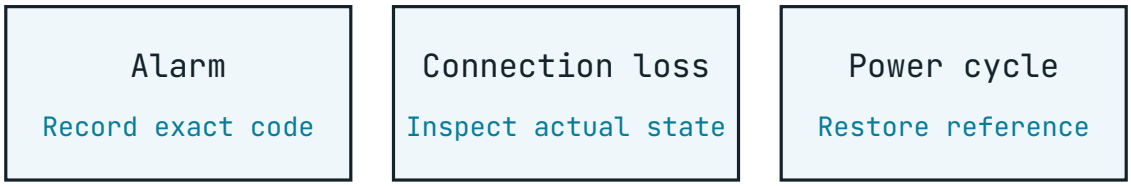
CONTROL REFERENCE

Recovering from alarms and connection loss

Use the reported state to organize recovery checks after an alarm or lost connection.

Review scope

Written review only. Keep **No Machine** selected and stay **disconnected**. No fault, firing or controller run is needed. Optional demo-projects have course machine links removed and retain only example design/settings.



Review scenarios, not a fault-creation exercise. The actual controller procedure determines recovery.

1. Use this reference without reproducing a fault. A lost connection and an alarm require different checks.

2. For an alarm, record the **exact code and message** before dismissing it. Consult your controller's own guide for the cause.

3. Fix the cause at the machine. **Unlock clears an alarm**; it does not repair the cause or establish a position reference.

4. For connection loss, Beam Bench no longer knows the controller's actual state. Do not assume the head has stopped. Use the machine's stop control when needed.

5. After reconnection or power cycling, startup zeros are not proof of a valid reference. Use the documented machine-specific reference procedure.

6. Before another run, inspect the work already done, stock, profile, mode, origin and planned output. Dismissing a message or saving the project does not restart or preserve the interrupted session.

SCENARIO REVIEW

Scenario review

Explain what you would check in each scenario below. Keep the machine disconnected and do not create an alarm, unplug a running controller or power cycle it for practice.

☐ Separate clearing a message from resolving a cause and restoring the reference.

☐ Consider completed engraving or cuts before any restart decision.

An alarm appears. What should you record, and what does Unlock do?

The connection disappears. Can you assume the head stopped?

The controller restarts at zero. Is its reference established?

Keep the comparison meaningful

Compare saved fields and explained reasoning. A file or software state cannot verify the physical machine.

EXPLAINED ANSWERS AND FILES

Explained answers and files

Alarm
Record the exact code/message; consult the controller guide. Unlock clears the alarm, not its cause or the position reference.

Lost connection
No. Inspect the actual machine state; the machine's own stop control remains relevant.

Startup zeros
No. Follow the documented reference procedure before evaluating a later run.

recovery-finished.lzrproj
Optional example under demo-projects; design/settings only.

recovery-practice.lzrproj
Optional example under demo-projects; design/settings only.

recovery-start.lzrproj
Optional example under demo-projects; design/settings only.

The reference cannot prove a machine is ready to restart. Optional demo-projects preserve design/settings only; they do not save an interrupted controller session.

Matches the demonstrated Beam Bench 0.2.37 controls and the corrected ending where applicable. Later panel layouts may differ.