Recovering an XML Personality File

All A2MC systems have an XML "personality file" that defines the characteristics of the machine. This file includes definitions for:

- Calibrations
- Size of Machine
- Type and number of devices
- All the tool definitions
- Definitions of origins
- Type and location of ATC systems

This XML Personality File will be programmed into the machine at the factory when it is manufactured and is stored in the machines memory. In order to facilitate the recovery of a machine that has lost its XML file recent XML files are also stored on the computer that is regularly used for programming the tooling on the machine.
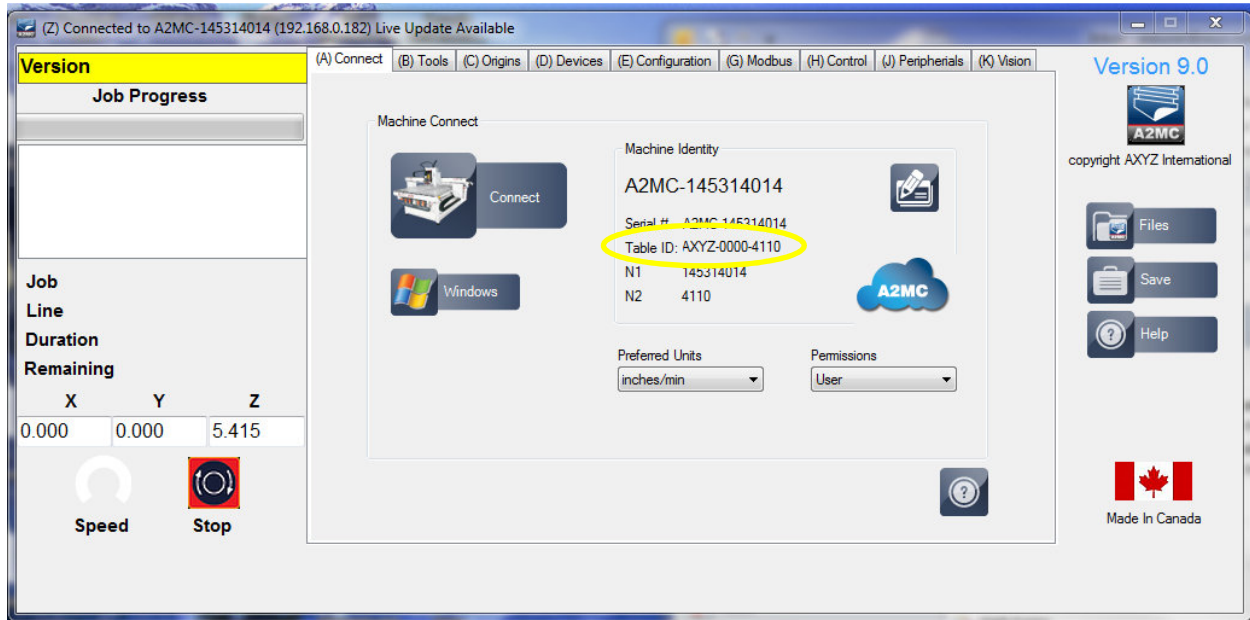
XML file recovery is usually necessary when the Compact Flash card has become corrupted and needs to be replaced. You can buy programmed Compact Flash cards from AXYZ at www.cncroutershop.com but it will not come with your specific XML personality so you will have to recover that and re-install it on the machine.

You can also use the recovery method if you have accidently programmed the XML personality incorrectly and you wish to return to an older version.
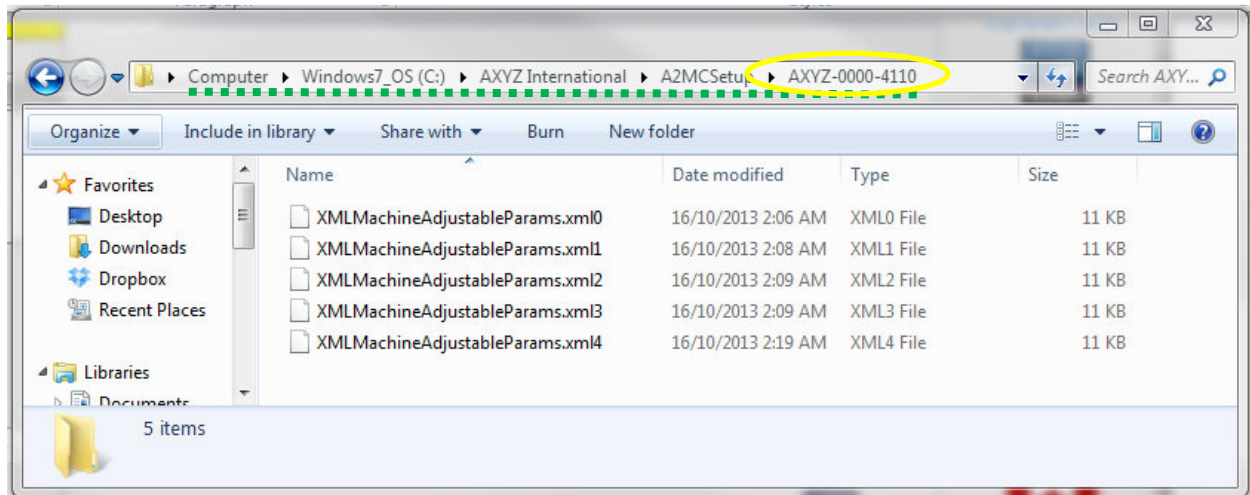
This document will explain how to do that.

XML Personality Recovery Folder

Whenever you open and then close the A2MC Setup GUI shown above it will copy the XML from the attached machine and place it in a recovery folder. The recovery folder is at the path shown in the address bar below (underlined in dotted green). Also note that the folder is named as the table ID (yellow circles in both pictures). It is easy to find. You can also search "AXYZ-" and you will find it quickly.
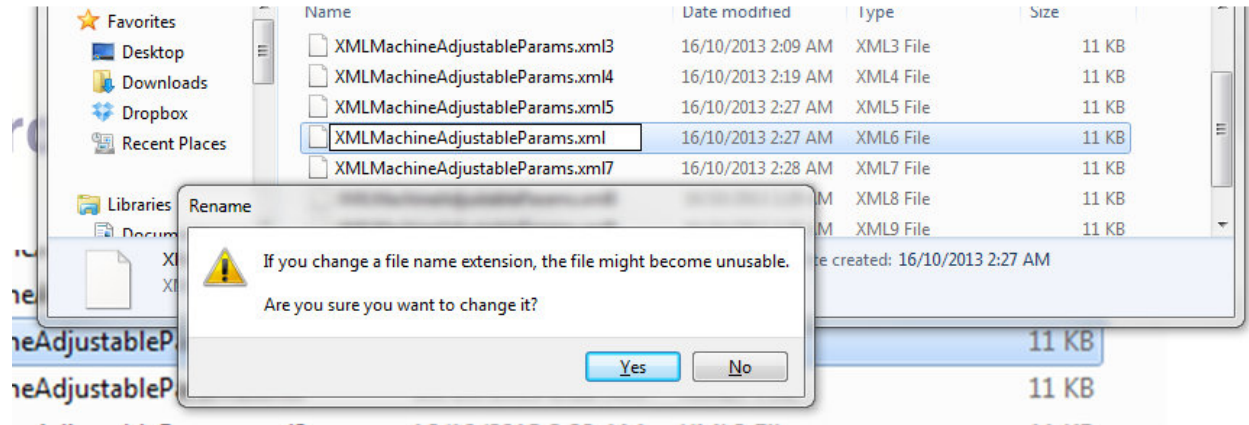

Each time you open and close the A2MC Setup GUI it will store another copy and number them as shown above. You can also see the date when it was stored so you can pick an appropriate XML personality file. The system will store them for several months with the most recent having the highest number. Generally you will want the most recent one.

Click on the one you want and simply and carefully remove the number as shown below. You will usually get a message as shown. You do want to change the extension to "xml" so click "Yes".

The look of the icon will change and it will usually pop to the top of the folder. The correct name must be exactly as shown highlighted below: **XMLMachineAdjustableParams.xml**.

You can click on it and take a look at the XML personality file. It is rather long but the first bit will look something like this:

```
<?xml version="1.0" encoding="UTF-8"?>
- <AXYZMachines xmlns:xsd="http://www.w3.org/2001/XMLSchema" xmlns:xsi="http://www.w3.org/2001/XMLSchema-instance">
  - <VersionParameters>
        <VersionXML>8.002</VersionXML>
    </VersionParameters>
  - <MotionParameters>
        <FeedRateMAX>1000</FeedRateMAX>
        <PlungeRateMAX>250</PlungeRateMAX>
        <TravelRateMAX>1000</TravelRateMAX>
        <TravelRate>699.99999999999989</TravelRate>
        <PlungeRate>150</PlungeRate>
        <FeedRate>699.99999999999989</FeedRate>
        <JogSpeedMode>0</JogSpeedMode>
        <SeekXYSpeed>200</SeekXYSpeed>
        <SeekZSpeed>50</SeekZSpeed>
        <JerkGrate>0.6981381421957259</JerkGrate>
        <AccelerationG>0.1453681836734694</AccelerationG>
```
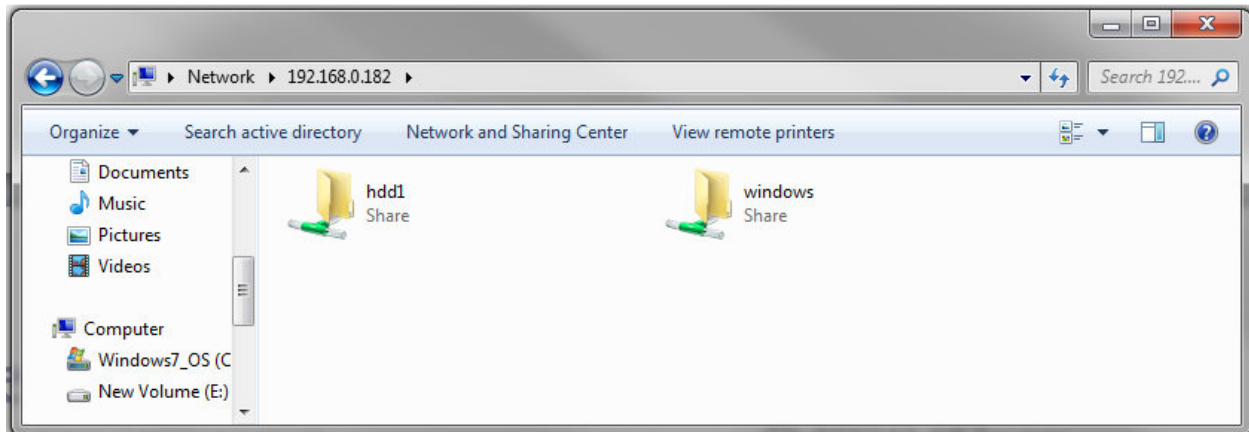
You have now recovered your XML personality file. Now you just have to install it on your machine…
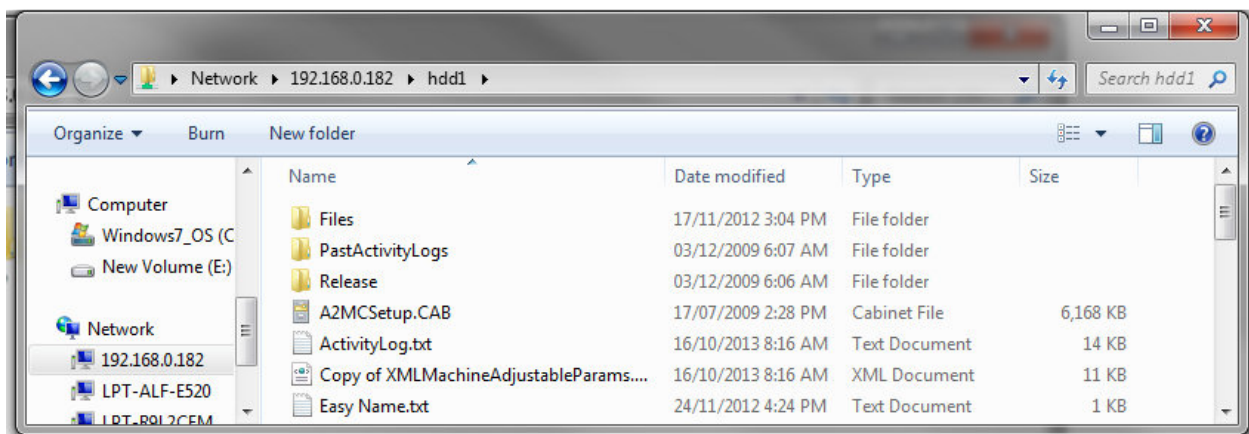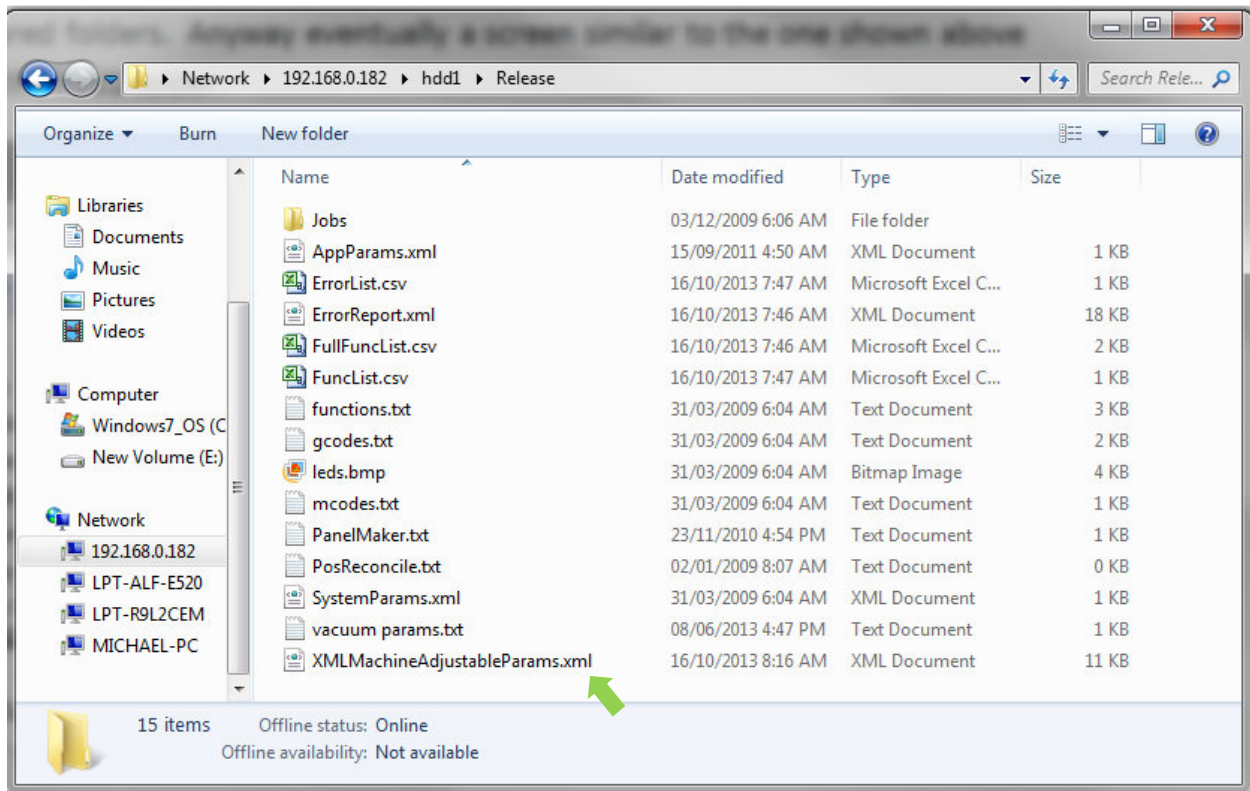
Installing the Recovered XML File

The first thing to do is to open up the machine's "Release Folder". To do this you have to know the machine's IP address. To find the IP address select function 1 on the controller and read it. It will be in the format "XXX.XXX.XXX.XXX". In this example the address is 192.168.0.182 and I can reach it by typing it into the address bar:
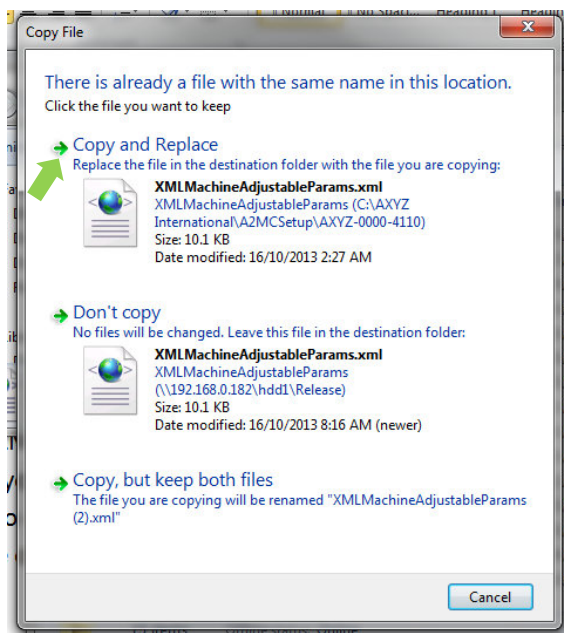

If you are using Windows 7 it might take a couple of minutes. Blame Windows, Windows 7 can be annoying when accessing shared folders. Anyway eventually a screen similar to the one shown above will appear. Double click on the hdd1 folder:

Again Windows 7 might be stubborn but eventually the contents of the hdd1 folder will appear. Finally double click on the "Release" folder:

There you will find the XMLMachineAdjustableParams.xml file. In this case it is right at the bottom. All machines will have one. If you install a new compact flash it will have a factory default one pre-installed.

What you need to do is simply copy the one from the recovery folder into the machine's release folder replacing the one that is there as shown on the left.

Select "copy and replace". The recovered XML file will now be installed on the machine.

Close up the machine's folders and then restart your machine. It will reboot with the recovered XML personality file and the machine should work exactly as it was working on the date you selected from the recovery folder.