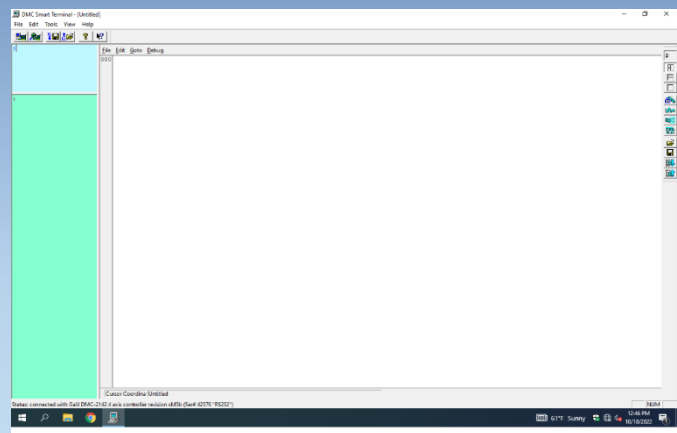




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Auto Bender Galil Software Update




Software update

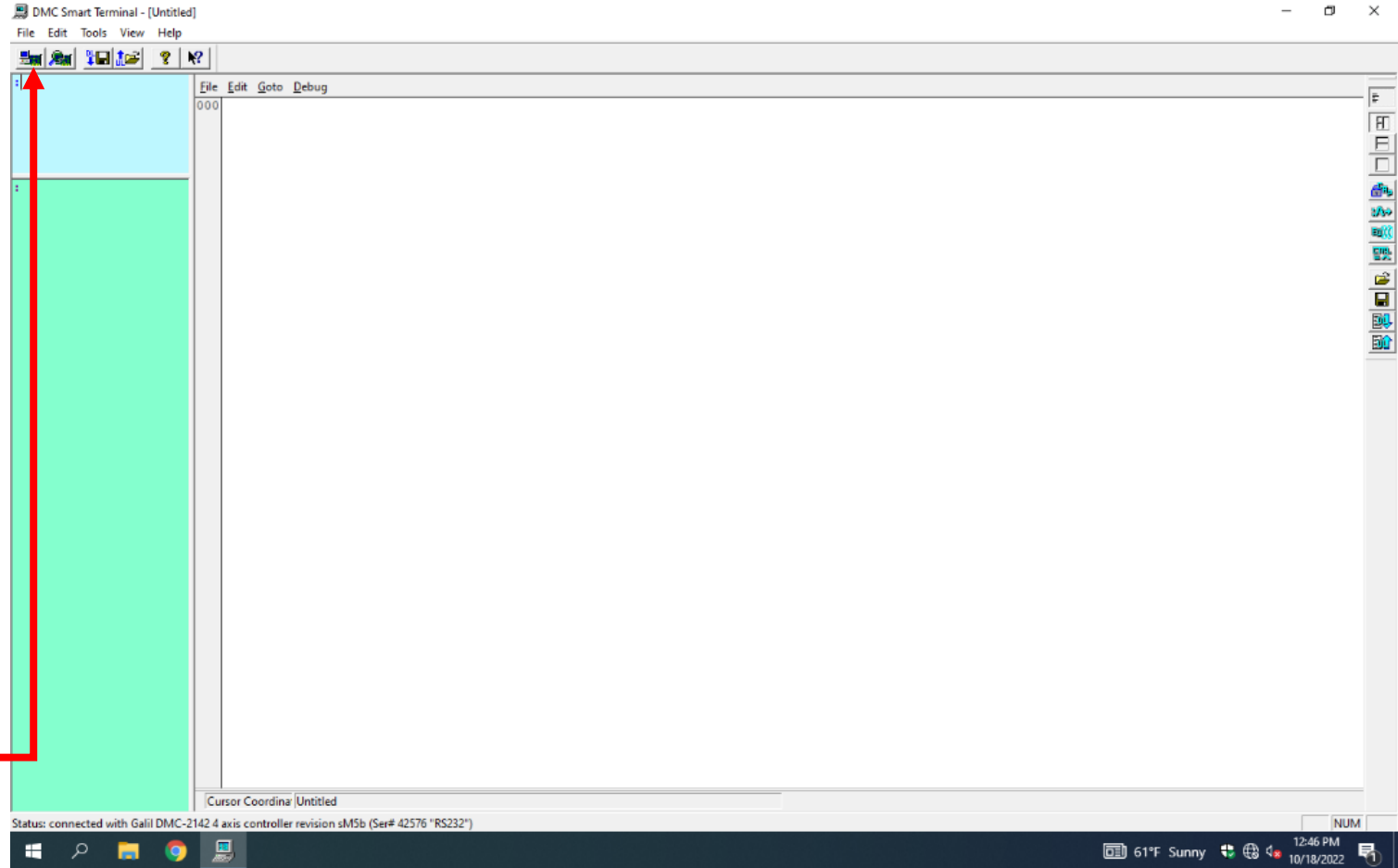
Installing the Galil files to the controller.

- Go to <https://www.clnofsouthflorida.com/free-cnc-machine-software-cln/>
- Download the CNC Auto Bender Software.
- Extract the zip folder to the desktop for easy access.
- Double click on the extracted folder.
- Copy the **Gbend_Servo_Stepper_Ver_7.dmc** file and past it to the C:\AutoBender folder.

Software update

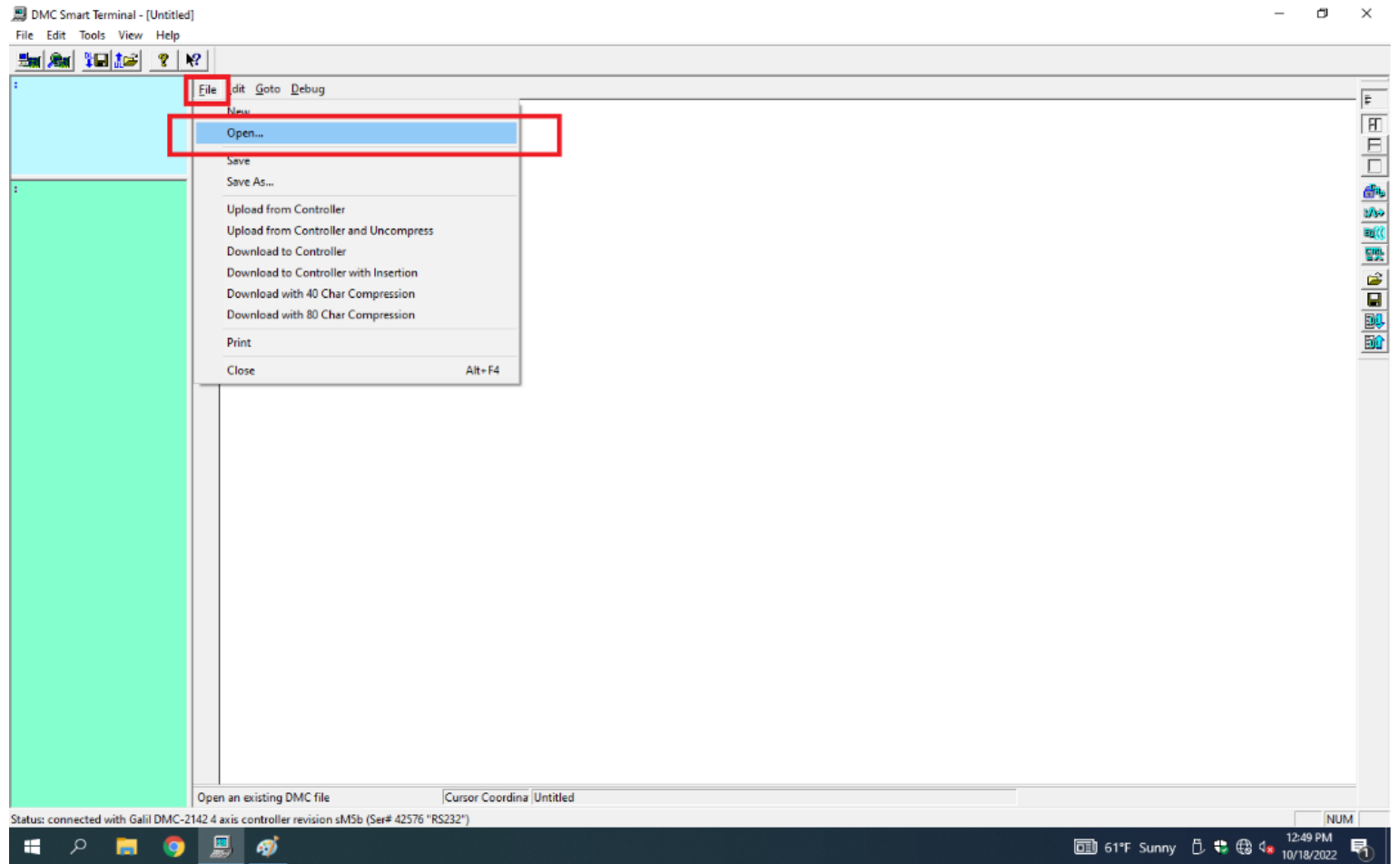
Installing the Galil files to the controller.

- The Gbend_Servo_Stepper_Ver_7.dmc needs to be downloaded into the machine's controller. First make sure that the Auto Bender Program is completely shut down. Go to the task manager and look for **BEN.exe** and end task on it.
- On the desktop you should have a shortcut to DMC Smart Terminal. If not go to [DMC Smart terminal Download](#) and download the DMC Smart Terminal and install the program. Double click on the icon to start the program.
- If you receive a message that says there is no controller in the registry then click on this link and download the [DMC Smart terminal Download Instructions.PDF](#). Go to [Controller Registration](#) section. Then repeat this step.
- There is a program running in the controller, and it must be interrupted for the DMC Smart terminal to connect. Disconnect and drain the compressed air out of the machine. Move one of the gold dies to the center of its travel, then press reset on the side of the machine.
- Click the connect icon. 
- If the program connects correctly, you should have 3 different color screens pop up. The large with one is the editor, the blue one is for sending commands and the green one is for receiving them.



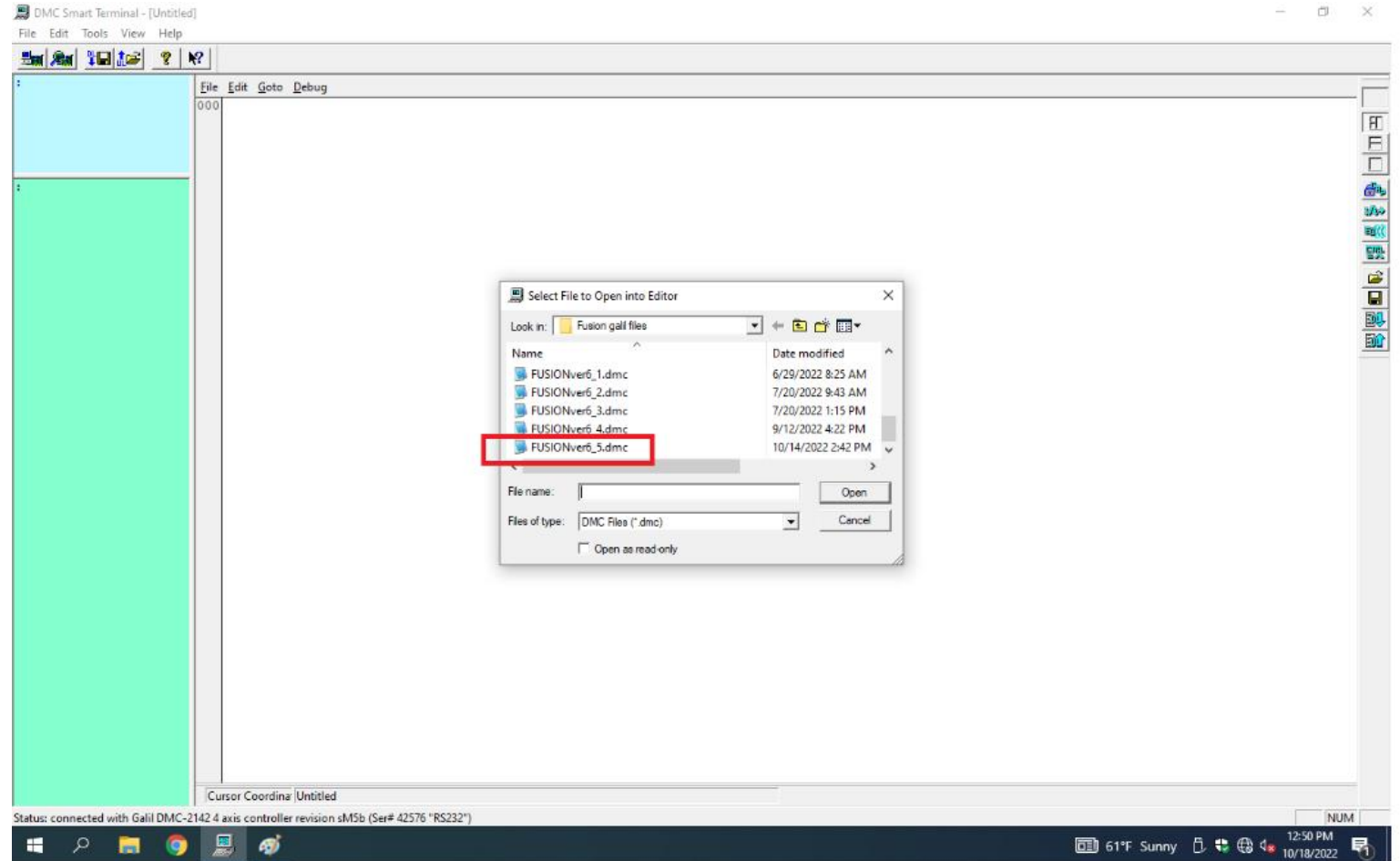
Software update

In the editor screen click on file open.



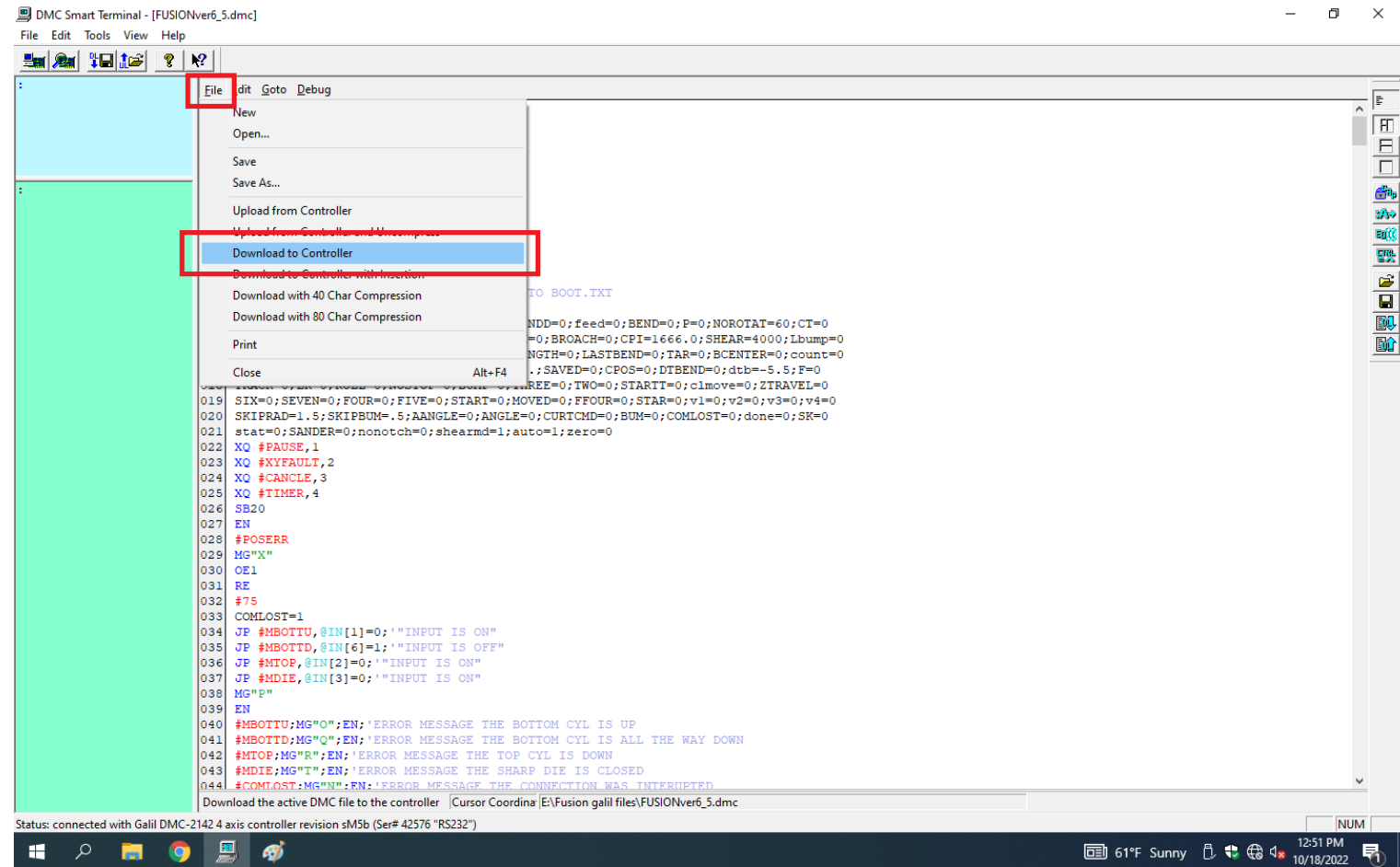
Software update

- Go to C:\Autobender and click on Gbend_Servo_Stepper_Ver_7.dmc file.



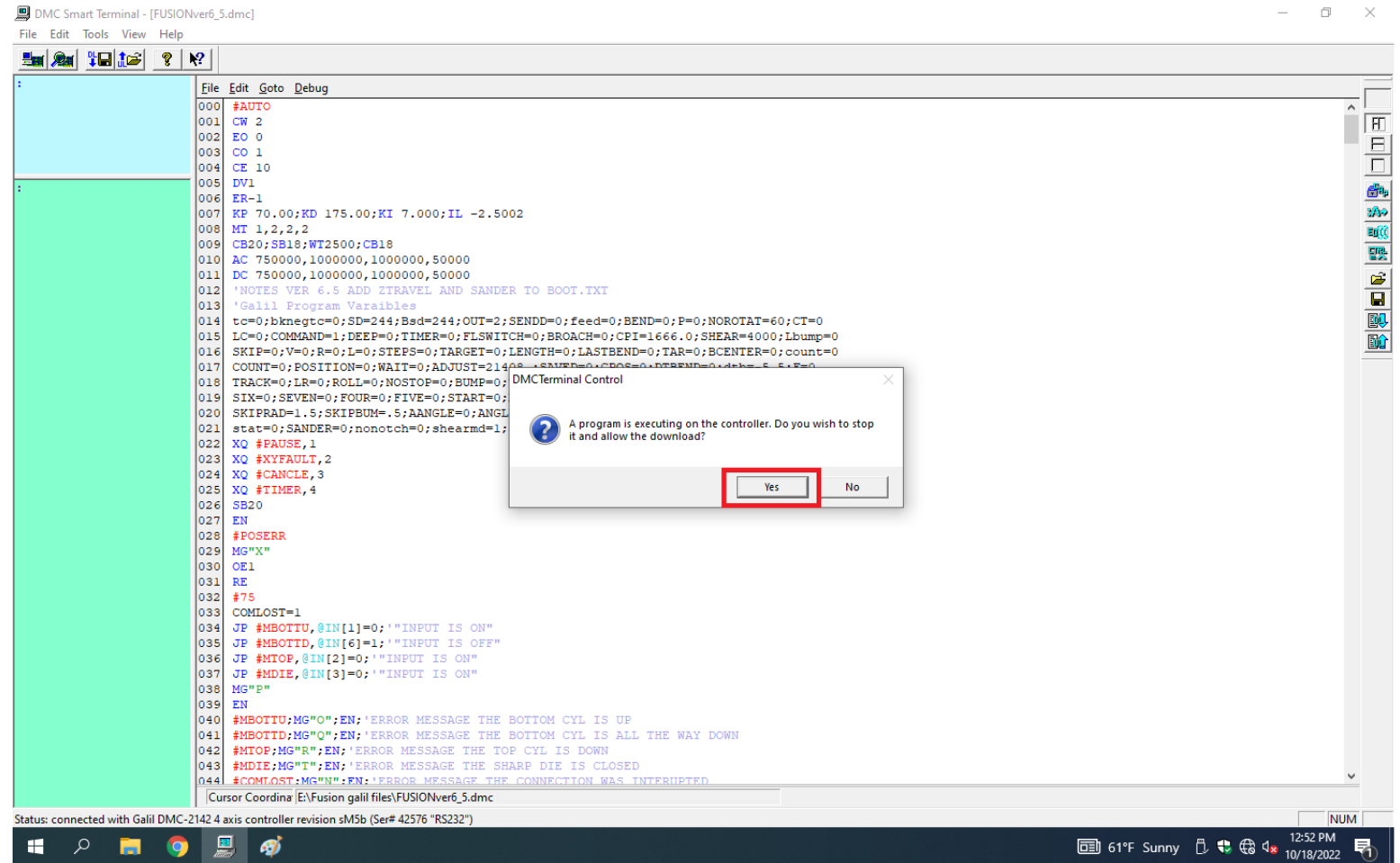
Software update

- Click on File download to controller



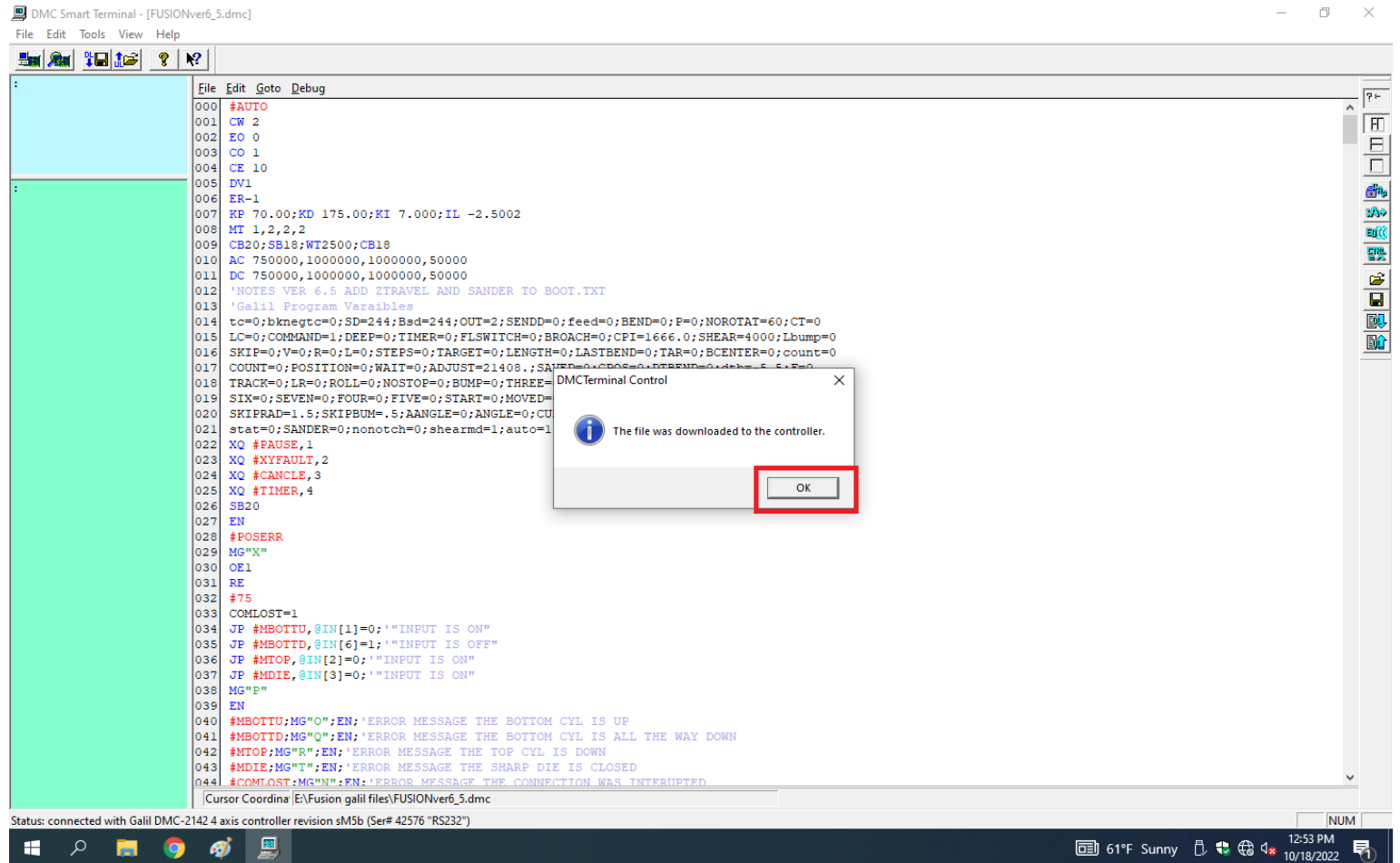
Software update

Click on Yes to download message



Software update

- Click on OK to file was download.



Software update

- You must use capital letters when typing in the blue screen
- In the blue screen type a **capital BP** then hit enter. Wait for 5 seconds for the program to complete burn into the controller. Exit out of the DMC Smart Terminal and don't save changes.

DMC Smart Terminal - [FUSIONver6_5.dmc]

File Edit Tools View Help

:BP

	File	Edit	Goto	Debug
000	#AUTO			
001	CW 2			
002	EO 0			
003	CO 1			
004	CE 10			
005	DV1			
006	ER-1			
007	KP 70.00;KD 175.00;KI 7.00			
008	MT 1,2,2,2			
009	CB20;SB18;WT2500;CB18			
010	AC 750000,1000000,1000000,			
011	DC 750000,1000000,1000000,			
012	'NOTES VER 6.5 ADD ZTRAVEL			
013	'Galil Program Variables			
014	tc=0;bknegtc=0;SD=244;Bsd=			
015	LC=0;COMMAND=1;DEEP=0;TIME			
016	SKIP=0;V=0;R=0;L=0;STEPS=0			
017	COUNT=0;POSITION=0;WAIT=0;			
018	TRACK=0;LR=0;ROLL=0;NOSTOP			
019	SIX=0;SEVEN=0;FOUR=0;FIVE=			
020	SKIPRAD=1.5;SKIPBUM=.5;AAN			