Many machines will experience transmission errors if the FIFO buffers are set high on the COM port used to communicate with a machine. Errors can occur when uploading to the machine's memory, but more often manifest when drip feeding to a machine or when storing or retreiving Mazatrol programs. Mazaks transfering Mazatrol may appear to start transfering correctly but experience communication errors later (CMT mis-connect error). Lower or disable the FIFO buffer on the COM port in question. I personally prefer to set all COM port buffers as low as possible. If you only have a choice of turning them on or off, turn them off. Instructions that follow show how to set the buffers low for COM ports native to a PC or laptop. Most 3rd party hardware require a separate driver and may not have the option to modify this setting.

Windows 7
Go to 'Control Panel' > 'System'
Click 'Device Manager...'
Click 'Ports (COM & LPT)' Click the com-port in question, e.g. 'Communications Port (COM1)'
Click the tab 'Port Settings'
Click 'Advanced'
Set both the Receive Buffer and Transmit Buffer sliders to 'Low'

Windows 2000, XP
Go to 'Control Panel', execute 'System'
Click the 'Hardware' tab
Click 'Device Manager...'
Click 'Ports (COM & LPT)' Click the com-port in question, e.g. 'Communications Port (COM1)'
Click the tab 'Port Settings'
Click 'Advanced'
Set both the Receive Buffer and Transmit Buffer sliders to 'Low'

Windows NT 4
Go to 'Control panel', if 'ports' is available execute the link.
Choose the port in question
Press 'Settings'
Press 'Advanced'
Set both the Receive Buffer and Transmit Buffer sliders to 'Low'

Windows 95-98 (all versions)
Go to 'Control Panel', execute 'System'
Find the port under 'Serial ports'
Press 'Properties'
Press 'Advanced'
Set both the Receive Buffer and Transmit Buffer sliders to 'Low'

If you have questions contact Jody Romanowski at (630)885-2306.