



# **MAZAK® M PLUS/ T PLUS Memory Upgrade**

## *Installation Instructions*

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## Instructions for control configuration for the Memex 1.5MB Memory Upgrade for the MAZAK T PLUS

### **REMARKS:**

The T-plus control is similar to the T32 control's method of initializing the memory. The 1131 procedure to put the control into "privileged mode" and the saving/loading of parameters to EEPROM are slightly different. These differences will be explained in this bulletin.

Similar to the T32, the T-plus is divided into 4 different memory areas.

Such as:

1. Area 00 8- CNC controls internal canned cycles.
2. Area 01 - Machine macro's area used for Slant ATC machines to control the C-axis when not an integral spindle. Also, movement commands for tool magazine on Integrex type machines.
3. Area 10 - Part program area.
4. Area 11 - Setup area for part programs, Gets saved normally during download of part programs depending on 157 bit 1. To gain access to these areas is accomplished by first getting into the control's "privileged mode." Next, go to Program File where a new "Device Change" menu key will now appear.

### **To do this on T-plus:**

### **Getting to Privilege Mode.**

- 1) Select Param menu key.
- 2) Press the extreme right menu key.
- 3) Type in 1131 and press Input.
- 4) You are now in "privileged mode," The menu button will not highlight as on the T32 control.

### **Changing Memory Area:**

- 5) Once in "privileged mode", select Program page.
- 6) Select Program File menu key.
- 7) Press "Device Change" menu key.
- 8) Type in the 00, 01, 10 or 11 memory area.

## **Reinitializing memory:**

**The procedure for Reinitializing memory is as follows:**

1) Back up all data. Make sure you check the 01 memory area to see if any machine programs are there. Save Parameters into EEPROM.

A) Do previous procedure to get to ‘privileged mode’.

B) Select Program menu key. ,

C) Select Program File menu key.

D) Press Device Change menu key.

E) Type in 01 and Input. This will display any programs. If there are programs, then please save them.

2) Power off machine.

3) Flip dip switch 1 and 3 on QX141 to the right hand side.

4) Power on control, and you should see the two green LEDs 1 & 2 go out after about 30 seconds.

5) Power off the control

6) Reset dip switches 1 & 3 to the left.

7) Power on the control.

8) Next, go to User parameter and set I1 to 2(CMT BAUD) and I65 to Bit 0=1. Next, reload parameter information. Or, reload the parameters from EEPROM.

A) Go to Diagnose page.

B) Select Version menu key.

C) Press Diagnose Monitor menu key.

D) Select Memory EEPROM menu key.

E) Bring cursor down to EEPROM.

F) Enter 2(Load) and then Input. Then press START. This will now bring parameters from EEPROM.

**Note: It would be a good idea to save to EEPROM before doing re-initialization.**

8.5) Make sure parameters OP38-OP47 are setup correctly. If they are not setup correctly you will continue to get Alarm #442

9) Power machine off,

10) Wait about 10 seconds & power on again.

11) Go into privileged mode.

12) Go to Diagnose page and select Data Erase menu key. Select all the tool data, tool offset, etc. by using the menu keys to highlight them.. You must use the --> key to get to the program, maintenance check, system program.

**Note: System program is the memory 00 area. Then key in -9999 & press Input.**

13) Reload programs and any other backed up information.

14) If a 218 alarm appears, then flip the chuck Internal/external switch and press footswitch for chuck(s).



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