AE018 - Status Codes and Recovery Procedures

ActiveEdge tools and macros provide operator feedback that both confirm when tool actions have completed successfully and also when a fault or process anomaly occurrs.

This document lists all Rigibore S codes, their meanings and remedial actions.

s100 - Compensation request queued OK

Source
All tool compensation macros and compensation status query macro 8506

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

Description
Is set when the compensation macro receives confirmation from the AEI that the command was queued successfully.

Indicates to status query macro 8506 that a compensation has completed successfully.

Recovery Procedure
Internal use only. No action required.

s101 - No compensation demanded

Source
All tool compensation macros.

Program Meaning
No compensation demanded.

Description
This status value is set when all compensation values are zero and the macro exits without queuing an adjustment. It causes the next compensation status query macro 8506 to similarly exit without checking the adjustment status of the same Tool ID.

Recovery Procedure
Internal use only. No action required.

s102 - AEI Busy

Source
Compensation status query macro 8506

Program Meaning
The AEI is continuing a process a previously queued tool compensation request.

Description
8506 queried the AEI, which was busy processing a command. The macro will exit when the status response changes.

Recovery Procedure
Internal use only. No action required.

s103 - Tool ID record not found

Source
Compensation status query macro 8506

Program Message
s103 TOOL ID RECORD NOT FOUND

Description
Macro 8506 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 to 8506 was the same as the Tool ID used by the preceding compensation macro.

s128 - Cartridge OK

Source
ActiveEdge tool

Program Meaning
Cartridge OK.

Description
The cartridge is operating normally.

Recovery Procedure
Internal use only. No action required.

s129 - Cartridge compensated OK

Source
ActiveEdge tool

Program Meaning
Cartridge compensated OK.

Description
The cartridge completed the compensation operation successfully.

Recovery Procedure
Internal use only. No action required.

s130 – Position too high

Source
ActiveEdge tool

Program Message
s404 UNUSEABLE AE TOOL

Description
The tool reported that the physical position of a cartridge is above its calibrated range. The cartridge may be damaged.

Recovery Procedure
Check the ActiveNet records for the tool and cartridge. If the unit has been cutting nominal size at above 90 percent of its physical adjustment range, it could indicate that the cartridge has been physically damaged.

Use ActiveNet to confirm that the tool memory contains the correct cartridge calibration data. The latest calibration library should be downloaded from:
https://rigibore.com/media/activeedge/CalibrationFiles/HandyCDF.dbf

Check that the cartridge is being used with an insert radius of the correct type – not with a larger radius than was specified when the tool was manufactured.

If this message persists, **make a note of this S code**, the Tool ID, cartridge serial number and email this information together with an ActiveNet CSV export to info@rigibore.com

s131 – Position too low

Source
ActiveEdge tool

Program Message
s404 UNUSEABLE AE TOOL

Description
The tool reported that the physical position of a cartridge is below its calibrated range. The cartridge may be damaged.

Recovery Procedure
Check the ActiveNet records for the tool and cartridge. If the unit has been cutting nominal size at below 10 percent of its physical adjustment range, it could indicate that the cartridge has been physically damaged.

Use ActiveNet to confirm that the tool memory contains the correct cartridge calibration data. The latest calibration library should be downloaded from:
https://rigibore.com/media/activeedge/CalibrationFiles/HandyCDF.dbf

Check that the cartridge is being used with an insert radius of the correct type – not with a smaller radius than was specified when the tool was manufactured.

If this message persists, **make a note of this S code**, the Tool ID, cartridge serial number and email this information together with an ActiveNet CSV export to info@rigibore.com

s132 – Target too low

Source
ActiveEdge tool

Program Message
s404 UNUSEABLE AE TOOL

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

Recovery Procedure
Check the last ActiveNet record for the tool and confirm that the correct compensation value was sent to the tool.

Use ActiveNet to confirm that the tool memory contains the correct cartridge calibration data. The latest calibration library should be downloaded from:
https://rigibore.com/media/activeedge/CalibrationFiles/HandyCDF.dbf

Check that the cartridge is being used with an insert radius of the correct type – not with a smaller radius than was specified when the tool was manufactured.

Remove the cartridge and carry out the maintenance procedures described in Rigibore document AE030.
https://rigibore.com/media/activeedge/AE030_AE_Tool_Maintenance.pdf

If this message persists, **make a note of this S code**, the Tool ID, cartridge serial number and email this information together with an ActiveNet CSV export to info@rigibore.com

s133 – Target too high

Source
ActiveEdge tool

Program Message
s404 UNUSEABLE AE TOOL

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 the last ActiveNet record for the tool and confirm that the correct compensation value was sent to the tool.

Use ActiveNet to confirm that the tool memory contains the correct cartridge calibration data. The latest calibration library should be downloaded from:
https://rigibore.com/media/activeedge/CalibrationFiles/HandyCDF.dbf

Check that the cartridge is being used with an insert radius of the correct type – not with a larger radius than was specified when the tool was manufactured.

Remove the cartridge and carry out the maintenance procedures described in Rigibore document AE030.
https://rigibore.com/media/activeedge/AE030_AE_Tool_Maintenance.pdf

If this message persists, **make a note of this S code**, the Tool ID, cartridge serial number and email this information together with an ActiveNet CSV export to info@rigibore.com

s134 – Cartridge not fitted

Source
ActiveEdge tool

Program Message
s404 UNUSEABLE AE TOOL

Description
The tool reported that the cartridge was missing.

Recovery Procedure
If the cartridge is fitted to the tool:

Use ActiveNet to carry out a toolcheck. If the status code repeats then remove the cartridge and carry out the maintenance procedures described in Rigibore document AE030.
https://rigibore.com/media/activeedge/AE030_AE_Tool_Maintenance.pdf

If this message persists, **make a note of this S code**, the Tool ID, cartridge serial number and email this information together with an ActiveNet CSV export to info@rigibore.com

s135 – Cartridge fault

Source
ActiveEdge tool

Program Message
s404 UNUSEABLE AE TOOL

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

Recovery Procedure
Use ActiveNet to carry out a toolcheck. If the status code repeats then remove the cartridge and carry out the maintenance procedures described in Rigibore document AE030.
https://rigibore.com/media/activeedge/AE030_AE_Tool_Maintenance.pdf

If this message persists, **make a note of this S code**, the Tool ID, cartridge serial number and email this information together with an ActiveNet CSV export to info@rigibore.com

s136 – Cartridge fault

Source
ActiveEdge tool

Program Message
s404 UNUSEABLE AE TOOL

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

Recovery Procedure
Use ActiveNet to carry out a toolcheck. If the status code repeats then remove the cartridge and carry out the maintenance procedures described in Rigibore document AE030.
https://rigibore.com/media/activeedge/AE030_AE_Tool_Maintenance.pdf

Use ActiveNet to carry out an adjustment of +100 microns on diameter, then an adjustment of -10 microns. If this status code message appears again, **do not carry out any further adjustments.** To do so may cause irreparable damage to the cartridge.

If this message persists, **make a note of this S code,** the Tool ID, cartridge serial number and email this information together with an ActiveNet CSV export to info@rigibore.com

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.

s138 – High drive current

Source
AE Tool

Program Meaning
The tool did not complete the compensation process.

Description
Tool compensation was interrupted part-way through the process because the average cartridge drive current limit was continuously exceeded for more than 30 seconds.

Recovery Procedure
The cause of the high current will need to be investigated. **Make a note of this S code**, the Tool ID and cartridge serial number and email this information together with an ActiveNet CSV export to info@rigibore.com. Request an RMA.

s139 – Unexpected change in cartridge position

Source
AE Tool

Program Meaning
The tool did not complete the compensation process.

Description
Tool compensation was interrupted part-way through the process because the cartridge position sensor recorded an abnormal change in position during an adjustment.

Recovery Procedure
Ensure that the tool is stationary during the adjustment process. Tool-changing the tool during an adjustment (or subjecting the tool to any form of sharp mechanical shock) could cause a brief spike in the cartridge position sensor output. This should be avoided if positional accuracy is to be maintained.

This status code can also be triggered if there is poor electrical contact between the cartridge and the tool. Carry out the 6 month maintenance procedure described in document **AE030**.

If this message persists, make a note of this S code, the Tool ID, cartridge serial number and email this information together with an ActiveNet CSV export to info@rigibore.com

s140 – Critical cartridge fault

Source
AE Tool

Program Meaning
The compensation process did not begin.

Description
The tool reported that there was a serious electrical short when a compensation was demanded. The maximum cartridge drive current was exceeded.

Recovery Procedure
This status code can be triggered if the cartridge zebra strip pocket has been contaminated with swarf. Carry out the 6 month maintenance procedure described in maintenance document **AE030**.

If this S code appears again after cleaning, the cause will need to be investigated. **Make a note of this S code**, the Tool ID and cartridge serial number and email this information together with an ActiveNet CSV export to info@rigibore.com. Request an RMA.

s201 – Low battery

Source
AE Tool

Program Meaning
Low battery power

Description
Cartridge compensation was interrupted part-way through the process due to low battery power. The amount of compensation completed is unknown. This status code occurs with an s137 cartridge error. On multi-cartridge tools, check which cartridge this code relates to.

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 power

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 standby mode. To check the battery level, 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 this S code,** the Tool ID, cartridge serial number and email this information together with an ActiveNet CSV export to info@rigibore.com

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 this S code,** the Tool ID, cartridge serial number and email this information together with an ActiveNet CSV export to info@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 this S code,** the Tool ID, cartridge serial number and email this information together with an ActiveNet CSV export to info@rigibore.com

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. If the status indicator light flashes within 20 seconds then the tool has not switched off.

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

If this message persists, **make a note of this S code,** the Tool ID, cartridge serial number and email this information together with an ActiveNet CSV export to info@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. If the status indicator light flashes within 20 seconds then the tool has not switched off.

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

If this message persists, **make a note of this S code,** the Tool ID, cartridge serial number and email this information together with an ActiveNet CSV export to info@rigibore.com

s214 – Calibration data upload error

Source
ActiveNet

Program Meaning
Calibration error

Description
The ActiveNet upload cartridge calibration data command failed at the start.

Recovery Procedure
Repeat the upload cartridge calibration data command after making sure that the target tool is within range of the Antenna.

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

If this message persists, **make a note of this S code**, the Tool ID, cartridge serial number and email this information together with an ActiveNet CSV export to info@rigibore.com

s215 – Calibration failed

Source
ActiveEdge tool

Program Meaning
ActiveNet reported that the tool was unable to write the cartridge calibration data to memory.

Description
The ActiveNet upload cartridge calibration data command failed part way through.

Recovery Procedure
Repeat the upload cartridge calibration data command after making sure that the target tool is within range of the Antenna.

It is essential that the tool is not used until this action has been successfully completed, as the tool calibration memory will contain incomplete data.

If this message persists, **make a note of this S code** the Tool ID, cartridge serial number and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s300 – Invalid Tool ID

Source
All tool compensation macros.

Program Message
s300 INVALID TOOL ID

Description
The Tool ID passed into a compensation macro was outside the valid range of 301 to 65535

Recovery Procedure
Check that the Tool ID passed into the macro was within the valid range.

s301 – Tool compensation request exceeds adjustment limit

Source
All tool compensation macros.

Program Message
s301 TOOL COMP REQUEST EXCEEDS ADJ. LIMIT

Description
A compensation value passed into the macro exceeds the physical compensation range of the cartridge. The compensation request was rejected.

Recovery Procedure
Check that all compensation values passed into the macro are within the valid range of -600 to +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
8508

Program Message
s302 UNIT 2 COMP EXCEEDS ADJUSTMENT LIMIT

Description
The compensation amount passed into the compensation macro 8508 for cartridge 2 will exceed the physical compensation range of the cartridge. The compensation request was not accepted.

Recovery Procedure
Check that the compensation value is within the valid adjustment range.

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
8506

Program Message
s303 CORRUPT RESPONSE FROM AEI

Description
Compensation status query macro 8506 received corrupt data from the AEI on three consecutive occasions.

Recovery Procedure
This indicates an electrical fault or possibly the machine has not been calibrated for use with the AEI.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

Re-calibrate the AEI by running Rigibore program 8500. Afterwards, copy the auto-generated timing file 8510 from the AEI system folder to the machine control. Contact Rigibore support before carrying out this procedure.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and Tool ID and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s305 – No response from AEI

Source
8506

Program Message
s305 NO RESPONSE FROM AEI

Description
Compensation status query macro 8506 did not receive a response from the AEI after three consecutive attempts.

Recovery Procedure
Ensure that the AEI is switched on and its indicator LED is showing solid green.

Use ActiveNet to check the tool status.

Run Rigibore test program 8501 with a valid Tool ID. The indicator LED should rapidly flash blue, followed by several longer green flashes.

Confirm that the AEI has been calibrated for use with the CNC control.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and Tool ID and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s306 – Corrupt response from AEI

Source
8506

Program Message
s306 CORRUPT RESPONSE FROM AEI

Description
Compensation status query macro 8506 received corrupt data from the AEI on three consecutive occasions.

Recovery Procedure
This indicates an electrical fault or possibly the machine has not been calibrated for use with the AEI.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

Re-calibrate the AEI by running Rigibore program 8500. Afterwards, copy the auto-generated timing file 8510 from the AEI system folder to the machine control. Contact Rigibore support before carrying out this procedure.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and Tool ID and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s307 – Unrecognised response from AEI

Source
8506

Program Message
s307 UNRECOGNISED RESPONSE FROM AEI

Description
Compensation status query macro 8506 received an unexpected response from the AEI on three consecutive occasions.

Recovery Procedure
This indicates that the AEI firmware version is more recent than the macros installed on the machine.

Use ActiveNet to confirm the latest firmware version of the AEI. **Make a note of this S code**, the AEI firmware version and serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export to info@rigibore.com

s308 – Corrupt response from AEI

Source
8506

Program Message
s308 CORRUPT RESPONSE FROM AEI

Description
Compensation status query macro 8506 received corrupt data from the AEI on three consecutive occasions.

Recovery Procedure
This indicates an electrical fault or possibly the machine has not been calibrated for use with the AEI.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

Re-calibrate the AEI by running Rigibore program 8500. Afterwards, copy the auto-generated timing file 8510 from the AEI system folder to the machine control. Contact Rigibore support before carrying out this procedure.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and Tool ID and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s309 – No response from AEI

Source
All tool compensation macros

Program Message
s309 NO RESPONSE FROM AEI

Description
A compensation macro did not receive a response from the AEI after three consecutive attempts.

Recovery Procedure
Ensure that the AEI is switched on and its indicator LED is showing solid green.

Use ActiveNet to check the tool status.

Run Rigibore test program 8501 with a valid Tool ID. The indicator LED should rapidly flash blue, followed by several longer green flashes.

Confirm that the AEI has been calibrated for use with the CNC control.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and Tool ID and email this information together with an ActiveNet CSV export to info@rigibore.com

s310 – Invalid Tool ID

Source
8506

Program Message
s300 INVALID TOOL ID

Description
The Tool ID passed into a compensation status macro was outside the valid range of 301 to 65535

Recovery Procedure
Check that the Tool ID passed into the macro was within the valid range.

s311 – Unexpected high detected on CNC input

Source
8506

Program Message
s311 UNEXPECTED HIGH DETECTED ON CNC INPUT

Description
The CNC input was detected as high for more than 2 seconds when macro 8506 attempted to query the AEI.

Recovery Procedure
Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure. Ensure that the orange wire has not been shorted to the 24VDC machine supply.

If this message persists, **make a note of this S code** and AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export to info@rigibore.com

s312 – Unable to queue compensation request

Source
All tool compensation macros

Program Message
s312 UNABLE TO QUEUE COMP. REQUEST

Description
The AEI was unable to queue a compensation request from a compensation macro. The request was not queued.

Recovery Procedure
Try compensating a different Tool ID on the same machine.

If this message persists, **make a note of this S code** and AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export to info@rigibore.com

s313 – Tool compensation refused

Source
All tool compensation macros

Program Message
s313 TOOL COMPENSATION REFUSED

Description
A compensation macro tried to queue a compensation request. The AEI would not accept the request after three attempts, because a compensation for the same Tool ID tool was already in progress.

Recovery Procedure
Investigate the manufacturing process to identify why a second compensation was triggered before the first one had completed.

Ensure that the date and time on the AEI is synchronised with the PC local time. Do this by selecting the appropriate AEI and performing a tool check.

If this message persists, **make a note of this S code** and AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export to info@rigibore.com

s314 – Unexpected high detected on CNC input

Source
All compensation macros

Program Messageunexpected
s314 UNEXPECTED HIGH DETECTED ON CNC INPUT

Description
The CNC input was detected as high for more than 2 seconds when a compensation macro attempted to queue an adjustment.

Recovery Procedure
Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure. Ensure that the orange wire has not been shorted to the 24VDC machine supply.

If this message persists, **make a note of this S code** and AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export to info@rigibore.com

s315 – Unrecognised response from AEI

Source
All Compensation macros

Program Message
s315 UNRECOGNISED RESPONSE FROM AEI

Description
A compensation macro received an unexpected response from the AEI on three consecutive occasions.

Recovery Procedure
This indicates that the AEI firmware version is more recent than the macros installed on the machine.

Use ActiveNet to confirm the latest firmware version of the AEI. **Make a note of this S code**, the AEI firmware version and serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export to info@rigibore.com

s316 – Corrupt response from AEI

Source
All compensation macros

Program Message
s316 CORRUPT RESPONSE FROM AEI

Description
A compensation macro received corrupt data from the AEI on three consecutive occasions.

Recovery Procedure
This indicates an electrical fault or possibly the machine has not been calibrated for use with the AEI.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

Re-calibrate the AEI by running Rigibore program 8500. Afterwards, copy the auto-generated timing file 8510 from the AEI system folder to the machine control. Contact Rigibore support before carrying out this procedure.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and Tool ID and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s317 – Corrupt response from AEI

Source
All compensation macros

Program Message
s317 CORRUPT RESPONSE FROM AEI

Description
A compensation macro received corrupt data from the AEI on three consecutive occasions.

Recovery Procedure
This indicates an electrical fault or possibly the machine has not been calibrated for use with the AEI.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

Re-calibrate the AEI by running Rigibore program 8500. Afterwards, copy the auto-generated timing file 8510 from the AEI system folder to the machine control. Contact Rigibore support before carrying out this procedure.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and Tool ID and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s318 – Corrupt response from AEI

Source
All compensation macros

Program Message
s318 CORRUPT RESPONSE FROM AEI

Description
A compensation macro received corrupt data from the AEI on three consecutive occasions.

Recovery Procedure
This indicates an electrical fault or possibly the machine has not been calibrated for use with the AEI.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

Re-calibrate the AEI by running Rigibore program 8500. Afterwards, copy the auto-generated timing file 8510 from the AEI system folder to the machine control. Contact Rigibore support before carrying out this procedure.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and Tool ID and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s319 – AEI internal error

Source
All compensation macros

Program Message
s319 AEI INTERNAL ERROR

Description
A compensation macro sent a compensation request but the AEI was unable to process the instruction. The compensation request was not queued.

Recovery Procedure
Reboot the AEI (AEI Management/Reboot) (or physically switch the AEI off and on again if this option does not work). Try running the compensation macro again after rebooting the AEI.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export to info@rigibore.com

s320 – Unexpected high detected on CNC input

Source
8521

Program Message
s320 UNEXPECTED HIGH DETECTED ON CNC INPUT

Description
The CNC input was detected as high for more than 2 seconds when the data capture macro attempted to record a value.

Recovery Procedure
Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure. Ensure that the orange wire has not been shorted to the 24VDC machine supply.

If this message persists, **make a note of this S code** and AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export to info@rigibore.com

s321 – AEI could not capture data

Source
8521

Program Message
s321 AEI COULD NOT CAPTURE DATA

Description
The AEI received valid data from the data capture macro 8521, but was unable to record the data.

Recovery Procedure
Reboot the AEI (AEI Management/Reboot) (or physically switch the AEI off and on again if this option does not work). Try running the compensation macro again after rebooting the AEI.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export to info@rigibore.com

s322 – No response from AEI

Source
8521

Program Message
s322 NO RESPONSE FROM AEI

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

Recovery Procedure
Ensure that the AEI is switched on and its indicator LED is showing solid green.

Run Rigibore test program 8501 with a valid Tool ID. The indicator LED should rapidly flash blue, followed by several longer green flashes.

Confirm that the AEI has been calibrated for use with the CNC control.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and Tool ID and email this information together with an ActiveNet CSV export to info@rigibore.com

s323 – Invalid user opcode

Source
8521

Program Message
s323 INVALID USER OPCODE

Description
The user opcode passed into data capture macro 8521 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 exceeds permitted range

Source
8521

Program Message
s324 DECIMAL VALUE EXCEEDS PERMITTED RANGE

Description
The value passed into data capture macro 8521 has exceeded the permitted size for a decimal value. The data was not recorded.

Recovery Procedure
Ensure that the size of decimal value passed into the macro is within the valid range of the machine variables.

s325 – Integer value exceeds permitted range

Source
8521

Program Message
s325 INTEGER VALUE EXCEEDS PERMITTED RANGE

Description
The value passed into data capture macro 8521 has exceeded the permitted size for an integer value. The data was not recorded.

Recovery Procedure
Ensure that the size of integer value passed into the macro is within the valid range of the machine variables.

s326 – Corrupt response from AEI

Source
8521

Program Message
s326 CORRUPT RESPONSE FROM AEI

Description
The data capture macro received a corrupt response from the AEI.

Recovery Procedure
This indicates an electrical fault or possibly the machine has not been calibrated for use with the AEI.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

Re-calibrate the AEI by running Rigibore program 8500. Afterwards, copy the auto-generated timing file 8510 from the AEI system folder to the machine control. Contact Rigibore support before carrying out this procedure.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s327 – Corrupt response from AEI

Source
8521

Program Message
s327 CORRUPT RESPONSE FROM AEI

Description
The data capture macro received a corrupt response from the AEI.

Recovery Procedure
This indicates an electrical fault or possibly the machine has not been calibrated for use with the AEI.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

Re-calibrate the AEI by running Rigibore program 8500. Afterwards, copy the auto-generated timing file 8510 from the AEI system folder to the machine control. Contact Rigibore support before carrying out this procedure.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s328 – Corrupt response from AEI

Source
8521

Program Message
s328 CORRUPT RESPONSE FROM AEI

Description
The data capture macro received a corrupt response from the AEI.

Recovery Procedure
This indicates an electrical fault or possibly the machine has not been calibrated for use with the AEI.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

Re-calibrate the AEI by running Rigibore program 8500. Afterwards, copy the auto-generated timing file 8510 from the AEI system folder to the machine control. Contact Rigibore support before carrying out this procedure.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s329 – Illogical bore parameters in 8503

Source
8503

Program Message
s329 ILLOGICAL BORE PARAMETERS IN 8503

Description
The parameters passed into the set compensation macro 8503 are not logical.

Recovery Procedure
Check that the chosen parameters make sense. Refer to Rigibore document AE040

s330 – Bore measurement out of specification

Source
8503

Program Message
s330 BORE MEASUREMENT OUT OF SPECIFCATION

Description
The bore measurement passed into the set compensation macro 8503 was outside the bore specification limits.

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

s331 – Illogical bore parameters in 8533

Source
8533

Program Message
s331 ILLOGICAL BORE PARAMETERS IN 8533

Description
The parameters passed into the set compensation macro 8533 are not logical.

Recovery Procedure
Check that the chosen parameters make sense. Refer to Rigibore document AE041

s332 – Bore measurement out of specification

Source
8533

Program Message
s332 BORE MEASUREMENT OUT OF SPECIFICATION

Description
The bore measurement passed into the set compensation macro 8533 was outside the bore specification limits.

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

s333 – Unexpected high detected on CNC input

Source
8523

Program Message
s333 UNEXPECTED HIGH DETECTED ON CNC INPUT

Description
The CNC input was detected as high for more than 2 seconds when AEI reboot macro 8523 attempted to query the AEI.

Recovery Procedure
Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure. Ensure that the orange wire has not been shorted to the 24VDC machine supply.

If this message persists, **make a note of this S code** and AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export to info@rigibore.com

s334 – AEI could not be rebooted remotely

Source
8523

Program Message
s334 AEI COULD NOT BE REBOOTED REMOTELY

Description
The AEI received a valid instruction from the AEI reboot macro 8523, but was unable to queue and carry out the command.

Recovery Procedure
The AEI must be rebooted manually before normal operation can continue.

If this message persists, **make a note of this S code** and AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s335 – No response from AEI

Source
8523

Program Message
s335 NO RESPONSE FROM AEI

Description
The AEI reboot macro 8523 did not receive a response from the AEI after three consecutive attempts.

Recovery Procedure
Ensure that the AEI is switched on and its indicator LED is showing solid green.

Run Rigibore test program 8501 with a valid Tool ID. The indicator LED should rapidly flash blue, followed by several longer green flashes.

Confirm that the AEI has been calibrated for use with the CNC control.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s336 – Corrupt response from AEI

Source
8523

Program Message
s336 CORRUPT RESPONSE FROM AEI

Description
The AEI reboot macro 8523 received a corrupt response from the AEI.

Recovery Procedure
This indicates an electrical fault or possibly the machine has not been calibrated for use with the AEI.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

Re-calibrate the AEI by running Rigibore program 8500. Afterwards, copy the auto-generated timing file 8510 from the AEI system folder to the machine control. Contact Rigibore support before carrying out this procedure.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s337 – Corrupt response from AEI

Source
8523

Program Message
s337 CORRUPT RESPONSE FROM AEI

Description
The AEI reboot macro 8523 received a corrupt response from the AEI.

Recovery Procedure
This indicates an electrical fault or possibly the machine has not been calibrated for use with the AEI.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

Re-calibrate the AEI by running Rigibore program 8500. Afterwards, copy the auto-generated timing file 8510 from the AEI system folder to the machine control. Contact Rigibore support before carrying out this procedure.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s338 – Corrupt response from AEI

Source
8523

Program Message
s338 CORRUPT RESPONSE FROM AEI

Description
AEI reboot macro 8523 received corrupt data from the AEI on three consecutive occasions.

Recovery Procedure
This indicates an electrical fault or possibly the machine has not been calibrated for use with the AEI.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

Re-calibrate the AEI by running Rigibore program 8500. Afterwards, copy the auto-generated timing file 8510 from the AEI system folder to the machine control. Contact Rigibore support before carrying out this procedure.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s340 – Invalid Tool ID

Source
8502

Program Message
s340 INVALID TOOL ID

Description
The Tool ID passed into tool shutdown macro 8502 was outside the valid range of 301 to 65535

Recovery Procedure
Check that the Tool ID passed into the macro was within the valid range.

s341 – Unexpected high detected on CNC input

Source
8502

Program Message
s341 UNEXPECTED HIGH DETECTED ON CNC INPUT

Description
The CNC input was detected as high for more than 2 seconds when macro 8502 attempted to shutdown the tool. The tool was not shut down.

Recovery Procedure
Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure. Ensure that the orange wire has not been shorted to the 24VDC machine supply.

If this message persists, **make a note of this S code** and AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export to info@rigibore.com

s342 – Tool shutdown could not be carried out

Source
8502

Program Message
s342 TOOL SHUTDOWN COULD NOT BE CARRIED OUT

Description
The AEI received the shutdown request from macro 8502, but was unable to internally queue the request. The tool was not shut down.

Recovery Procedure
Reboot the AEI (AEI Management/Reboot) (or physically switch the AEI off and on again if that option does not work). Try running the shutdown macro again after the AEI has rebooted.

If this message persists, **make a note of this S code** and AEI serial number (AEI0xxxx) and Tool ID and email this information together with an ActiveNet CSV export to info@rigibore.com

s343 – No response from AEI

Source
8502

Program Message
s343 NO RESPONSE FROM AEI

Description
Tool shutdown macro 8502 did not receive a response from the AEI after three consecutive attempts.

Recovery Procedure
Ensure that the AEI is switched on and its indicator LED is showing solid green.

Use ActiveNet to check the tool status.

Run Rigibore test program 8501 with a valid Tool ID. The indicator LED should rapidly flash blue, followed by several longer green flashes.

Confirm that the AEI has been calibrated for use with the CNC control.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and Tool ID and email this information together with an ActiveNet CSV export to info@rigibore.com

s344 – Corrupt response from AEI

Source
8502

Program Message
s344 CORRUPT RESPONSE FROM AEI

Description
Tool shutdown macro 8502 received a corrupt response from the AEI after three consecutive attempts.

Recovery Procedure
This indicates an electrical fault or possibly the machine has not been calibrated for use with the AEI.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

Re-calibrate the AEI by running Rigibore program 8500. Afterwards, copy the auto-generated timing file 8510 from the AEI system folder to the machine control. Contact Rigibore support before carrying out this procedure.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s345 – Corrupt response from AEI

Source
8502

Program Message
s345 CORRUPT RESPONSE FROM AEI

Description
Tool shutdown macro 8502 received a corrupt response from the AEI after three consecutive attempts.

Recovery Procedure
This indicates an electrical fault or possibly the machine has not been calibrated for use with the AEI.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

Re-calibrate the AEI by running Rigibore program 8500. Afterwards, copy the auto-generated timing file 8510 from the AEI system folder to the machine control. Contact Rigibore support before carrying out this procedure.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s346 – Corrupt response from AEI

Source
8502

Program Message
s346 CORRUPT RESPONSE FROM AEI

Description
Tool shutdown macro 8502 received a corrupt response from the AEI after three consecutive attempts.

Recovery Procedure
This indicates an electrical fault or possibly the machine has not been calibrated for use with the AEI.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

Re-calibrate the AEI by running Rigibore program 8500. Afterwards, copy the auto-generated timing file 8510 from the AEI system folder to the machine control. Contact Rigibore support before carrying out this procedure.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s347 – Invalid Tool ID

Source
8520

Program Message
s347 INVALID TOOL ID

Description
The Tool ID passed into toolcheck macro 8520 was outside the valid range of 301 to 65535

Recovery Procedure
Check that the Tool ID passed into the macro was within the valid range.

s348 – Unexpected high detected on CNC input

Source
8520

Program Message
s348 UNEXPECTED HIGH DETECTED ON CNC INPUT

Description
The CNC input was detected as high for more than 2 seconds when macro 8520 attempted to queue a toolcheck. The toolcheck was not queued.

Recovery Procedure
Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure. Ensure that the orange wire has not been shorted to the 24VDC machine supply.

If this message persists, **make a note of this S code** and AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export to info@rigibore.com

s349 – Tool shutdown could not be carried out

Source
8520

Program Message
s349 TOOL SHUTDOWN COULD NOT BE CARRIED OUT

Description
The AEI received the toolcheck request from macro 8520, but was unable to internally queue the request. The tool was not shut down.

Recovery Procedure
Reboot the AEI (AEI Management/Reboot) (or physically switch the AEI off and on again if that option does not work). Try running the shutdown macro again after the AEI has rebooted.

If this message persists, **make a note of this S code** and AEI serial number (AEI0xxxx) and Tool ID and email this information together with an ActiveNet CSV export to info@rigibore.com

s350 – No response from AEI

Source
8520

Program Message
s350 NO RESPONSE FROM AEI

Description
Toolcheck macro 8520 did not receive a response from the AEI after three consecutive attempts.

Recovery Procedure
Ensure that the AEI is switched on and its indicator LED is showing solid green.

Use ActiveNet to check the tool status.

Run Rigibore test program 8501 with a valid Tool ID. The indicator LED should rapidly flash blue, followed by several longer green flashes.

Confirm that the AEI has been calibrated for use with the CNC control.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and Tool ID and email this information together with an ActiveNet CSV export to info@rigibore.com

s351 – Corrupt response from AEI

Source
8520

Program Message
s351 CORRUPT RESPONSE FROM AEI

Description
Toolcheck macro 8520 did not receive a response from the AEI after three consecutive attempts.

Recovery Procedure
This indicates an electrical fault or possibly the machine has not been calibrated for use with the AEI.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

Re-calibrate the AEI by running Rigibore program 8500. Afterwards, copy the auto-generated timing file 8510 from the AEI system folder to the machine control. Contact Rigibore support before carrying out this procedure.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s352 – Corrupt response from AEI

Source
8520

Program Message
s352 CORRUPT RESPONSE FROM AEI

Description
Toolcheck macro 8520 did not receive a response from the AEI after three consecutive attempts.

Recovery Procedure
This indicates an electrical fault or possibly the machine has not been calibrated for use with the AEI.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

Re-calibrate the AEI by running Rigibore program 8500. Afterwards, copy the auto-generated timing file 8510 from the AEI system folder to the machine control. Contact Rigibore support before carrying out this procedure.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export and AEI logfile.txt to info@rigibore.com

s353 – Corrupt response from AEI

Source
8520

Program Message
s353 CORRUPT RESPONSE FROM AEI

Description
Toolcheck macro 8520 did not receive a response from the AEI after three consecutive attempts.

Recovery Procedure
This indicates an electrical fault or possibly the machine has not been calibrated for use with the AEI.

Check for an electrical fault by ensuring that the 5-wire cable between the AEI and the machine control is electrically secure, particularly the orange wire.

Re-calibrate the AEI by running Rigibore program 8500. Afterwards, copy the auto-generated timing file 8510 from the AEI system folder to the machine control. Contact Rigibore support before carrying out this procedure.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export to info@rigibore.com

s354 – Illogical spigot parameters in 8532

Source
8532

Program Message
s354 ILLOGICAL SPIGOT PARAMETERS IN 8532

Description
The parameters passed into the set compensation macro 8532 are not logical.

Recovery Procedure
Check that the chosen parameters make sense.

s355 – Spigot measurement out of specification

Source
8532

Program Message
s355 SPIGOT MEASUREMENT OUT OF SPECIFCATION

Description
The spigot measurement passed into the set compensation macro 8532 was outside the specification limits.

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

s400 – Tool not found

Source
8506

Program Message
s400 TOOL NOT FOUND

Description
Macro 8506 queried the AEI after a compensation macro had been run. The AEI reported that it could not get a response from the tool after several attempts.

Recovery Procedure
Ensure that the correct Tool ID number was used in 8506 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 this S code**, AEI serial number (AEI0xxxx) and Tool ID and email this information together with an ActiveNet CSV export to info@rigibore.com

s401 – Tool compensation failed

Source
8506

Program Message
s401 TOOL COMPENSATION FAILED

Description
Macro 8506 queried the AEI. The AEI responded that the tool did not acknowledge 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.

This status code indicates a poor radio connection between the AEI Antenna and the ActiveEdge tool. Consider the following options:

- Move tool closer to the Antenna.
- Permanently re-locate the Antenna so it is closer to where the tool is being adjusted.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and Tool ID and email this information together with an ActiveNet CSV export to info@rigibore.com

s402 – Tool compensation not confirmed

Source
8506

Program Message
s402 TOOL COMPENSATION NOT CONFIRMED

Description
Macro 8506 queried the AEI. The response was that the tool received and started to carry out the compensation command, but the AEI was unable to receive a final confirmation that the adjustment process completed successfully. It is likely that the tool was adjusted successfully.

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

This status code indicates a poor radio connection between the AEI Antenna and the ActiveEdge tool. Consider the following options:

- Move tool closer to the Antenna.
- Permanently re-locate the Antenna so it is closer to where the tool is being adjusted.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and Tool ID and email this information together with an ActiveNet CSV export to info@rigibore.com

S403 – AEI internal error

Source
8506

Program Message
S403 AEI INTERNAL ERROR

Description
Macro 8506 queried the AEI. The AEI was unable to access the compensation record for the requested Tool ID.

Recovery Procedure
Check ActiveNet.

Reboot the AEI (AEI Management/Reboot) (or physically switch the AEI off and on again if this option does not work).

Try running the compensation macro again after rebooting the AEI.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export to info@rigibore.com

s404 – Unusable ActiveEdge tool

Source
8506

Program Message
s404 UNUSABLE AE TOOL

Description
The macro 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 operator that the tool should not be used until the specific cause has been identified and remedied.

Recovery Procedure
Consult ActiveNet and review the last record for the Tool ID and identify the specific status code reported by the tool. Then refer to this document and carry out the appropriate remedial action.

s405 – Low AEI backup battery

Source
All tool compensation macros

Program Message
s405 LOW AEI BACKUP BATTERY

Description
The AEI has been switched on and it's internal date and time is not correct due to a low backup battery. A macro then tried to queue a command, but the AEI refused to accept the command because of this.

The ActiveEdge system depends on chronological accuracy, so the AEI time must be synchronised with the correct local time, as displayed on any PC running ActiveNet.

Recovery Procedure
No command macro will work until either battery is replaced or a toolcheck command is sent from ActiveNet to syncronise the AEI with the current time on the local PC.

If this message persists, **make a note of this S code**, AEI serial number (AEI0xxxx) and email this information together with an ActiveNet CSV export to info@rigibore.com