

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#

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.