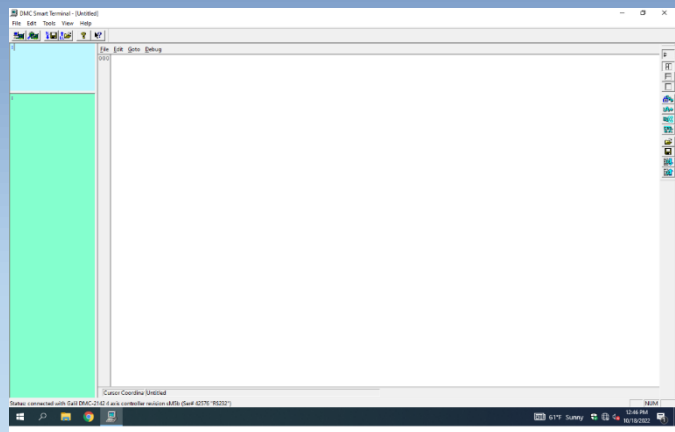




of South Florida, Inc.

*High Performance | Tight Tolerances | Clean Cuts*

# CLN 1510 and 2010 Galil Software Update



# Software update

## Installing the Galil files to the controller.

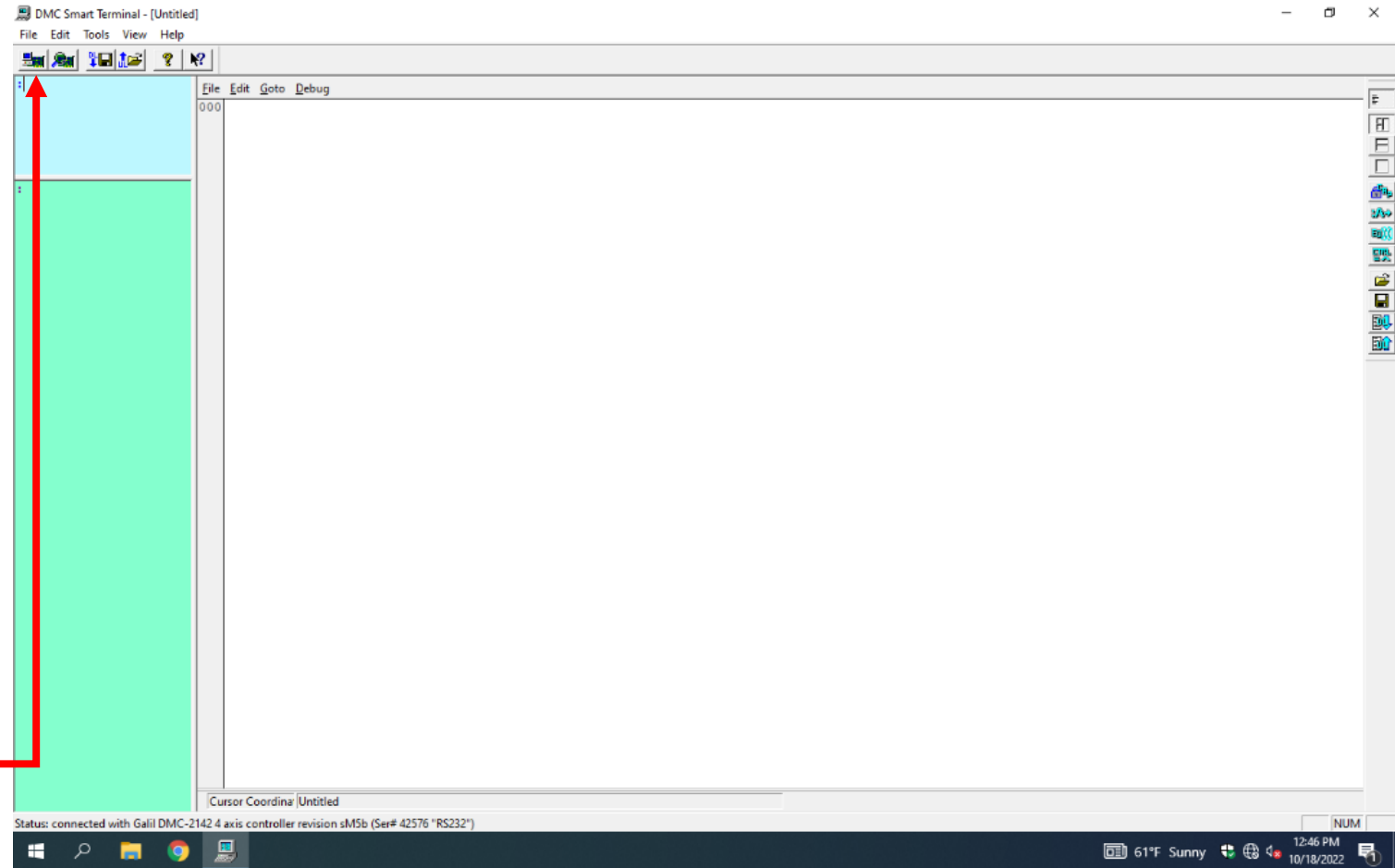
- This update is only for machines that have a external reset button, located on the left side of the machine. The older machines have a different controller and there is no controller update for them. However, the software still available for this machine.
- Go to <https://www.clnofsouthflorida.com/free-cnc-machine-software-cln/>
- Download the CLN 1510 or 2010 Notching Software.
- Extract the zip folder to the desktop for easy access.
- Double click on the extracted folder.
- Copy the **Notcher\_Ver\_2.dmc** file and past it to the C:\Notcher folder.



# Software update

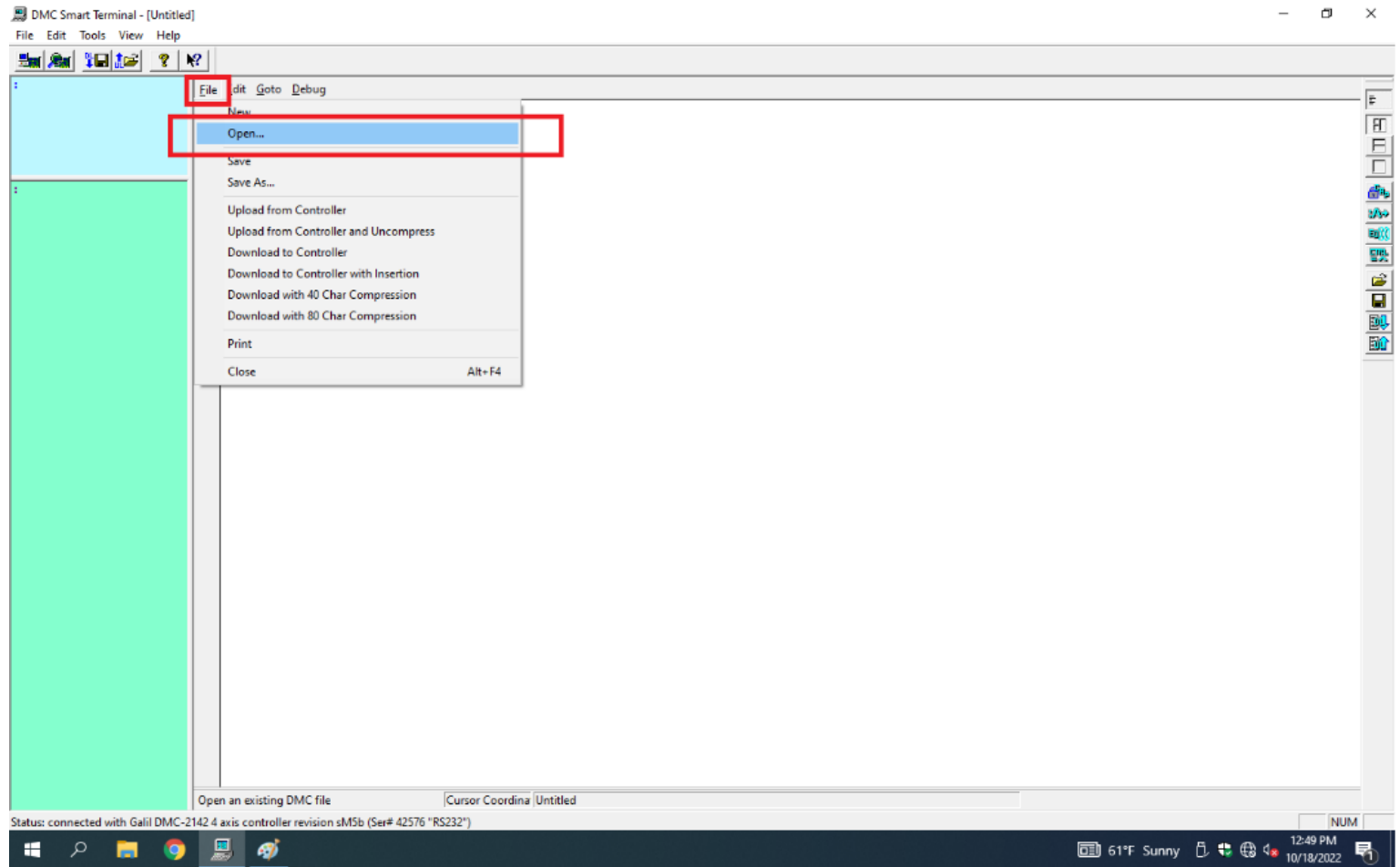
## Installing the Galil files to the controller.

- The Notcher\_Ver\_2.dmc needs to be downloaded into the machine's controller. First make sure that the CLN Program is completely shut down. Go to the task manager and look for **CLN.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.
- Its not easy to connect to the controller with the DMC Smart Terminal. There is a program that's is running in the controller, and it must be interrupted for the DMC Smart terminal to connect. You must press the external reset button and at the same time click on the connect to controller icon. If it fails try it again. This may take a few try's to get it.
- 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.



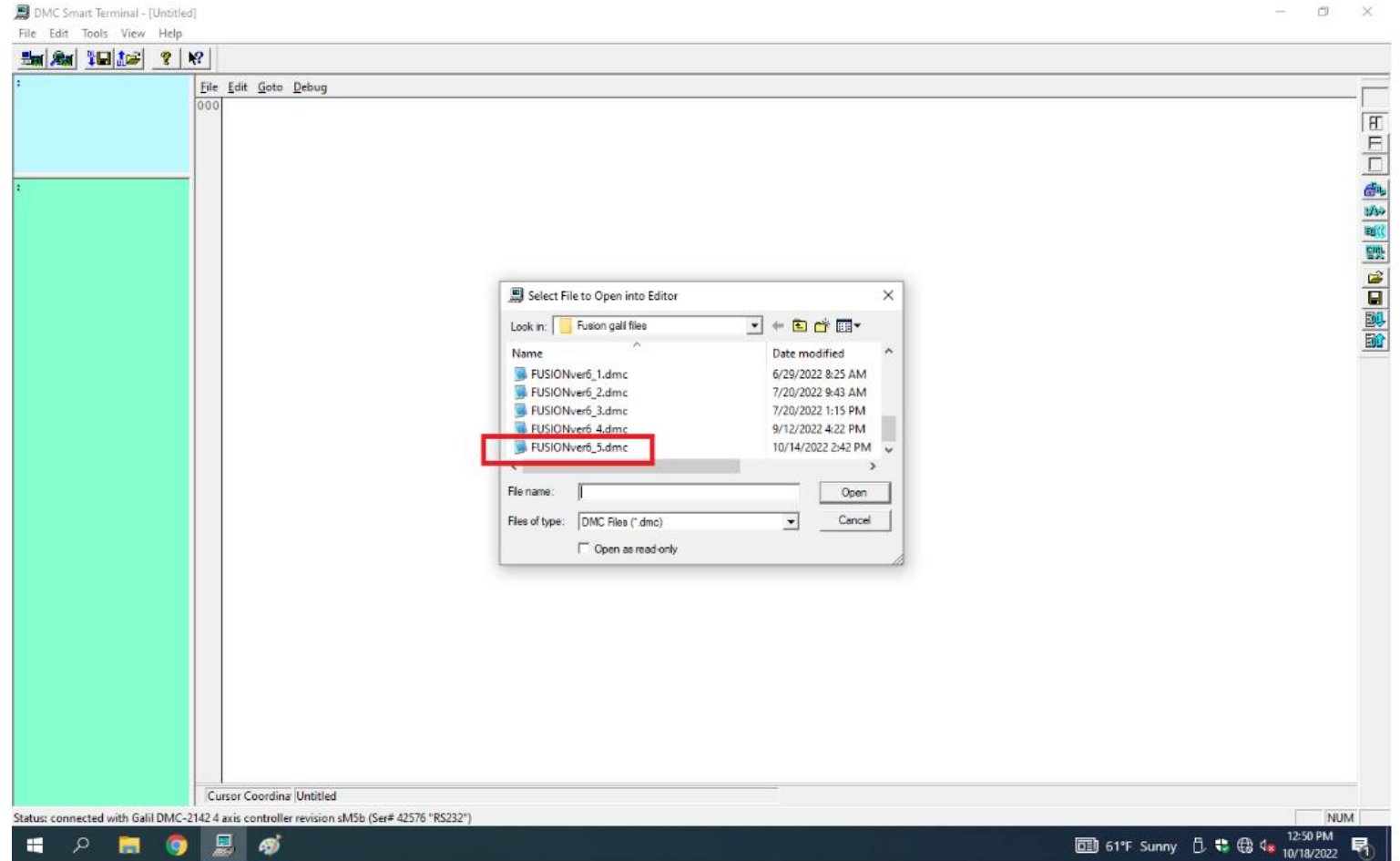
# Software update

In the editor screen click on file open.



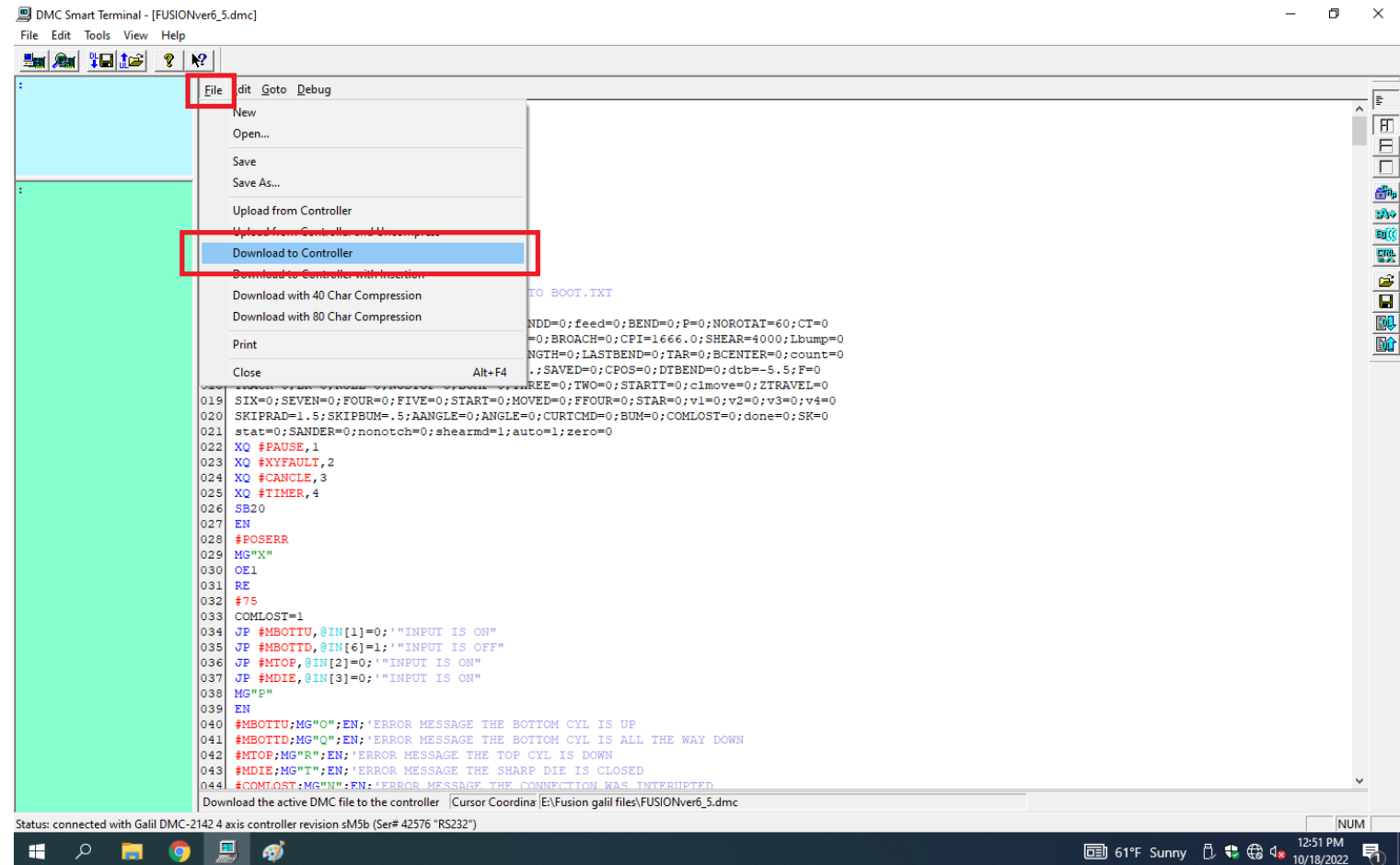
# Software update

- Go to C:\ Notcher and click on Notcher\_Ver\_2.dmc file.



# Software update

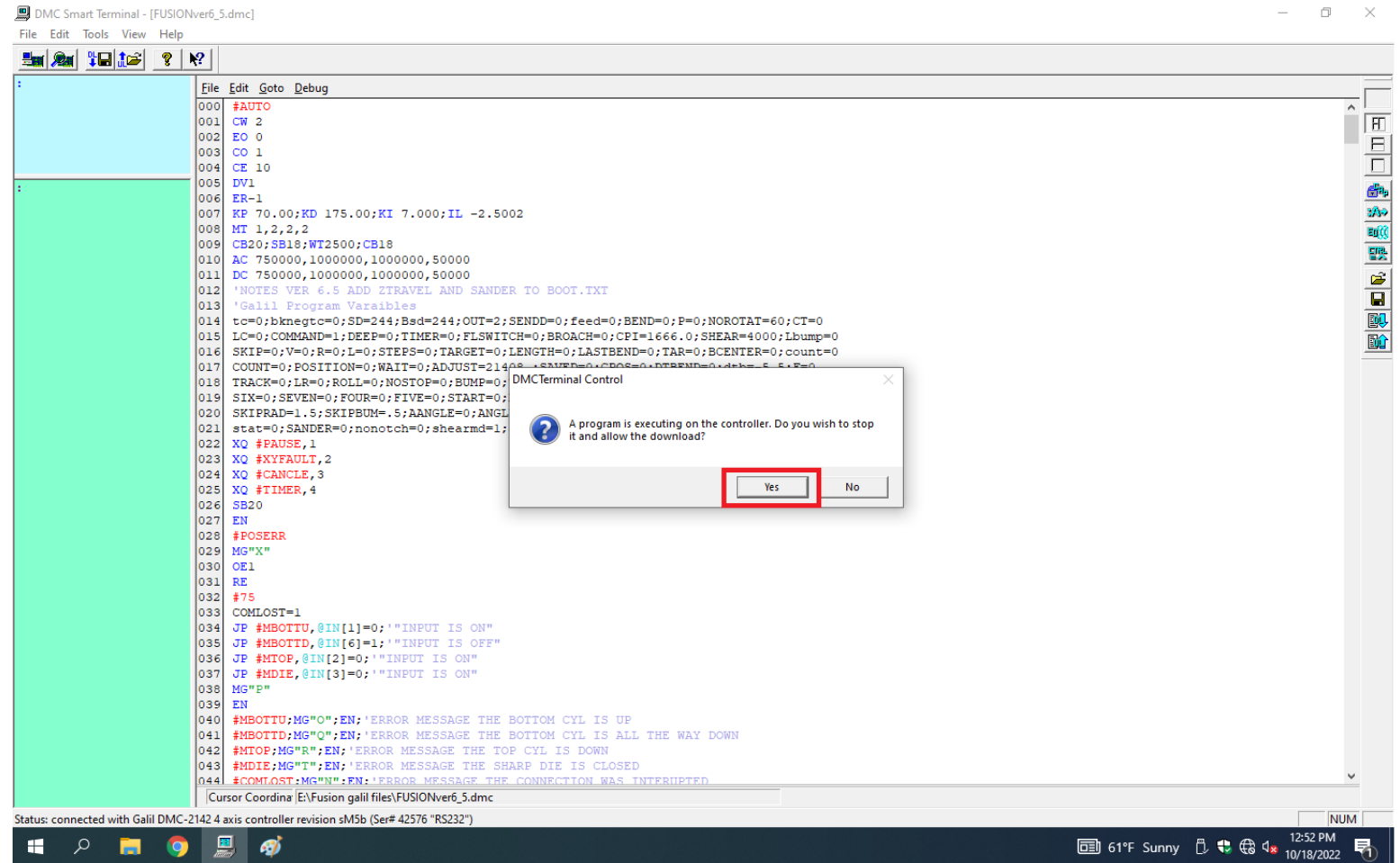
- Click on File download to controller





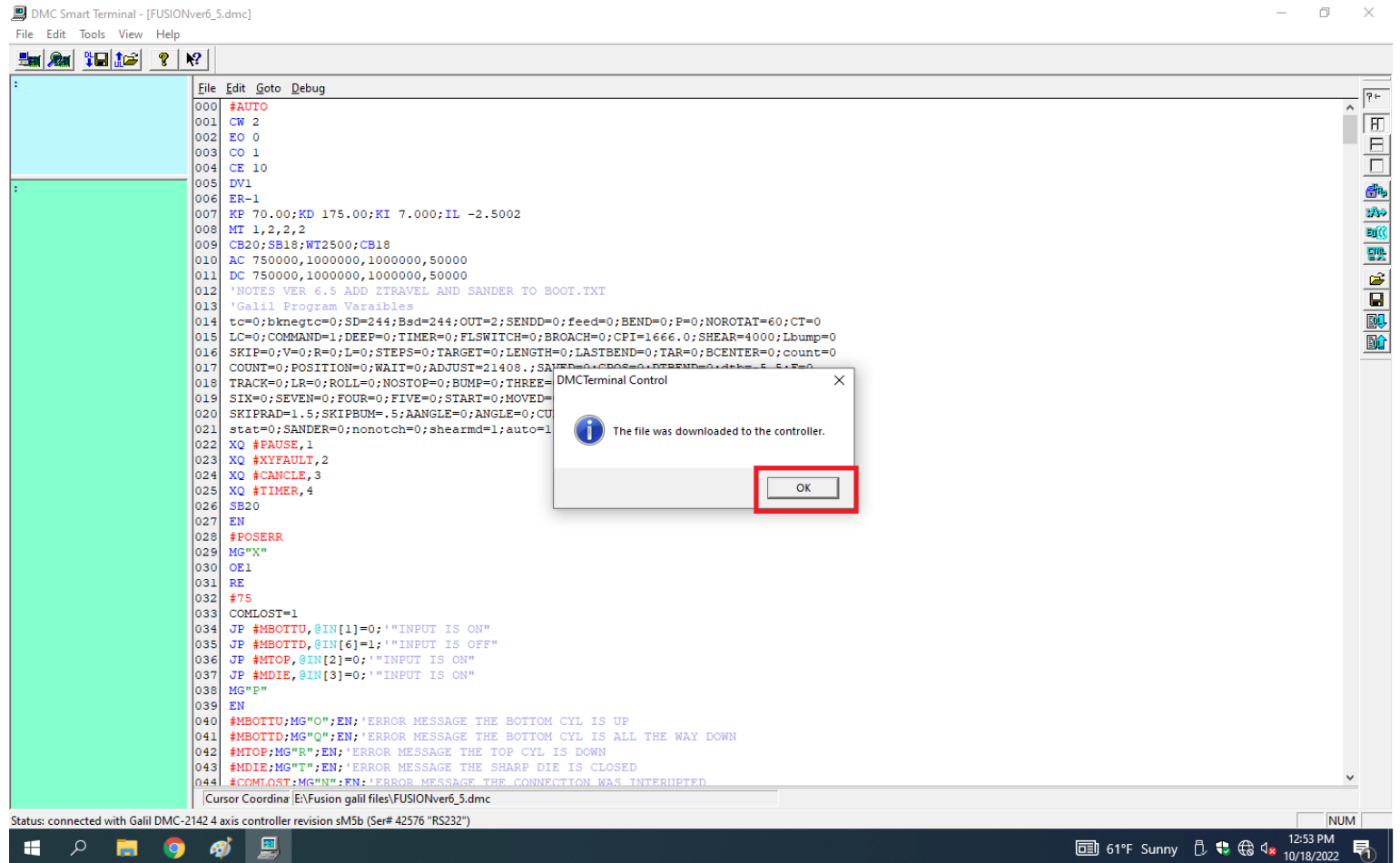
# Software update

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

```
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
```