



To restore PLC 'ladder'

These instructions apply ONLY to G4 CNC's with VB7009 motherboard. VB7009 motherboards began shipping mid-2016. ZipLoaders that shipped with VB7009-equipped GT75's have the 9-pin ribbon cable stowed in the PLC cabinet. If you don't know if your CNC has VB7009, you can call the factory with your CNC serial number at hand.

Open the PLC cabinet door and procure the 3-foot long 9-pin ribbon cable that is stored there. Open small door on PLC and set grey "Run/Stop" switch down (Stop).

Disconnect nine-pin ribbon cable from the RS422 converter, and connect the 3-foot long 9-pin ribbon cable. Route other end of this cable to RS232 9-pin connector on back panel.

Route 3-foot long 9-pin ribbon cable from RS232 connector on back panel of CNC to RS422 converter and connect to RS422 converter as shown.

After this connection has been made, power up the CNC.

At blue CNC 'splash' screen (*"Please Backup Program Files" prompt*), drop to DOS with Ctrl-C (press and hold Ctrl key, then press C key).

At K:CNC> prompt type UPDZIP then press enter.

Follow the on-screen prompts.

After "Transfer Completed" prompt, set CNC off, reconnect RS422 converter, stow 9-pin ribbon cable in PLC cabinet, and set Run/Stop switch to Run (up).