

# FAGOR



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## **CPU 8055/ABC and CNC 8040/55i exchange / restore by using MEM-KEY-CARD as backup**

1. Turn OFF the machine.
2. Insert the CPU card in the empty slot of the CNC
3. Insert the backup MEM-KEY-CARD in the slot A of the CPU
4. Power ON the CNC (turn ON the machine)
5. Restore all Machine Parameters tables:  
Start with General Machine Parameters, follow the keystroke:  
**[MAIN MENU], [F7 +], [F4 MACHINE PARAMETERS],  
[F1 GENERAL PARAMETERS], [F5 LOAD], [F3 CARD A]**  
then press **[SHIFT] [RESET]** this will prepare the rest of the tables

Repeat the above keystroke for the rest of the tables that is Axes Parameters, Spindle Parameters, Serial Ports etc. Press **[SHIFT] [RESET]** after all the tables are loaded. Use **[ESC]** key to step back one level.

6. Restore PLC Program, Messages and Errors files, follow the keystroke:  
**[MAIN MENU], [F6 UTILITIES], [F2 COPY], [F2 CARD A],  
[F1 PLC PROGRAM], [F1 MEMORY], [F1 PLC PROGRAM]**

Repeat the above keystroke for the rest of the files that is PLC MESSAGES and PLC ERRORS. Press **[SHIFT] [RESET]**, and Compile the PLC program. Use **[ESC]** key to step back one level.

7. Restore OEM subroutines and other part programs  
**[MAIN MENU], [F6 UTILITIES], [F2 COPY], [F2 CARD A],  
type CARD A (source) part program number, [F6 TO], [F1 MEMORY], type  
MEMORY (destination) part program number, [ENTER]**

Repeat the above keystroke for the rest of the part programs. Use **[ESC]** key to step back one level.