

AE018 - Status Codes and Recovery Procedures

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s100 - Compensation request queued OK

Source

O8504
O8508
O8506

Program Meaning

Confirms that a compensation request was successfully queued on the AEI.

Description

Used to indicate that compensation macro O8504 or O8508 queued the command successfully. Also used by query macro O8506 to confirm that a compensation had completed successfully.

Recovery Procedure

No action required.

s101 - No compensation demanded

Source

O8504
O8508

Program Meaning

No compensation demanded.

Description

This status value is set by compensation macros O8504 and O8508 when compensation values of zero are written to them. It causes these macros to skip. It also causes the status query macro O8506 to skip.

Recovery Procedure

No action required.

s102 - AEI Busy

Source

O8506

Program Meaning

AEI busy.

Description

Macro O8506 queried the AEI, which was busy processing a command. Typically the macro exits when this status response changes.

Recovery Procedure

No action required.

s103 - Tool ID record not found

Source

O8506

Program Message

s103 TOOL ID RECORD NOT FOUND

Description

Macro O8506 queried the AEI. The AEI reported that it has no active record for the TOOL ID queried.

Recovery Procedure

Check that the TOOL ID passed into the query macro was the same as the TOOL ID passed into the preceding compensation macro O8504 or O8508.

s128 - Cartridge OK

Source

AE Tool

Program Meaning

Cartridge OK.

Description

Cartridge operating normally.

Recovery Procedure

No action required.

s129 - Cartridge compensated OK

Source

AE Tool

Program Meaning

Cartridge compensated OK.

Description

The cartridge completed the compensation operation successfully.

Recovery Procedure

No action required.

s130 – Position too high

Source

AE Tool

Program Message

s130 POSITION TOO HIGH

Description

The tool reported that the cartridge's physical position is above its calibrated range. The cartridge may be damaged.

Recovery Procedure

Check the most recent ActiveNet records for the tool/cartridge. Has the unit been cutting nominal size at above 95 percent of its physical adjustment range? This could indicate that the cartridge has been physically damaged.

Ensure that the tool memory contains the correct calibration table for the cartridge. This can be downloaded from <http://rigibore.com/ActiveEdge/CDFDownload.php>.

Check that the cartridge is being used with an insert radius of the correct type – not with a larger radius than that specified for the tool it is being used on.

If this message persists, make a note of the Tool ID, cartridge serial number and this error code, and email to Rigibore

s131 – Position too low

Source

AE Tool

Program Message

s131 POSITION TOO LOW

Description

The tool reported that the cartridge's physical position is below its calibrated range.

Recovery Procedure

Check the most recent ActiveNet records for the tool/cartridge. Has the unit been cutting nominal size at below 10 percent of its physical adjustment range? This could indicate that the cartridge has been physically damaged.

Ensure that the tool memory contains the correct calibration table for the cartridge. This can be downloaded from <http://rigibore.com/ActiveEdge/CDFDownload.php>.

Check that the cartridge is being used with an insert radius of the correct type – not with a smaller radius than that specified for the tool it is being used on.

If this message persists, make a note of the Tool ID, cartridge serial number and this error code, and email to Rigibore

s132 – Target too low

Source

AE Tool

Program Message

s132 TARGET TOO LOW

Description

The tool reported that the requested negative compensation could not be carried out as it would exceed the minimum adjustment range of the cartridge.

Recovery Procedure

Check that the correct compensation value was sent to the tool.

Remove the cartridge from the tool and ensure that no debris has been trapped between it and the cartridge pocket.

Ensure that the tool memory contains the correct calibration table for the cartridge. This can be downloaded from <http://rigibore.com/ActiveEdge/CDFDownload.php>.

Check that the cartridge is being used with an insert radius of the correct type – not with a smaller radius than that specified for the tool it is being used on.

If this message persists, make a note of the Tool ID, cartridge serial number and this error code, and email to [Rigibore](mailto:rigibore@rigibore.com)

s133 – Target too high

Source

AE Tool

Program Message

s133 TARGET TOO HIGH

Description

The tool reported that the requested positive compensation could not be carried out as it would exceed the maximum adjustment range of the cartridge.

Recovery Procedure

Check that the correct compensation value was sent to the tool.

Ensure that the tool memory contains the correct calibration table for the cartridge. This can be downloaded from <http://rigibore.com/ActiveEdge/CDFDownload.php>.

Check that the cartridge is being used with an insert radius of the correct type – not with a larger radius than that specified for the tool it is being used on.

If this message persists, make a note of the Tool ID, cartridge serial number and this error code, and email to [Rigibore](mailto:rigibore@rigibore.com)

s134 – Cartridge not fitted

Source

AE Tool

Program Message

s134 CARTRIDGE NOT FITTED

Description

The tool reported that the cartridge was missing.

Recovery Procedure

If the cartridge was fitted to the tool:

Ensure that the elastomeric strip (AE-PCN01) has (a) been fitted and is (b) clean and undamaged. Fit or renew as necessary.

Ensure that the electrical contacts in both the tool pocket and on the underside of the cartridge are clean and untarnished. Refer to the [cartridge replacement instructions](#) for a description of the correct cleaning procedure.

If this message persists, make a note of the Tool ID, cartridge serial number and this error code, and email to [Rigibore](#)

s135 – Cartridge fault

Source

AE Tool

Program Meaning

Cartridge fault

Description

The tool reported that the cartridge may have an electrical fault.

Recovery Procedure

Ensure that the electrical contacts in both the tool pocket and on the underside of the cartridge are clean and untarnished. Refer to the [cartridge replacement instructions](#) for a description of the correct cleaning procedure.

Ensure that the elastomeric strip (AE-PCN01) is clean and undamaged.

If this message persists, make a note of the Tool ID, cartridge serial number and this error code, and email to [Rigibore](#)

s136 – Cartridge fault

Source

AE Tool

Program Meaning

Cartridge fault

Description

The tool reported that the cartridge position sensor reported no physical movement for 30 seconds during an adjustment.

Recovery Procedure

Ensure that the electrical contacts in both the tool pocket and on the underside of the cartridge are clean and untarnished. Refer to the [cartridge replacement instructions](#) for a description of the correct cleaning procedure.

Ensure that the elastomeric strip (AE-PCN01) is clean and undamaged.

Put the tool into a presetter and carry out a positive adjustment of 100 microns on diameter. If this status message appears again, **do not carry out any further adjustments**. Make a note of the Tool ID, cartridge serial number and this error code, and email to [Rigibore](#)

s137 – Partial compensation

Source

AE Tool

Program Meaning

The tool did not complete the compensation process.

Description

Cartridge compensation was interrupted part-way through the process, probably due to low battery power. The amount of compensation completed is unknown.

Recovery Procedure

Physical inspection of the tool is required and the tool should be checked for size.

Check the most recent ActiveNet records and check the tool battery condition. If the battery status is less than 30 percent, the batteries should be replaced.

s201 – Low battery

Source

AE Tool

Program Meaning

Low battery.

Description

Cartridge compensation was interrupted part-way through the process due to low battery power. The amount of compensation completed is unknown.

Recovery Procedure

Physical inspection of the tool is required, so the tool can be checked for size.

Examine the most recent ActiveNet records for the tool and check the tool battery condition. If the battery status is less than 30 percent, the batteries should be replaced.

s202 – Low battery

Source

AE Tool

Program Meaning

Low battery.

Description

The tool battery level was too low on receipt of the action command. The tool could not carry out the command and has shut down completely.

Recovery Procedure

The tool batteries must be replaced.

s204 – Tool not found

Source

ActiveNet

Program Meaning

Tool not found.

Description

The AEI was unable to receive a response from the tool after several attempts.

Recovery Procedure

Ensure that the correct TOOL ID number was used to access the tool.

Check that the tool is switched on. It is possible that the tool had automatically switched off due to low battery power while in polling mode. To confirm this, switch on the tool and immediately perform a toolcheck using ActiveNet.

s209 – Tool check failed

Source

ActiveNet

Program Meaning

Tool check failed.

Description

The ActiveNet tool check command could not be completed.

Recovery Procedure

Repeat the action after making sure that the target tool is within range of the AEI antenna.

If this message persists, make a note of the Tool ID, cartridge serial number and this error code, and email to [Rigibore](#)

s210 – Tool check failed

Source

ActiveNet

Program Meaning

Tool check failed.

Description

The ActiveNet tool check command could not be completed.

Recovery Procedure

Repeat the action after making sure that the target tool is within range of the AEI antenna.

If this message persists, make a note of the Tool ID, cartridge serial number and this error code, and email to [Rigibore](mailto:rigibore@rigibore.com)

s211 – Tool check failed

Source

ActiveNet

Program Meaning

Tool check failed.

Description

The ActiveNet tool check command could not be completed.

Recovery Procedure

Repeat the action after making sure that the target tool is within range of the AEI antenna.

If this message persists, make a note of the Tool ID, cartridge serial number and this error code, and email to Rigibore

s212 – Shutdown unconfirmed

Source

ActiveNet

Program Meaning

Shutdown unconfirmed.

Description

The ActiveNet tool shutdown command could not be confirmed.

Recovery Procedure

Visually inspect the tool to ensure that the white status indicator light does not flash for 20 seconds, indicating that the tool has switched off.

Repeat the shutdown command after making sure that the target tool is within range of the AEI antenna.

If this message persists, make a note of the Tool ID, cartridge serial number and this error code, and email to [Rigibore](mailto:rigibore@rigibore.com)

s213 – Shutdown unconfirmed

Source

ActiveNet

Program Meaning

The Shutdown unconfirmed.

Description

The ActiveNet tool shutdown command could not be confirmed.

Recovery Procedure

Visually inspect the tool to ensure that the white status indicator light does not flash for 20 seconds, indicating that the tool has switched off.

Repeat the shutdown command after making sure that the target tool is within range of the AEI antenna.

If this message persists, make a note of the Tool ID, cartridge serial number and this error code, and email to [Rigibore](mailto:rigibore@rigibore.com)

s214 – Calibration error

Source

ActiveNet

Program Meaning

Calibration error.

Description

The ActiveNet replace cartridge command failed to complete.

Recovery Procedure

Repeat the replace cartridge command after making sure that the target tool is within range of the AEI antenna.

It is essential that the tool is not used until this action has been successfully completed, as the tool calibration memory may have been corrupted.

If this message persists, make a note of the Tool ID, cartridge serial number and this error code, and email to [Rigibore](mailto:rigibore@rigibore.com)

s215 – Calibration error

Source

ActiveNet

Program Meaning

Calibration error.

Description

The ActiveNet replace cartridge command failed to complete.

Recovery Procedure

Repeat the replace cartridge command after making sure that the target tool is within range of the AEI antenna.

It is essential that the tool is not used until this action has been successfully completed, as the tool calibration memory may have been corrupted.

If this message persists, make a note of the Tool ID, cartridge serial number and this error code, and email to [Rigibore](mailto:rigibore@rigibore.com)

s300 – Invalid tool ID

Source

O8504
O8508

Program Message

s300 INVALID TOOL ID

Description

The TOOL ID passed into compensation macro O8504 or O8508 was not recognised. The compensation request was not queued.

Recovery Procedure

Check that the TOOL ID passed into the macro was within the valid range of 301 to 9999999999.

s301 – Unit 1 compensation exceeds adjustment limit

Source

O8504
O8508

Program Message

s301 UNIT 1 COMP EXCEEDS ADJUSTMENT LIMIT

Description

The compensation amount passed into the compensation macro O8504 or O8508 for UNIT 1 would exceed the physical compensation range of the cartridge. The compensation request was not queued.

Recovery Procedure

Check that the compensation value passed into the macro was within the absolute maximum valid range of +/-600 microns.

Perform a tool check using ActiveNet, and confirm that there is sufficient adjustment range available for the requested compensation.

s302 – Unit 2 compensation exceeds adjustment limit

Source

O8508

Program Message

s302 UNIT 2 COMP EXCEEDS ADJUSTMENT LIMIT

Description

The compensation amount passed into the compensation macro O8504 or O8508 for UNIT 2 would exceed the physical compensation range of the cartridge. The compensation request was not queued.

Recovery Procedure

Check that the compensation value passed into the macro was within the absolute maximum valid range of +/-600 microns.

Perform a tool check using ActiveNet, and confirm that there is sufficient adjustment range available for the requested compensation.

s303 – Corrupt response from AEI

Source

O8506

Program Message

s303 CORRUPT RESPONSE FROM AEI

Description

Status query macro O8506 received corrupt data from the AEI on three consecutive occasions.

Recovery Procedure

Check for an electrical fault by ensuring that the 4-wire interface between the AEI and the machine control is electrically secure. Particularly the white conductor.

Re-calibrate the AEI with the CNC control by running the Rigibore program O8500. Refer to the instructions located [here](#).

If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](#)

s305 – No response from AEI

Source

O8506

Program Message

s305 NO RESPONSE FROM AEI

Description

Status query macro O8506 did not receive a response from the AEI after three consecutive attempts.

Recovery Procedure

Ensure that the AEI is switched on. Try accessing the unit from ActiveNet.

Check for an electrical fault by ensuring that the 4-wire interface between the AEI and the machine control is electrically secure. Particularly the orange conductor.

Re-calibrate the AEI with the CNC control by running the Rigibore program O8500. Refer to the instructions located [here](#).

If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](#)

s306 – Corrupt response from AEI

Source

O8506

Program Message

s306 CORRUPT RESPONSE FROM AEI

Description

Status query macro O8506 received corrupt data from the AEI on three consecutive occasions.

Recovery Procedure

Check for an electrical fault by ensuring that the 4-wire interface between the AEI and the machine control is electrically secure. Particularly the white conductor.

Re-calibrate the AEI with the CNC control by running the Rigibore program O8500. Refer to the instructions located [here](#).

If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](#)

s307 – Unrecognised response from AEI

Source

O8506

Program Message

s307 UNRECOGNISED RESPONSE FROM AEI

Description

Status query macro O8506 received an unexpected response from the AEI on three consecutive occasions.

Recovery Procedure

Ensure that the latest Rigibore status codes macro O8509 is installed on the NC control.

If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](#)

s308 – Corrupt response from AEI

Source

O8506

Program Message

s308 CORRUPT RESPONSE FROM AEI

Description

Status query macro O8506 received corrupt data from the AEI on three consecutive occasions.

Recovery Procedure

Check for an electrical fault by ensuring that the 4-wire interface between the AEI and the machine control is electrically secure. Particularly the white conductor.

Re-calibrate the AEI with the CNC control by running the Rigibore program O8500. Refer to the instructions located [here](#).

If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](#)

s309 – No response from AEI

Source

O8504
O8508

Program Message

s309 NO RESPONSE FROM AEI

Description

The compensation macro O8504 or O8508 did not receive a response from the AEI after three consecutive attempts.

Recovery Procedure

Ensure that the AEI is switched on. Try accessing the AEI from ActiveNet.

If the compensation record is visible on ActiveNet, check for an electrical fault by ensuring that the 4-wire interface between the AEI and the machine control is electrically secure. Particularly the orange conductor.

Re-calibrate the AEI with the CNC control by running the Rigibore program O8500. Refer to the instructions located [here](#).

If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](#)

s310 – Invalid tool ID

Source

O8506

Program Message

s310 INVALID TOOL ID

Description

The TOOL ID passed into status macro O8506 was not recognised.

Recovery Procedure

Check that the TOOL ID passed into the macro was within the valid range of 301 to 9999999999.

s311 – Unexpected high detected on CNC input

Source

O8506

Program Message

s311 UNEXPECTED HIGH DETECTED ON CNC INPUT

Description

The CNC input was detected as high for more than 2 seconds when macro O8506 attempted to query the AEI.

Recovery Procedure

This code indicates an AEI wiring fault. Check to ensure that the 4-wire interface between the AEI and the machine control is wired correctly and that the connections are secure.

If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](mailto:rigibore@rigibore.com)

s312 – Unable to queue compensation request

Source

O8504
O8508

Program Message

s312 UNABLE TO QUEUE COMP. REQUEST

Description

The AEI was unable to queue a compensation request from macro O8504 or macro O8508. The compensation request was not queued.

Recovery Procedure

Try compensating a different tool ID on the same machine.

If this message persists, make a note of the AEI serial number, the original tool ID and this error code, and email to [Rigibore](mailto:rigibore@rigibore.com)

s313 – Tool compensation refused

Source

O8504
O8508

Program Message

s313 TOOL COMPENSATION REFUSED

Description

Compensation macro O8504 or O8508 tried to queue a compensation request. The AEI would not accept the request after three tries, because a compensation request for the tool was already queued.

Recovery Procedure

Ensure that the date and time on the PC and AEI are synchronised, by selecting the AEI in ActiveNet and performing a tool check.

If the above doesn't work, update the AEI software with the latest update (UPD) file.

If this message persists, make a note of the AEI serial number, the original tool ID and this error code, and email to [Rigibore](#)

s314 – Unexpected high detected on CNC input

Source

O8504
O8508

Program Message

s314 UNEXPECTED HIGH DETECTED ON CNC INPUT

Description

The CNC input was detected as high for more than 2 seconds when macro O8504 or O8508 attempted to queue a compensation request on the AEI. The command was not queued.

Recovery Procedure

This code indicates an AEI wiring fault. Check to ensure that the 4-wire interface between the AEI and the machine control is wired correctly and that the connections are secure.

If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](mailto:rigibore@rigibore.com)

s315 – Unrecognised response from AEI

Source

O8504
O8508

Program Message

s315 UNRECOGNISED RESPONSE FROM AEI

Description

Compensation macro O8504 or O8508 received an unexpected response from the AEI on three consecutive occasions. The compensation request was not queued.

Recovery Procedure

Ensure that the latest Rigibore status codes macro O8509 is installed on the NC control.

If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](#)

s316 – Corrupt response from AEI

Source

O8504
O8508

Program Message

s316 CORRUPT RESPONSE FROM AEI

Description

Compensation macro O8504 or O8508 received a corrupt response from the AEI on three consecutive occasions. The compensation request was not queued.

Recovery Procedure

Check for an electrical fault by ensuring that the 4-wire interface between the AEI and the machine control is electrically secure. Particularly the white conductor.

Re-calibrate the AEI with the CNC control by running the Rigibore program O8500. Refer to the instructions located [here](#).

If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](#)

s317 – Corrupt response from AEI

Source

O8504
O8508

Program Message

s317 CORRUPT RESPONSE FROM AEI

Description

Compensation macro O8504 or O8508 received a corrupt response from the AEI on three consecutive occasions. The compensation request was not queued.

Recovery Procedure

Check for an electrical fault by ensuring that the 4-wire interface between the AEI and the machine control is electrically secure. Particularly the white conductor.

Re-calibrate the AEI with the CNC control by running the Rigibore program O8500. Refer to the instructions located [here](#).

If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](#)

s318 – Corrupt response from AEI

Source

O8504
O8508

Program Message

s318 CORRUPT RESPONSE FROM AEI

Description

Compensation macro O8504 or O8508 received a corrupt response from the AEI on three consecutive occasions. The compensation request was not queued.

Recovery Procedure

Check for an electrical fault by ensuring that the 4-wire interface between the AEI and the machine control is electrically secure. Particularly the white conductor.

Re-calibrate the AEI with the CNC control by running the Rigibore program O8500. Refer to the instructions located [here](#).

If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](#)

s319 – AEI internal error

Source

O8504
O8508

Program Message

s319 AEI INTERNAL ERROR

Description

Compensation macro O8504 or O8508 sent a compensation request but the AEI was unable to process the instruction. The compensation request was not queued.

Recovery Procedure

Try running the macro after rebooting the AEI. If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](#)

s320 – Unexpected high detected on CNC input

Source

O8521

Program Message

s320 UNEXPECTED HIGH DETECTED ON CNC INPUT

Description

The CNC input was detected as high for more than 2 seconds when macro O8521 attempted to write data to the AEI. The data was not recorded.

Recovery Procedure

This code indicates an AEI wiring fault. Check to ensure that the 4-wire interface between the AEI and the machine control is wired correctly and that the connections are secure.

If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](mailto:rigibore@rigibore.com)

s321 – AEI could not capture data

Source

O8521

Program Message

s321 AEI COULD NOT CAPTURE DATA

Description

The AEI received valid data from the data capture macro O8521, but was unable to record the data.

Recovery Procedure

If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](#)

s322 – No response from AEI

Source

O8521

Program Message

s322 NO RESPONSE FROM AEI

Description

The data capture macro O8521 did not receive a response from the AEI after three consecutive attempts.

Recovery Procedure

Ensure that the AEI is switched on. Try accessing the AEI's public folder using ActiveNet.

If there are three instances of the last data capture record in data.txt, check for an electrical fault by ensuring that the 4-wire interface between the AEI and the machine control is electrically secure. Particularly the orange conductor.

Re-calibrate the AEI with the CNC control by running the Rigibore program O8500. Refer to the instructions located [here](#).

If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](#)

s323 – Invalid user opcode

Source

O8521

Program Message

s323 INVALID USER OPCODE

Description

The user opcode passed into data capture macro O8521 was not recognised. The data was not recorded.

Recovery Procedure

Ensure that the user opcode passed into the macro is within the valid range 100 to 300 inclusive.

s324 – Decimal value too big to capture

Source

O8521

Program Message

s324 DECIMAL VALUE TOO BIG TO CAPTURE

Description

The value passed into data capture macro O8521 has exceeded the permitted size for a DECIMAL value. The data was not recorded.

Recovery Procedure

Ensure that the decimal value passed into the macro is within the valid range of +/- 999,999.9999

s325 – Integer value too big to capture

Source

O8521

Program Message

s325 INTEGER VALUE TOO BIG TO CAPTURE

Description

The value passed into data capture macro O8521 has exceeded the permitted size for an INTEGER value. The data was not recorded.

Recovery Procedure

Ensure that the integer value passed into the macro is within the valid range of +/- 9,999,999,999.

s326 – Corrupt response from AEI

Source

O8521

Program Message

s326 CORRUPT RESPONSE FROM AEI

Description

Data capture macro O8521 received a corrupt response from the AEI. The data was not captured.

Recovery Procedure

Check for an electrical fault by ensuring that the 4-wire interface between the AEI and the machine control is electrically secure. Particularly the white conductor.

Re-calibrate the AEI with the CNC control by running the Rigibore program O8500. Refer to the instructions located [here](#).

If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](#)

s327 – Corrupt response from AEI

Source

O8521

Program Message

s327 CORRUPT RESPONSE FROM AEI

Description

Data capture macro O8521 received a corrupt response from the AEI. The data was not captured.

Recovery Procedure

Check for an electrical fault by ensuring that the 4-wire interface between the AEI and the machine control is electrically secure. Particularly the white conductor.

Re-calibrate the AEI with the CNC control by running the Rigibore program O8500. Refer to the instructions located [here](#).

If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](#)

s328 – Corrupt response from AEI

Source

O8521

Program Message

s328 CORRUPT RESPONSE FROM AEI

Description

Data capture macro O8521 received a corrupt response from the AEI. The data was not captured.

Recovery Procedure

Check for an electrical fault by ensuring that the 4-wire interface between the AEI and the machine control is electrically secure. Particularly the white conductor.

Re-calibrate the AEI with the CNC control by running the Rigibore program O8500. Refer to the instructions located [here](#).

If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](#).

s329 – Incorrect parameters passed to O8503

Source

O8503

Program Message

s329 INCORRECT PARAMETERS PASSED TO O8503

Description

The parameters passed into the set compensation macro O8503 are not logical.

Recovery Procedure

Check that the parameters make sense.

s330 – Bore measurement out of tolerance

Source

O8503

Program Message

s330 BORE MEASUREMENT OUT OF TOLERANCE

Description

The bore measurement passed into the set compensation macro O8503 was outside the bore specification limits.

Recovery Procedure

Check that the probe is operating correctly, or that the tool insert is not badly damaged.

s400 – Tool not found

Source

O8506

Program Message

s400 TOOL NOT FOUND

Description

Macro O8506 queried the AEI. The AEI reported that it was unable to obtain a response from the tool after several attempts.

Recovery Procedure

Ensure that the correct TOOL ID number was used to access the tool.

Check that the tool is switched on. It is possible that the tool had automatically switched off due to low battery power. To confirm this, switch on the tool and immediately perform a tool check using ActiveNet.

If this message persists, make a note of the AEI serial number, the tool ID and this error code, and email to [Rigibore](mailto:rigibore@rigibore.com).

s401 – Tool compensation failed

Source

O8506

Program Message

s401 TOOL COMPENSATION FAILED

Description

Macro O8506 queried the AEI. The response was that the tool did not confirm receipt of a compensation command. It is likely that the compensation process did not occur.

Recovery Procedure

The tool should be checked for size before being re-used.

Ensure that the target tool was within range of the AEI antenna.

If this message persists, make a note of the AEI serial number, the tool ID and this error code, and email to [Rigibore](mailto:rigibore@rigibore.com).

s402 – Tool compensation not confirmed

Source

O8506

Program Message

s402 TOOL COMPENSATION NOT CONFIRMED

Description

Macro O8506 queried the AEI. The response was that the tool acted upon the compensation command, but the AEI was unable to receive a final confirmation that the process completed successfully. It is likely that the tool was compensated successfully.

Recovery Procedure

It may be advisable to check the tool for size before it is re-used.

Ensure that the target tool was within range of the AEI antenna.

If this message persists, make a note of the AEI serial number, the tool ID and this error code, and email to [Rigibore](#).

s403 – AEI internal error

Source

O8506

Program Message

s403 INTERNAL ERROR

Description

Macro O8506 queried the AEI. The AEI was unable to access the requested compensation record.

Recovery Procedure

Try running the macro after rebooting the AEI. If this message persists, make a note of the AEI serial number and this error code, and email to [Rigibore](#).

s404 – Unusable ActiveEdge tool

Source

O8506

Program Message

s404 UNUSABLE AE TOOL

Description

Macro O8506 queried the AEI after a compensation command was successfully sent to the tool. This response indicates that the tool was unable to compensate the tool. This status condition is provided to indicate to the machine program and operator that the tool should not be used until the cause is identified.

Recovery Procedure

Consult ActiveNet and review the relevant TOOL ID record to identify what remedial action is required.