

Fadal Commands

The more you know about the available commands on your Fadal control, the more efficient you become running the machine. Below is a complete list of Fadal commands with a brief description of what the command does.

| Description | Command | Parameters |
|--------------------------|------------|---|
| Auto | AU, | From, to, dry run option, direct block start. |
| Backlash | BL, 1,2,3 | Axis no. Amount to center at negative limit again at the positive limit |
| Change device | CD, | Baud rate, line feed option, command echo, device option |
| Change program blocks | CH, | From, through which program blocks |
| Copy program blocks | CO, | From, through, to just after |
| Command lock | CL | This locks out certain functions of the control |
| Cold start | CS | This zeros your machine upon startup |
| Display bucket # | DD | |
| Delete program blocks | DE, | From, through |
| Diagnostic mode | DI | For service personal only |
| Display fixture offsets | DF | |
| Display feed forward | DFF | |
| Display tool table | DT | |
| Display tool time | DTT | |
| Direct numerical control | DNC (DNCX) | Video option, error option, dry run, start block number |
| Draw | DR | Displaying from, through, CRC option, list option |
| Display variable table | DV | |
| Fixture offset | FO | Number, X, Y & Z amounts |
| Home all axes | HO | |
| Insert program blocks | IN, | From, increment |
| Learn mode | LE | First block number, increment |
| List program blocks | LI, | From, through |
| Macros | MA | |
| Memory | ME | |
| Menu | MU | |
| Manual data input | MD | |
| New program | NE | This will erase the current program in memory. See the PR command. |
| Program number | NU, | Increment for renumbering |
| Program maintenance | PR, | Program number |
| Program page edit | PA | |
| Punch program | PU, | Data option, code option, TTY option |
| Reinitialize | RI | |
| Set (parameter) | SET | Parameter code (SETX, SETY, SETZ, SETA, SETB, SETHO, SETME, SETIN) |
| Save parameters | SP | Parameter#, Option# |

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|---------------------------|----------------|--|
| Set (pallet) | (SETPA)(SETPB) | This command is used to tell the control which pallet is loaded in the machine and only occurs at start-up |
| SETTO | SETTO | Setting tool number one |
| SETTO, #: | SETTO# | Set specific tool number in the spindle |
| Let length offset | SL, | Tool number, optional change value |
| Sum program | SU, | Displaying from, through, CRC option, list option |
| Survey | SV | For use by trained technicians only |
| System parameters | SETP | |
| Tape reader input | TA, | Device option, error option, add at end |
| Tool changer home | TC, | Option |
| Tool parameter definition | TO, | Tool number, diameter, length offset. |
| Utility | UT, | Tool number |
| Verification of tape | VT | |

For an in-depth description of the user codes, refer to the maintenance manual.