



My MASSO Touch Controller is acting weird when I try to run a program

1. These are some of the symptoms.

A. It runs in Auto mode when it is on Single Step.

B. While running a proven program, the program will stop at a certain line while it is running and not proceed to run the rest of the program. This will also happen when you load other proven programs.

2. The problem:

A. This is caused by an “intermittent contact on the USB drive.”

3. The fix:

A. Power on the control, go to the F1 screen, double click on General Settings, then click on “Load “Autoload.nc” on power up”. Then click save.



B. Load the “Autoload.nc” program into the root directory of your USB drive.



1. Here is a copy of the Autoload.nc file.

(Autoload)

(File created: Thursday February 10 2022 - 11:11 AM)

(for Masso from Vectric VCarve Pro / Aspire 11)

(Post Processor version Metric v2.0)

(Material Size)

(X= 300.000, Y= 300.000 ,Z= 25.000)

()

(Toolpaths used in this file:)

(Profile 1)

(Tools used in this file:)

(1 = End Mill {0.5 mm})

N12 G00

N13 G21

N14 G17

N15 G90

N16 G80

N17 (End Mill {0.5 mm})

N18 T1 M06

N19 G00 Z20.000

N20 S12000 M03

N21 (Toolpath:- Profile 1)

N22 ()

N23 G94

N24 G00 X0.000 Y0.000

N25 G00 X-48.250 Y-36.030 Z5.000

N26 G01 X-48.250 Y-36.030 Z-3.000 F1200.0

N27 G02 X46.750 Y-36.280 I47.349 J-57.633 F3600.0

N28 G00 X46.750 Y-36.280 Z5.000

N29 G00 X-17.375 Y36.970 Z5.000

N30 G01 X-17.375 Y36.970 Z-3.000 F1200.0

N31 G03 X17.375 Y36.970 I17.375 J0.000 F3600.0

N32 G00 X17.375 Y36.970 Z5.000

N33 G00 X-38.750 Y68.045 Z5.000

N34 G01 X-38.750 Y68.045 Z-3.000 F1200.0

N35 G03 X-45.825 Y60.970 I0.000 J-7.075 F3600.0

N36 G03 X-38.750 Y53.894 I7.075 J0.000

N37 G03 X-31.675 Y60.970 I0.000 J7.075

N38 G03 X-38.750 Y68.045 I-7.075 J0.000

N39 G00 X-38.750 Y68.045 Z5.000

N40 G00 X-41.750 Y80.186 Z5.000

N41 G01 X-41.750 Y80.186 Z-3.000 F1200.0

N42 G03 X-55.716 Y66.220 I0.000 J-13.966 F3600.0

N43 G03 X-41.750 Y52.253 I13.966 J0.000

N44 G03 X-27.784 Y66.220 I0.000 J13.966

N45 G03 X-41.750 Y80.186 I-13.966 J0.000

N46 G00 X-41.750 Y80.186 Z5.000

N47 G00 X0.000 Y136.935 Z5.000

N48 G01 X0.000 Y136.935 Z-3.000 F1200.0

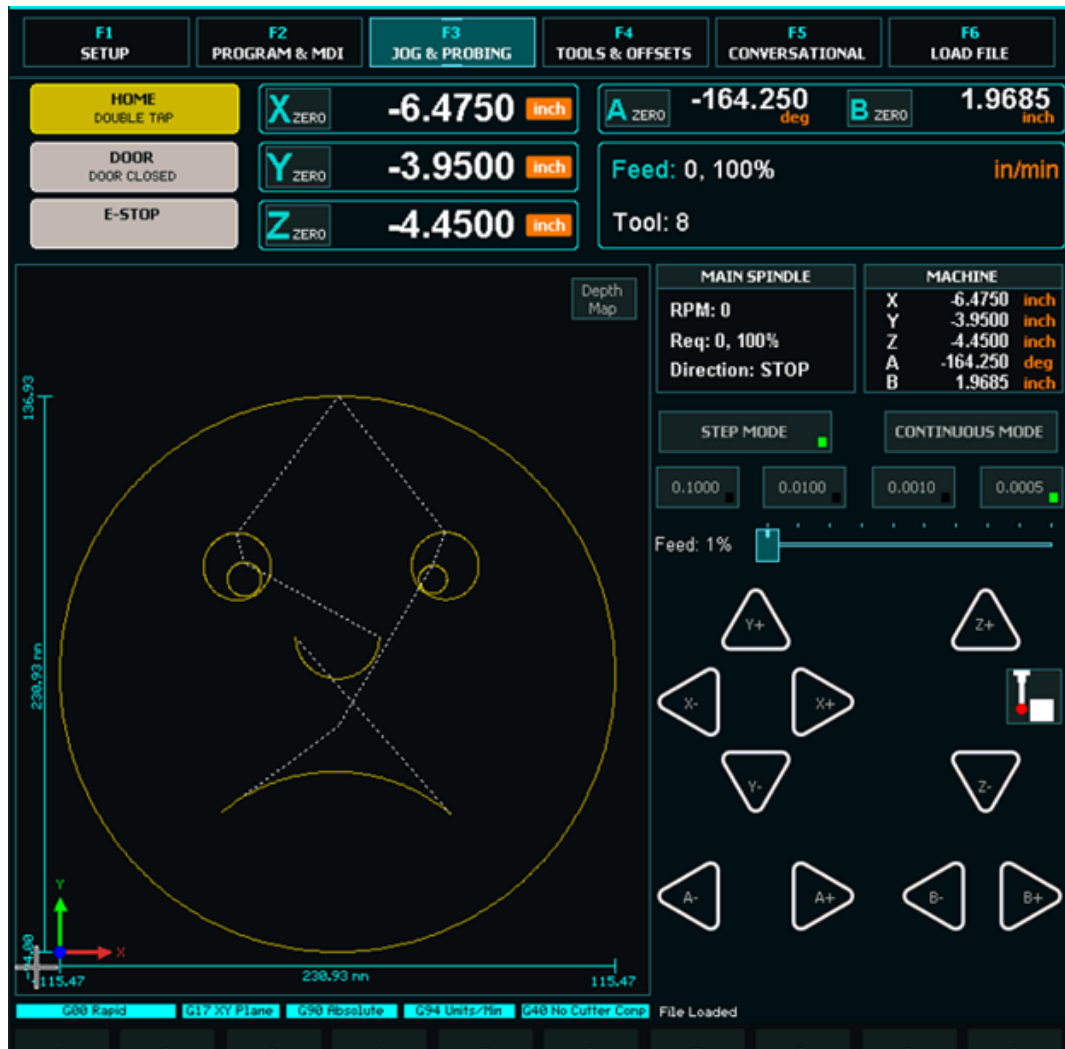
N49 G03 X-115.466 Y21.470 I0.000 J-115.466 F3600.0

N50 G03 X0.000 Y-93.996 I115.466 J0.000

N51 G03 X115.466 Y21.470 I0.000 J115.466
N52 G03 X0.000 Y136.935 I-115.466 J0.000
N53 G00 X0.000 Y136.935 Z5.000
N54 G00 X44.750 Y80.436 Z5.000
N55 G01 X44.750 Y80.436 Z-3.000 F1200.0
N56 G03 X30.784 Y66.470 I0.000 J-13.966 F3600.0
N57 G03 X44.750 Y52.503 I13.966 J0.000
N58 G03 X58.716 Y66.470 I0.000 J13.966
N59 G03 X44.750 Y80.436 I-13.966 J0.000
N60 G00 X44.750 Y80.436 Z5.000
N61 G00 X39.684 Y66.714 Z5.000
N62 G01 X39.684 Y66.714 Z-3.000 F1200.0
N63 G03 X33.847 Y60.878 I0.000 J-5.836 F3600.0
N64 G03 X39.684 Y55.041 I5.836 J0.000
N65 G03 X45.520 Y60.878 I0.000 J5.836
N66 G03 X39.684 Y66.714 I-5.836 J0.000
N67 G00 X39.684 Y66.714 Z5.000
N68 G00 Z20.000
N69 G00 X0.000 Y0.000
N70 M05
N71 M09
N72 M30
%

C. Now power off/on the control.

D. Now the control will read the Autoload.nc file on power up and you will see this image on the part/toolpath screen. This will happen every time you power up the control



E. With the Autoload.nc file loaded at start up, if you suffer a disconnection and reconnection while machining it will also load and you will know that you had a disconnection which can look like the machine has frozen when in actual fact it hasn't.

When there is a USB disconnect and autoload is active, it will load the autoload.nc file when the USB is re-connected. Then the sad face will show again on your screen.

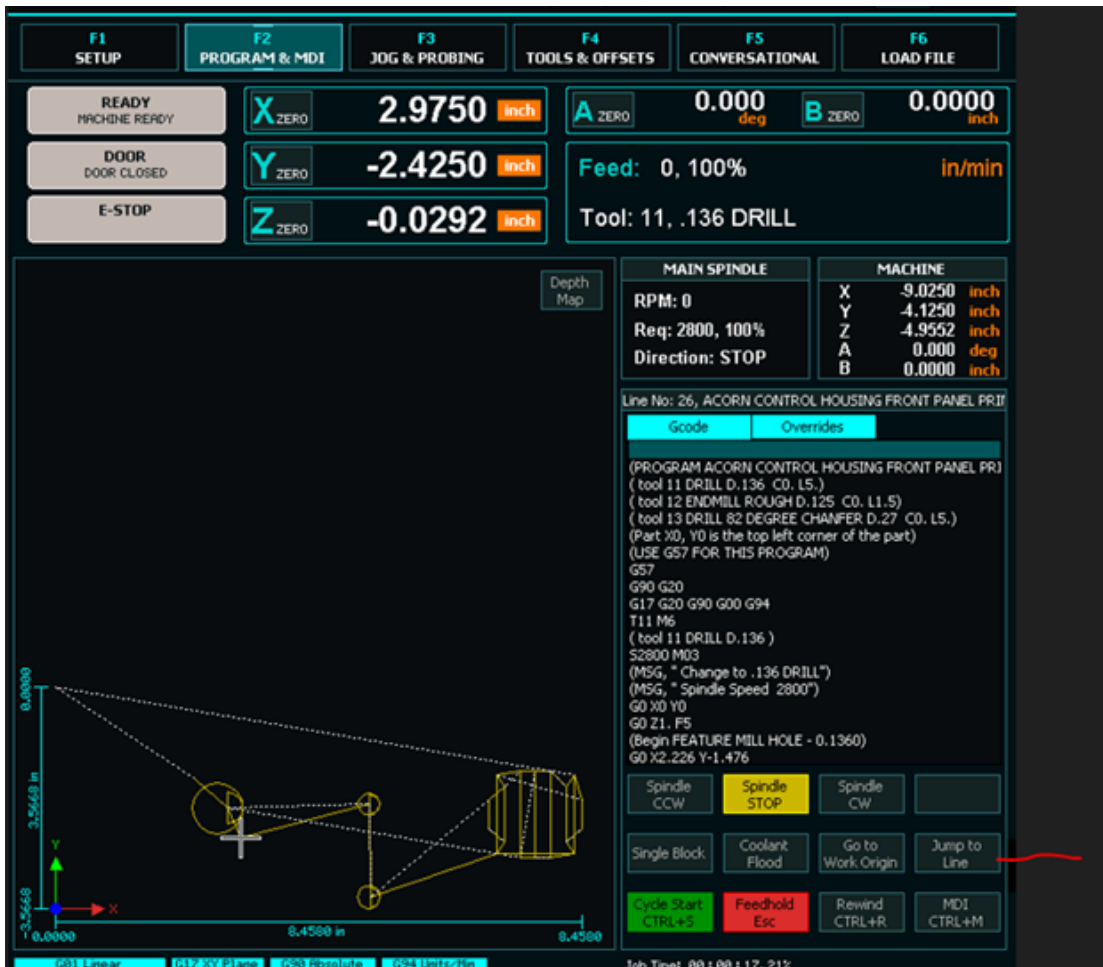
If the flash drive disconnects the machine will stop running it's program and you need to reload it to resume machining.

A real freeze mans you can't do anything at all.

If you press the Estop button and Estop flashes on screen your MASSO is not frozen or locked up.

F. To restart your program, do the following.

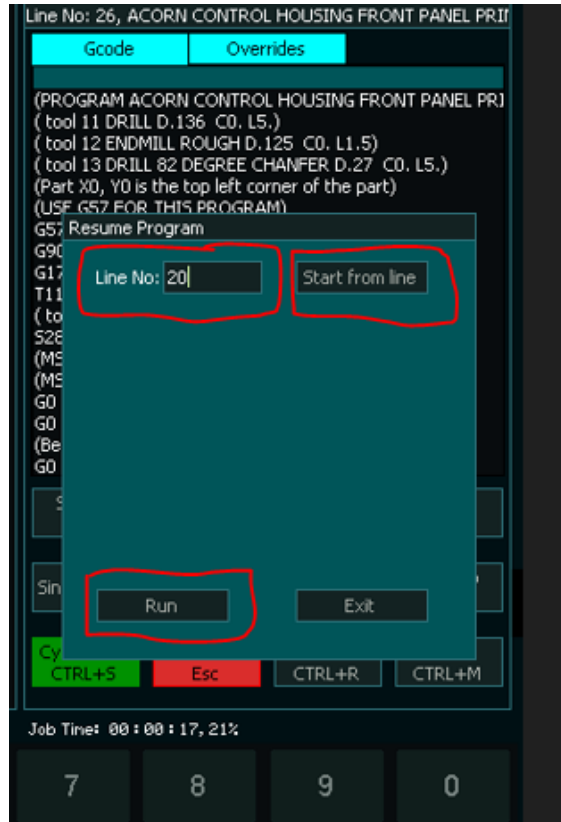
1. Go to the F6 Load File screen and reload your program.
2. Go to the F2 Program & MDI screen and then click on "Jump to Line".



3. When the jump to line box comes up, it will show the last line of the program that was running when the USB disconnected. The screen shot below shows Line No 26.



4. Change the Line No to several lines before the last line (we input line 20). Then click on “Start from line”, and then click on “Run”.



5. You will need to click on “Cycle Start” a couple times, and then the program will continue to run from where it had stopped.

G. This Autoload.nc program will load every time on power up. All you need to do in order to run your program is to go to the F6 Load File screen and load your program.

H. If you continue to have intermittent contact on the USB drive, you may consider replacing it with a new USB drive. These drive are known to go bad.