



of South Florida, Inc.

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CLN 1510 and 2010 Software Update



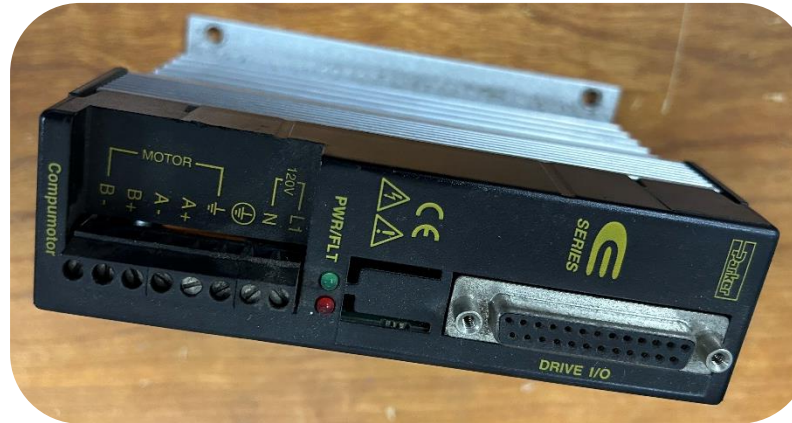
Software update

- You must identify what Step Motor Drive is installed in the machine.
This is how you can tell what drive came with your machine.
Remember this for future reference.

2000 D6I



Parker EA-C

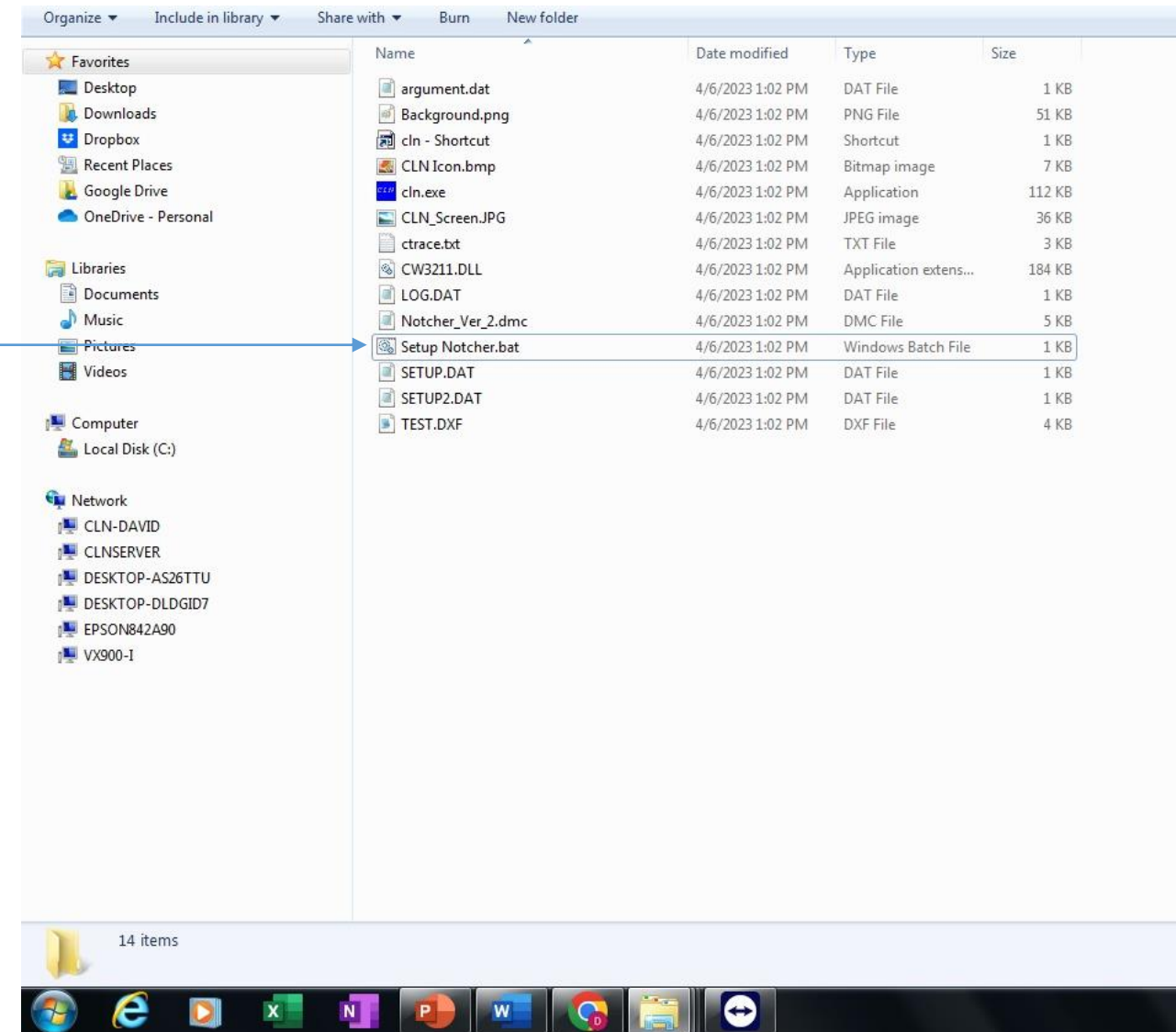


Lead Shine



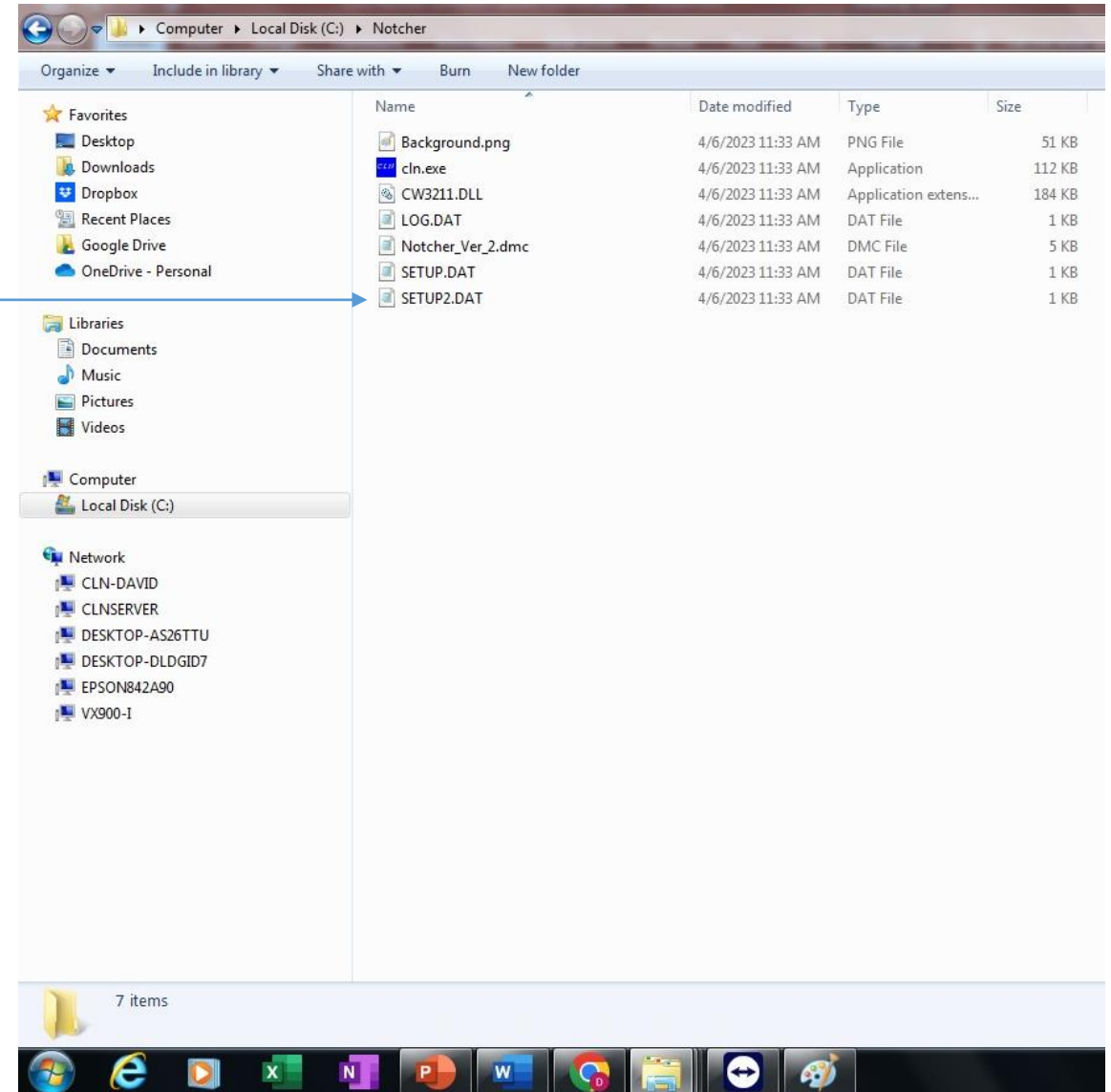
Software update

- Go to <https://www.clnofsouthflorida.com/cnc-machines-tech-support/>
- Download the CLN Notcher software.
- Unzip it to the desktop for easy access.
- Double click on the extracted folder.
- Double click on **Setup Notcher.bat**
- If you receive a Windows Protection message that is preventing an unrecognized app from starting. Click More Info then Run Anyway.
- This will make new 2 folders. One folder call Notcher and one called Jobs. (C:\Notcher) (C:\Jobs).



Software update

- Go to the C:\Notcher folder.
- Double click on Setup2.DAT.
- Open it with notepad.



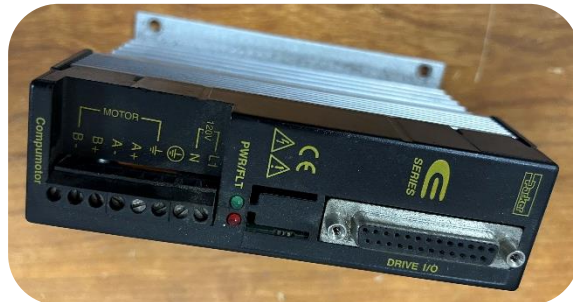
Software update

- Over the years. There were 3 step motor drives that were used in the notcher.
- 1. 2000-D6I: Skip this step. Setup2.DAT is not needed.
- 2. Parker EA-C: Drive =0
- 3. Lead Shine: Drive =1
- The drive type needs to be changed to the type of drive that you have installed in the machine. The example shows a 1 for Lead Shine. You need to make it a 0 for Parker EA-C
- If Drive=1 then, to get the calibration of the step motor close, the SPCNT needs to =10
- If Drive=0 then, to get the calibration of the step motor close, the SPCNT needs to =20
- Save and exit Notepad

Lead Shine, Drive =1



EA-C, Drive =0



```
SETUP2 - Notepad
File Edit Format View Help
'Use with Galil config file: Notcher_Ver_1.DMC
'Serial Number TDK-1289
'Commanded Distance / Actual Distance Moved * CPI or SPCNT = New CPI or SPCNT
'Code
phdhw=13362
'Encoder counts CPI=1664., Make number bigger to make material longer
CPI=1664.
'Step motor counts SPCNT=9.969, Make number bigger to make material longer
SPCNT=9.969
'30 Degree notcher down delay
down30=75
'30 Degree notcher up delay
up30=175
'105 Degree notcher down delay
down10=150
'105 Degree notcher up delay
up10=300
'Clamp delay up and down
clamp=300
'Flange delay down
flange=800
'Flange delay up
flanup=500
'Double dimple delay
ddimpl=200
'Single dimple delay
dimpl=200
'Shear cycle delay
shear=3000
'DM1182 Drive set Drive=1
'EAC Drive set Drive=0
Drive=1
'Make sure that all of the variables are sent
Failod=1
'END
```

Software update

- Go to C:\ Notcher folder.
- Right click on CLN.EXE and create a short cut and move it to the desk top.
- Delete the execrated install folder located on the desk top.
- Reset the machine and double click on the CLN shortcut.
- If a message pops up, when you first start the program. It's either a problem with the Com Port or commutating with the controller. It doesn't matter at this point.
- In the CLN program, go to Tools Setup.
- Change the Model to a 3 for 2000_D6I driver, and a 4 for a EA-C or Lead Shine. Save and start the program again.
- If you receive a message that says, that the Com Port is not right. Go back to tools setup and change the com port setting. The software can only be set to 1,2,3 or 4. If you are using a USB to com Port adaptor you have to configure the adaptor to 1,2,3,or 4.
- Start the program. If it open with no message then put in all of the settings for setup and setup2.DAT, that are in the back of the manual that you received with the machine.
- If you don't have the settings then watch this training video to setup the machine. [Notcher Training Video](#)

