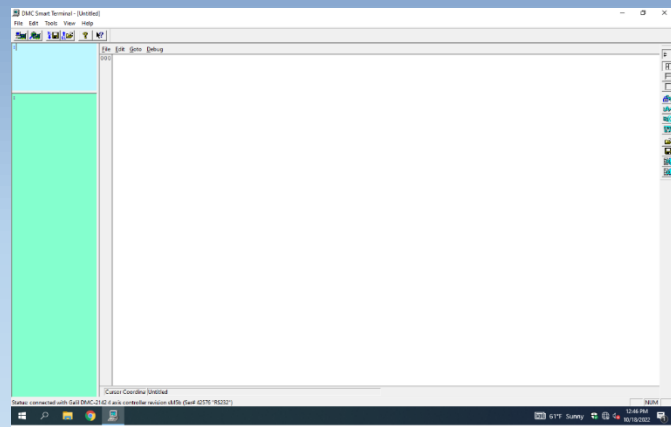




of South Florida, Inc.

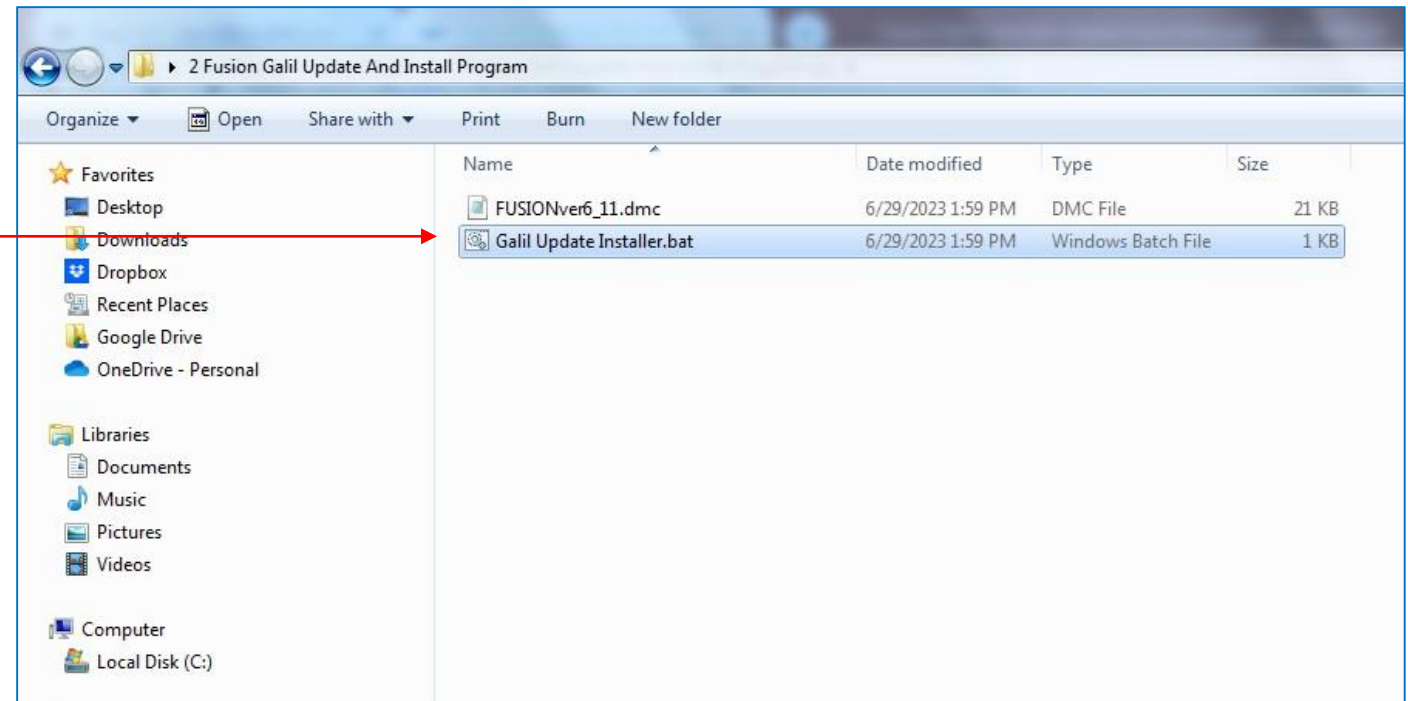
High Performance | Tight Tolerances | Clean Cuts

Fusion Galil Controller Update Instructions



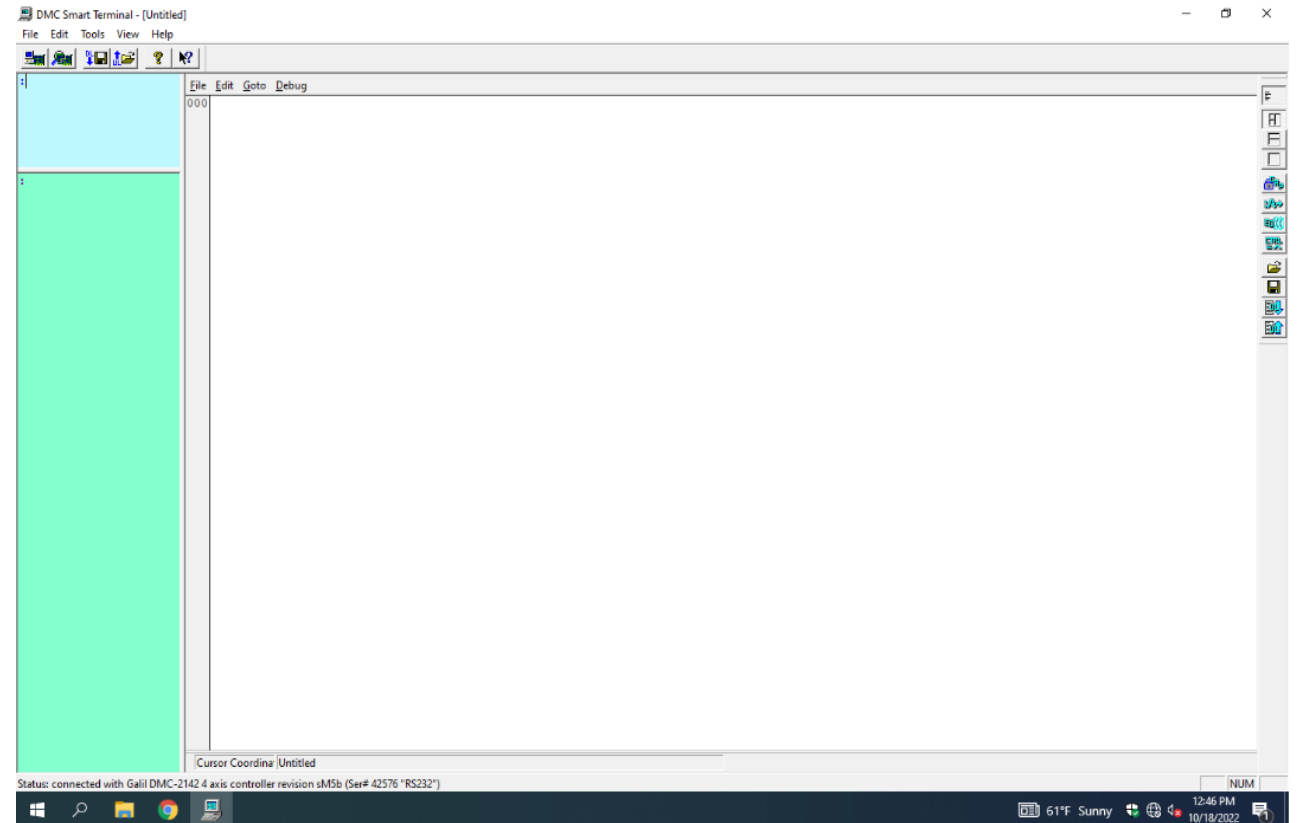
Fusion Galil Update

- Download the latest update Files at CLNofSFL.com.
- Extract or unzip the files to your desktop for easy access.
- Double click on the folder to see the extracted files.
- Double click the file called Galil Update Installer.bat.
- If you receive a Windows Protection message that is preventing an unrecognized app from starting. Click More Info then Run Anyway.
- A black screen will pop up and it will install the necessary files. You may have to press any key to continue.



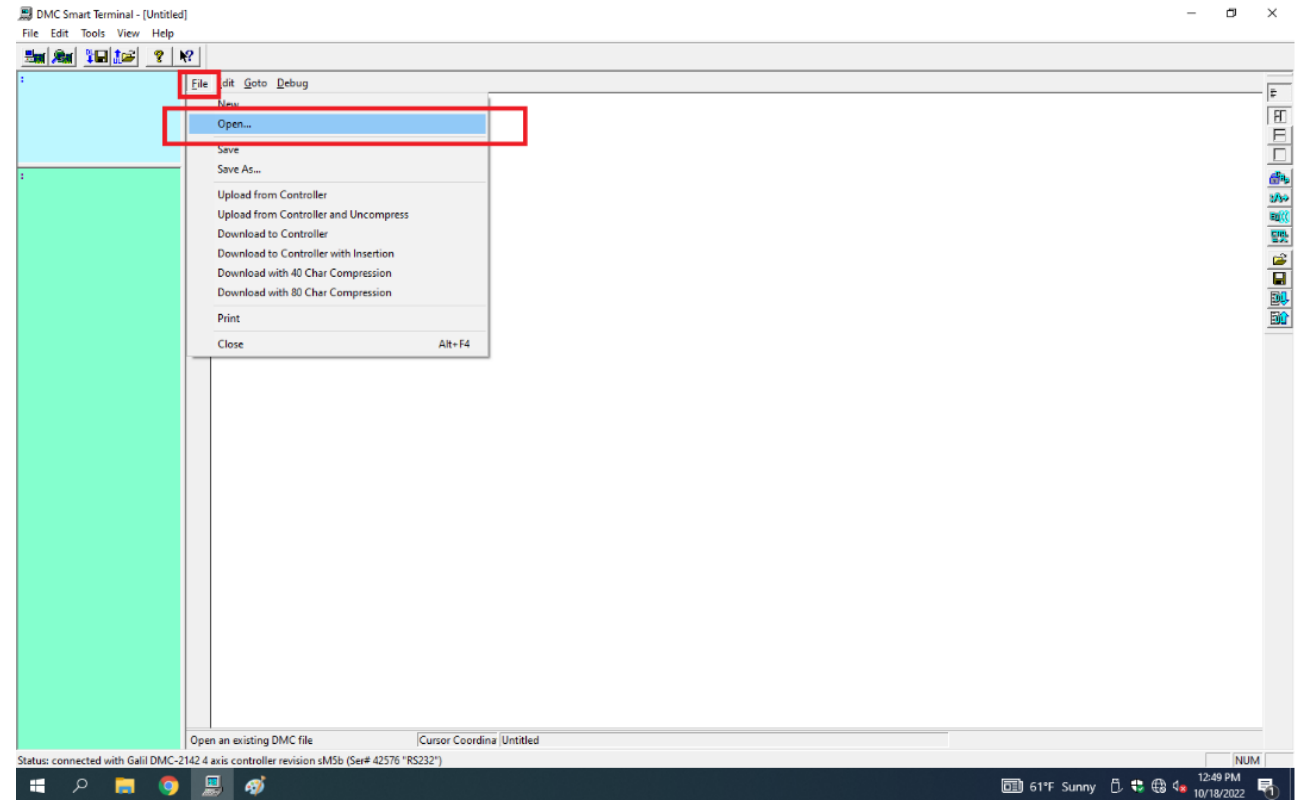
Fusion Galil Update

- **Installing the Galil files to the controller.**
- When you clicked on **Galil Update Installer.bat** you copied the files to the computer, now you have to install them into the machine's controller.
- First make sure that the fusion is completely shut down. Go to the task manager and look for **portbencode.exe** and end task on it.
- Make sure that the emergency stop is released.
- On the desktop you should have a shortcut to **DMC Smart Terminal**. If you don't have the DMC Smart Term Icon, Go to [CLN of South Florida Tech Support Page](#) and down load the DMC Smart Terminal.
- Double click on the DMC Smart Terminal Icon. If the program starts correctly, you should have 3 different color screens pop up.
- The large white one is the editor, the blue one is for sending commands and the green one is for receiving them.



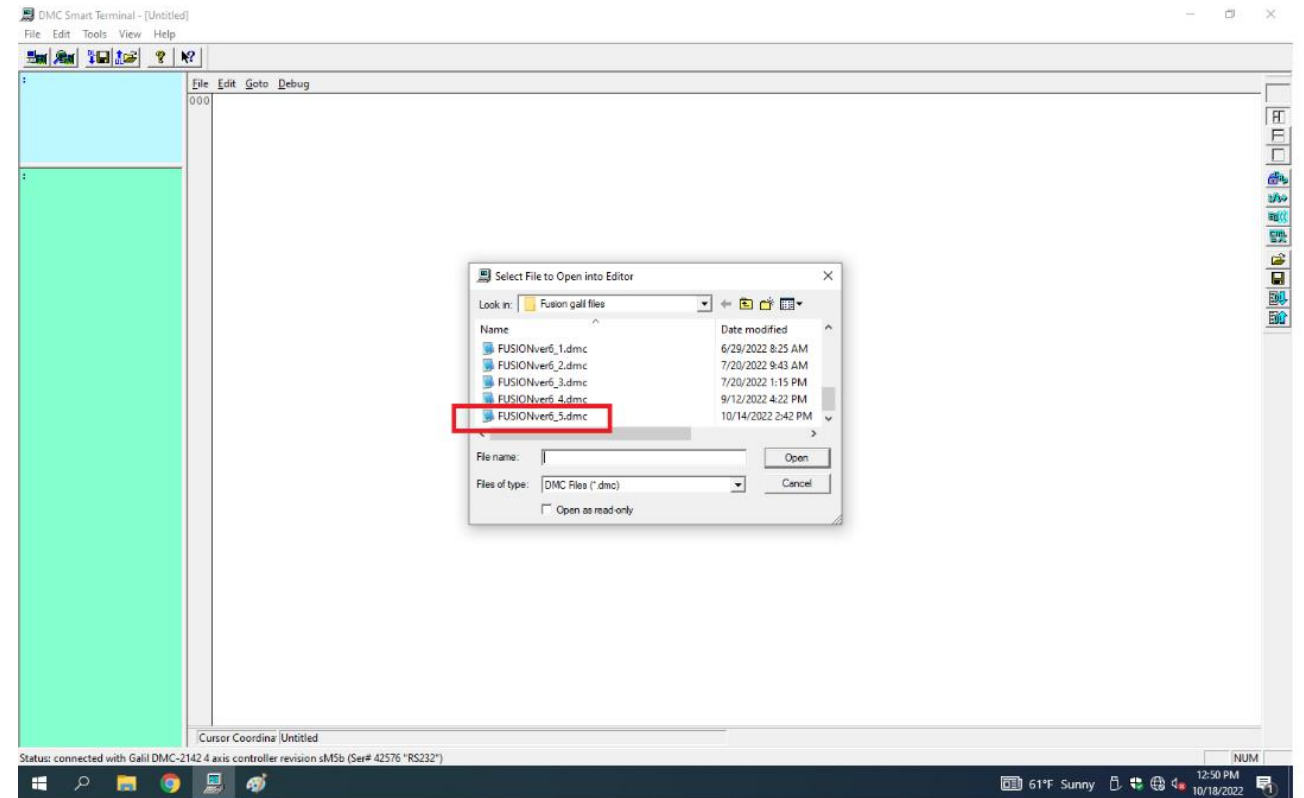
Fusion Galil Update

In the editor screen click on file open.



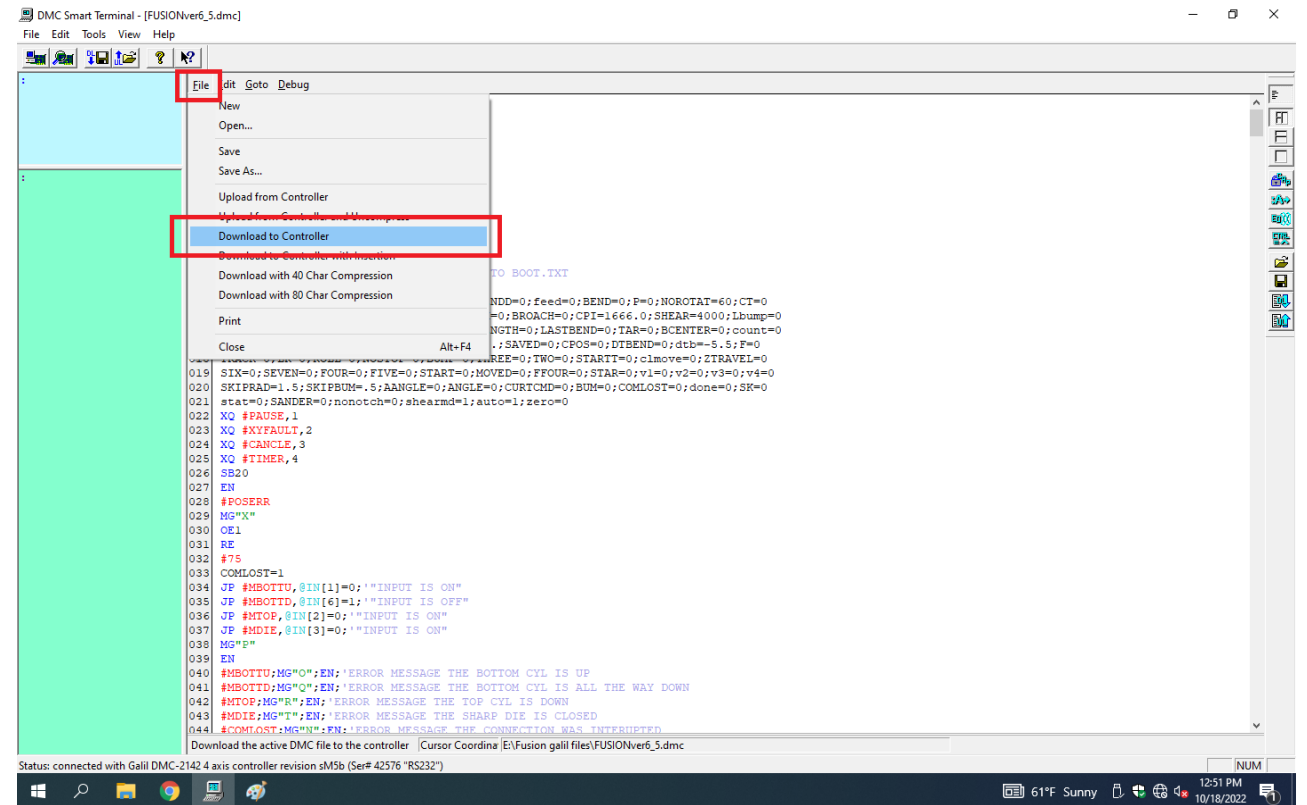
Fusion Galil Update

- Go to C:\Fusion Galil Files. Click on the latest Galil file.



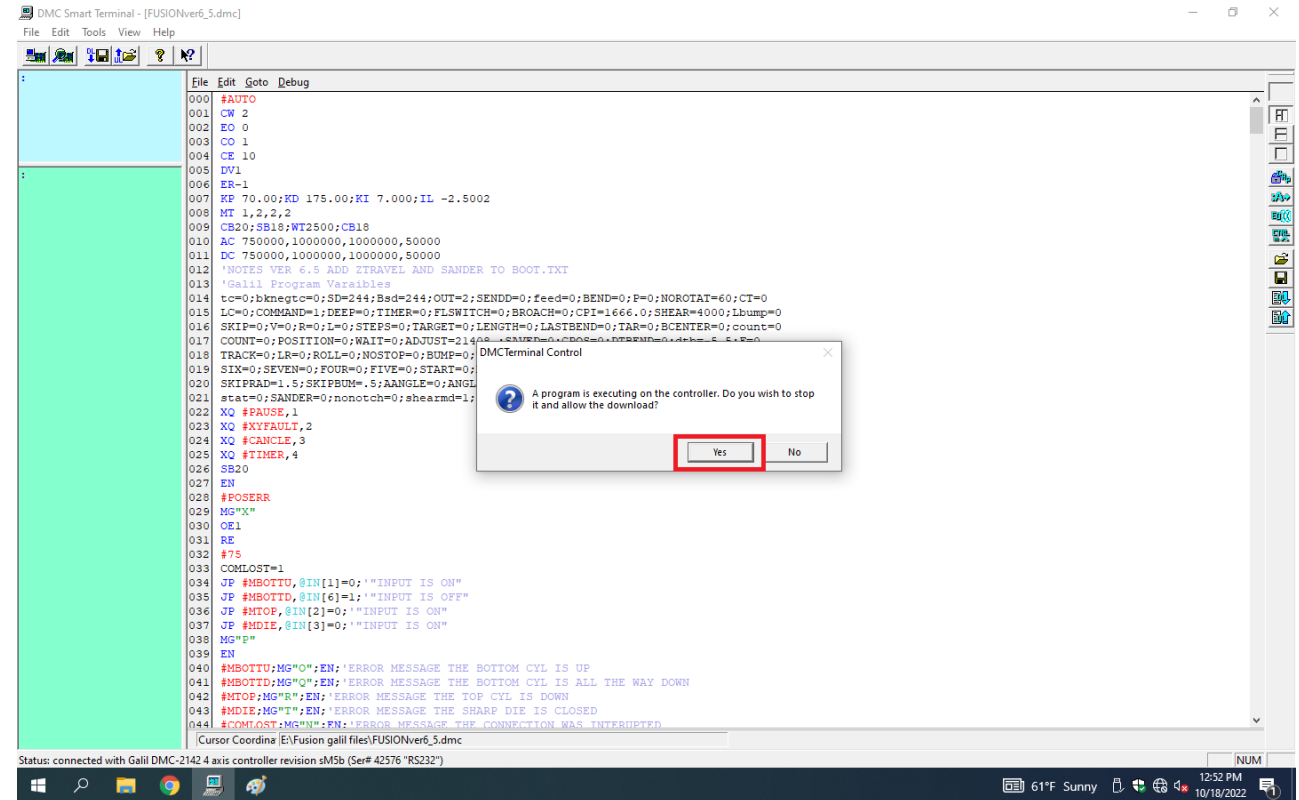
Fusion Galil Update

- Click on File download to controller



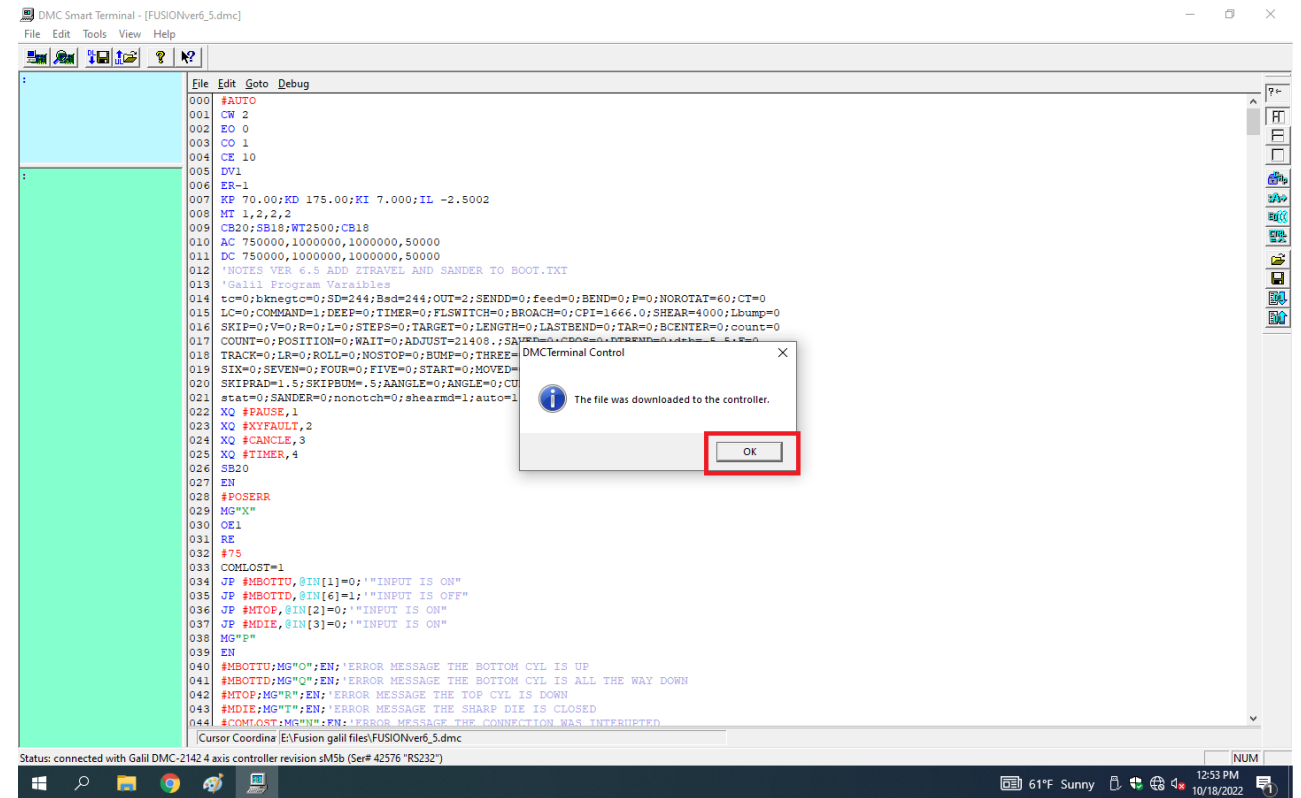
Fusion Galil Update

- Click on Yes to download message



Fusion Galil Update

- Click OK, to file was download.



Fusion Galil Update

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

```
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 7.000;IL -2.5002
008 MT 1,2,2,2
009 CB20;SB18;WT2500;CB18
010 AC 750000,1000000,1000000,50000
011 DC 750000,1000000,1000000,50000
012 NOTES VER 6.5 ADD ZTRAVEL AND SANDER TO BOOT.TXT
013 Galil Program Variables
014 tc=0;bknegtc=0;SD=244;Bsd=244;OUT=2;SEND=0;feed=0;BEND=0;P=0;NOROTAT=60;CT=0
015 LC=0;COMMAND=1;DEEP=0;TIMER=0;FLSWITCH=0;BROACH=0;CFI=1666.0;SHEAR=4000;Lbump=0
016 SKIP=0;V=0;R=0;L=0;STEPS=0;TARGET=0;LENGTH=0;LASTBEND=0;TAP=0;BCEENTER=0;count=0
017 COUNT=0;POSITION=0;WAIT=0;ADJUST=21408;SAVED=0;CPOS=0;DTBEND=0;deb=-5.5;P=0
018 TRACK=0;LR=0;ROLL=0;NOSTOP=0;BUMP=0;THREE=0;TWO=0;STARTT=0;clmove=0;ZTRAVEL=0
019 SIX=0;SEVEN=0;FOUR=0;FIVE=0;START=0;MOVED=0;FFOUR=0;STAR=0;v1=0;v2=0;v3=0;v4=0
020 SKIPRAD=1.5;SKIPBUM=.5;AANGLE=0;ANGLE=0;CURTCMD=0;BUM=0;COMLOST=0;done=0;SK=0
021 stat=0;SANDER=0;nonotch=0;shearwd=1;auto=1;zero=0
022 XQ #FAUSE,1
023 XQ #XYFAULT,2
024 XQ #CANGLE,3
025 XQ #TIMER,4
026 SB20
027 EN
028 #POSERR
029 MG"X"
030 OE1
031 RE
032 #75
033 COMLOST=1
034 JP #NBOTTU,0IN[1]=0;"INPUT IS ON"
035 JP #NBOTTU,0IN[6]=1;"INPUT IS OFF"
036 JP #NTOP,8IN[2]=0;"INPUT IS ON"
037 JP #MDIE,8IN[3]=0;"INPUT IS ON"
038 MG"P"
039 EN
040 #NBOTTU;MG"O";EN;"ERROR MESSAGE THE BOTTOM CYL IS UP"
041 #NBOTTU;MG"O";EN;"ERROR MESSAGE THE BOTTOM CYL IS ALL THE WAY DOWN"
042 #NTOP;MG"R";EN;"ERROR MESSAGE THE TOP CYL IS DOWN"
043 #MDIE;MG"R";EN;"ERROR MESSAGE THE SHARD DIE IS CLOSED"
044 #COMLOST;MG"N";EN;"ERROR MESSAGE THE CONNECTION WAS INTERRUPTED"

Cursor Coordinate [E:\Fusion galil files\FUSIONver6_5.dmc]
Status: connected with Galil DMC-2142 4 axis controller revision sM5b (Ser# 42576 "RS232")
61°F Sunny 12:54 PM 10/18/2022
```