurator (for DNC Professional 5/6).
- Also make sure the Ip address of the moxa is setup in Nport Driver Manager and the correct comport is assigned to it as well.