Operating Instruction

emco COMPACT 5 PC

Edition 90-7
Ref. No. EN2 031
Foreword

This software for the Compact 5 PC was developed by specialists, who have been working on software development for industrial systems for many years.

With the COMPACT 5 PC software you have not only an efficient CAD/CAM software, but you can also work like at a normal CNC machine and set up standard (DIN 66025 and ISO 1056) NC programs (software description chapter 6, Editor).

You can learn to operate a computer-controlled machine tool in a very short time by reading the respective manuals yourself, even if you do not have any previous programming knowledge. You should work through this software description step by step and practise all examples listed directly on the PC.

If you have any CAD knowledge, you can start with the specimen examples in chapter 5 by means of the good user guidance on the screen and the operating sheets (the last three pages of this manual).

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TECHNICAL DOCUMENTATION
wishes you success
CONTENTS

A Description of machine 5

Accident prevention 5

Technical data machine 6

Technical data PC 7

Scope of supply 8

Setting-up 8

Connection of the machine 8

Description of the machine 9
- Main elements 9
- Key switch 9
- Emergency-off key 9
- Main spindle switch 9
- Adjusting the speed 10
- Main spindle speed display 11
- Travelling range of the slides 11
- Drive of slides 12
- Toolholder 13
- Tailstock 14
- Care of machine 14

Clamping devices for workpieces 15
- Summary 15
- 3-Jaw chuck ø 80 mm 16
- The collet chuck attachment 17
- The independent chuck 18
- The clamping plate ø 90 mm 18

Technological data 19
- Cutting speed 19
- Spindle speed 19
- Calculation of feed 19

Finding the cutting values 20
- Finding the spindle speed 20
- Finding the feed speed in mm/min 21

Service parts 23
B Software description

1. Vocabulary explanations

2 Software installation, access into program
2.1 Possible PC configuration
2.2 PC with a hard disk and 1 disk drive
installation, access

3. Explanations for the software
3.1 The differences in the input keyboards
3.2 Important key functions
3.3 Coordinate system
3.4 Screen cursor
3.5 Menu structure - menu summary
3.6 Screen display
3.7 Selection / deselection of the menu points

4. Menu points
4.1 Work piece
4.2 Draw
4.2.1 Cursor
4.2.2 Point
4.2.3 Line
4.2.4 Arc
4.2.5 Visible edges
4.2.6 Mirroring
4.2.7 Cleaning
4.2.8 Erasing the geometric element
4.2.9 Erasing all
4.2.10 Hotkeys - draw
Specimen example 1
Specimen example 2
Specimen example 3
4.3 Program
4.3.1 Moving in the rapid
4.3.2 Moving with feed speed
4.3.3 Cycles
Roughing cycle
Back pocket cycle
Follow contour cycle
Cut-in cycle
Threading cycle
4.3.4 Machining possibilities: CAD/CAM -
4.3.5 Edit Tool change
4.3.6 Erase the last movement
4.3.7 Erasing the machining program
4.3.8 Entering the feed values
4.3.9 Change feed unit
4.3.10 Entering the finishing offsets
4.4 Display
   4.4.1 Zoom all
   4.4.2 Zoom window
   4.4.3 Zoom work piece
   4.4.4 Removing, inserting the head stock
   4.4.5 Removing, inserting the work piece
   4.4.6 Removing, inserting the tool
   4.4.7 Removing, inserting the tool path
   4.4.8 Inserting, removing the tail stock
   4.4.9 Changing the simulation display
   4.4.10 Shift Geometry

4.5 Set up 0.0

4.6 Manual

4.7 Machine
   4.7.1 Automatic
   4.7.2 Single Step
   4.7.3 Fast run (Rapid)
   4.7.4 Empty cut step
   4.7.5 Repeating the program
   4.7.6 Moving the tool to the cursor
   4.7.7 Shifting the program
   4.7.8 Altering the scale program

4.8 Archive
   4.8.1 Storing the program
   4.8.2 loading the program
   4.8.3 Storing the geometry
   4.8.4 loading the geometry

4.9 Print

4.10 End

5. Specimen examples

6. Edit

7. Notes for the software compilation

Work sheets: Menu summary, hotkeys (for taking out)
A DESCRIPTION OF MACHINE

Accident Prevention - Safety Instructions

• Note: the feed power of the slides is 1000 Newton (100 kp). If program is not correct, the workpiece could be pressed out of the clamping device when it is not clamped and supported correctly. Therefore use tailstock center for supporting the workpiece.

• Read instruction manual before working with the machine.

• Electrical connection: The electrical connections must be carried out professionally. A grounding receptacle must be available.

• Do not alter guards! Close belt guard before starting the machine. Never open belt guard while machine is running. Don’t dismantle chip guard! Never work with dismantled cover of E-control!

• Keep children and visitors away! The machine should be stored so that children and visitors not acquainted with the use of the machine cannot start it.

• Always wear safety goggles! Be also aware that some materials (for example, brass) spray while being worked on. Therefore, it is important that all persons near the machine are protected.

• Wear proper apparel! Loose sleeves could get caught in chuck or workpiece.

• Keep work area clean! Cluttered areas and benches invite accidents.

• Remove adjusting keys and wrenches! Even when machine is not being used. The chuck keys should never be attached to the machine with chains or similar.

• Carry out measuring, adjusting, set-up, maintenance and resetting work only during standstill of the machine!

• Use chip hook for removing chips.

• Never touch running machine parts! Never try to stop workpiece or chuck with the hand.

• Do not surpass the clamping capacity of the lathe chuck and independent chuck! See maximum capacities.

• Be careful of extending chucks! Never reach over running (rotating) chucks.

• Switch machine off before servicing! Remove plug from socket.

• The cover of the E-control has to be removed by trained service people only.

• All electrical service and repair works (replacing fuses, boards etc.) have to be done by trained service people only.

• Use original spare parts, otherwise there is no title whatsoever to guarantee!
# Technical Data Machine

<table>
<thead>
<tr>
<th>Specification</th>
<th>Value</th>
<th>Note</th>
</tr>
</thead>
<tbody>
<tr>
<td>Center height</td>
<td>65 mm</td>
<td>(2.559&quot;)</td>
</tr>
<tr>
<td>Distance between centers</td>
<td>310 mm</td>
<td>(12.205&quot;)</td>
</tr>
<tr>
<td>Swing over bed</td>
<td>130 mm</td>
<td>(5.118&quot;)</td>
</tr>
<tr>
<td>Swing over cross slide</td>
<td>60 mm</td>
<td>(2.362&quot;)</td>
</tr>
<tr>
<td>Travel of cross slide</td>
<td>50 mm</td>
<td>(1.969&quot;)</td>
</tr>
<tr>
<td>Approx. net weight</td>
<td>55 kg</td>
<td>(121 lb)</td>
</tr>
</tbody>
</table>

**TAILSTOCK:**
- Center sleeve diameter: 22 mm (0.866")
- Tailstock taper: MK1 (MT1)
- Stroke of center sleeve: 35 mm (1.378")

**TOOLHOLDER:**
- Max. shaft height: 12.5 mm (0.492")

**HEADSTOCK:**
- Hole through work spindle: 16 mm (0.630")
- Spindle hole taper: MK2 (MT2)
- Speed range: 200 - 2400 rev./min
- Spindle nose according to manufacturer's standard

**FEED MOTORS:**
- Step motor: 5", 50 Ncm (0.37 ft.lbf)
- Rapid feed: 700 mm/min (27.559 in/min)
- Feed power: 350 mm/min (13.780 in/min)
- Feed power: approx. 1000 N (225 lbf)

**MAIN SPINDLE DRIVE:**
- Single-phase asynchronous motor
- Electric supply: 220 V AC / 50 Hz / 3.3 A
- Power (60% duty cycle): 800 W
- Speed: 2650 min⁻¹

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Technical modifications reserved!

Due to improvements and different modifications of the individual delivery countries, illustrations may diverge from the delivered machine.
Technical Data PC

Minimum configuration
IBM or compatible (PC/XT, PC/AT, PC/AT-386) with
- 1 hard disk 20 MB and
- 1 disk drive
- keyboard

Operating system MS-DOS from version 3.1
Main storage 640 kB RAM
Graphic card Hercules graphic card or
EGA- colour graphic card
Screen monochrome or colour display
Interface parallel interface

Recommended configuration
IBM compatible PC/AT with
- 640 kB RAM
- 1 disk drive 1.2 MB
- 1 hard disk 44 MB
- 1 EGA - graphic card
- EGA - graphicable colour screen
- keyboard
- operating system MS-DOS version 3.3
- parallel interface
- co-processor

Note:
The software is valid for all 100 % IBM compatible PC's. Upon request Messrs. EMCO will indicate to you all computers on which this EMCO software was tested.

Modifications reserved!
Scope of Supply

Base machine
Operating tools
- Double open-jawed spanner SW 13x17
- Open-jawed spanner SW 8
- Ring spanner SW 13
- Hexagon socket screw key SW 8,5,4,3

Accessory:
interface cable (2):
In addition a 25-pole interface cable is necessary for the operation of the machine to connect the machine to the PC. (Not included in the scope of supply!)

Dongle:
Is delivered with the EMCO-software. The dongle is a software-protection (protection against unauthorized operation). If the dongle wouldn't be connected, following restrictions have to be expected:
- no possibilities to store or load programs
- editor locked
- no possibilities to print screen hard-copies
- no data-exchange to the machine

Setting-Up

Place the machine to a stable table.
Recommended height approx. 650 mm (25°).

Connection of the Machine

Power supply
Plug in mains cable (1).
Electrical connections must be done professionally. A grounding receptacle must be available.

PC connection
Connect PC to the machine with the interface cable (2) via parallel interface (connection X7 at the rear side of the machine).
Description of the Machine

Key switch (1)
At position 1 of the key switch the machine is ready for operation (pilot lamp (2) lights up).
Main and feed motors are supplied with power.

Note:
To protect the machine against unauthorized starting, the key should always be taken off.

Emergency-off key with locking (3)
Upon actuation the power supply to main and feed motors is interrupted (pilot lamp (2) lights up).
Unlocking: Turn button in clockwise direction.

Main spindle switch (4)
The main spindle switch only remains in position 1 (main motor runs) if the key switch is in position 1, the emergency-off key is unlocked and if the gearbox cover is closed.

Note:
To avoid a too heavy warm-up of the stepping motors the machine should be switched off during a major standstill.
Adjusting the speed

Via the belt drive six different speeds can be adjusted on the main spindle:

<table>
<thead>
<tr>
<th>Speed (rpm)</th>
<th>Belt position</th>
</tr>
</thead>
<tbody>
<tr>
<td>200</td>
<td>BC1</td>
</tr>
<tr>
<td>330</td>
<td>BC2</td>
</tr>
<tr>
<td>550</td>
<td>BC3</td>
</tr>
<tr>
<td>950</td>
<td>AC1</td>
</tr>
<tr>
<td>1500</td>
<td>AC2</td>
</tr>
<tr>
<td>2400</td>
<td>AC3</td>
</tr>
</tbody>
</table>

Change of the V-belt
The V-belt from the motor pulley A to the transmission pulley B is always mounted.

Drive for range of revolutions, AC1/AC2/AC3
From motor pulley A to main spindle pulley C. The belt can be put on in 3 positions: AC1/AC2/AC3. The pulley B runs idle.

Drive for range of revolutions, BC1/BC2/BC3
Belt pulley B to belt pulley C (main spindle). The belt can be put on in 3 positions: BC1/BC2/BC3.

Procedure
Open gearbox cover using the socket head screw (5).
Loosen hexagon nut (6) at the rear side (motor side) of the gearbox.
Lift motor.
Put belt to desired pulley position.
Press motor downward and tighten hexagon nut.
Close gearbox cover.
Main spindle speed display

Perforated disc and light barrier on main spindle

1. Function for all turning operations except when screw-cutting
Via hole series 1 and light barrier 1 the main spindle speed is indicated at the screen.

2. Function when screw-cutting
Via hole series 1 and light barrier 1 the main spindle speed is indicated at the screen.
The impulse from light barrier 2 via slot 2 is needed as an additional information for the angle position of the main spindle (synchronization of the main spindle with the slide feed).

Travelling range of the slides

The sketch shows the travelling range of the slides in the menu MANUAL (see software description) and without mounted clamping device.

Note:
Mind that the travelling range of the slides changes with the clamping device used and the way of clamping (three-jaw chuck, tailstock).
Drive of slides

Step motors:

Technical data:

Single step 5°
Torque 0,50 Nm (0.37 ft.lbf)

As the name says, a revolution of the motor is divided into steps.

![Image of step motor]

Ball screws - Preloaded nuts

Longitudinal and cross slides are driven via ball screws. The screws run play-free in the nuts (no backlash).

Reduction step motor - feed screws

Smallest slide movement (for longitudinal and cross slides)

When the step motor turns by 5° (with the smallest step) the slide will move 0,0138 mm (.001°).

Traverse path indication on screen - slide movement

The traverse path will be indicated on the screen in 0,001 mm (.00004°).

<table>
<thead>
<tr>
<th>Steps (angle of step motors)</th>
<th>Traverse path (mm)</th>
<th>Traverse path (in)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Step (5°)</td>
<td>0.0138</td>
<td>.00054</td>
</tr>
<tr>
<td>2. Step (10°)</td>
<td>0.0277</td>
<td>.00109</td>
</tr>
<tr>
<td>3. Step (15°)</td>
<td>0.0416</td>
<td>.00164</td>
</tr>
<tr>
<td>4. Step (20°)</td>
<td>0.0555</td>
<td>.00219</td>
</tr>
<tr>
<td>5. Step (25°)</td>
<td>0.0694</td>
<td>.00273</td>
</tr>
<tr>
<td>6. Step (30°)</td>
<td>0.0833</td>
<td>.00328</td>
</tr>
<tr>
<td>7. Step (35°)</td>
<td>0.0972</td>
<td>.00383</td>
</tr>
<tr>
<td>8. Step (40°)</td>
<td>0.111</td>
<td>.00437</td>
</tr>
<tr>
<td>9. Step (45°)</td>
<td>0.125</td>
<td>.00492</td>
</tr>
</tbody>
</table>

Technical data:

- Traverse speed for longitudinal and cross slides:
  Rapid traverse speed
  700 mm/min (27.6 in/min) (PC/AAT, PC/386)
  350 mm/min (13.8 in/min) (PC/XT)

- Programmable feed rates 2-499 mm/min resp.
  0.002-0.499 mm/rev (0.08°-70 resp .00008 - .02 in/rev.)

- Smallest possible traverse path: 0.0138 mm (.001°)
- Traverse path longitudinal slide 300 mm (11.81"
- Traverse path cross slide 50 mm (1.969"

- Indication on screen in mm (in)
- Feed power on slides approx. 1000 N (225 lbf)

A revolution of the step motors is divided into 72 steps, i.e. one step = angle of 5°
(360° / 72 = 5°)

The limitation of the traverse paths (the Tack-Tack sound)

If you move the slides to the limit positions or against a stop, you will hear a tack-tack sound.

The step motor receives impulses for further movement, but cannot move any further. That means overload on spindles, nuts and guideways of the slides.

Remedy: Stop machine
The toolholder

The toolholder can be fixed in a front or back position on the cross slide.

Max. tool section: 12x12 mm (0.47" x 0.47")

Positions of toolholder

The toolholder can be clamped in front position and in back position.

Front position

Outside diameter Ø 0 bis Ø 90 mm (0.354")

Interior diameter Ø 14 bis Ø 100 mm (0.551" - 3.937")

Mounting

1. Put base (1) on toolholder support (2) and fasten with socket head screw (3).
2. Loosen T-sliding block (4) with hexagon screw (5) and thread in the toolholder from the top.
3. Unscrew cylinder screw (6), turn the milled nut (7) in and out respectively until the main cutting edge of the clamped cutter is exactly at centre height. Turn in socket head screw (6), thus the milled nut is protected against twisting.
Back position

Outside diameter Ø 25 to Ø 130 mm (0.984" - 5.118")

The tailstock

The tailstock serves to support the workpiece by using a center - as well as for drilling / centering.

Drilling operation

Drills up to Ø 8 mm (0.314") to be mounted in drill chuck. Drills of more than 8 mm need a MT1 so that they can be set directly into the tailstock barrel.

Feed via handwheel and tailstock sleeve.

Interior diameter Ø 40 to Ø 130 mm (1.575" - 5.118")

Tailstock accessories

- Plug-in pivot: for mounting clamping devices (e.g. chuck)
- Lathe centre

Clamp the toolholder in the front position for programming exercises.

Regular care of machine

Clean slideways and oil them with non-rusting slide oil. Main spindle bearing, recirculating ball screws are maintenance-free.
Clamping Devices for Workpieces (Summary)

**Collet chuck attachment**
Clamping capacity 1.5 - 14 mm in connection with collets type ESX 25.

Round workpieces can be clamped with highest round-run accuracy using the collets. Collets leave no clamping marks on the workpiece.

**4-jaw independent chuck 90 mm diameter**
With the 4-jaw independent chuck, workpieces can be clamped centrically and eccentrically. Each jaw can be individually adjusted and reversed.

**3-jaw chuck, 80 mm diameter**
The 3-jaw chuck serves for centrically clamping round, hexagon or twelve-sided workpieces.

**Clamping plate, 90 mm diameter**
For clamping large-dimensioned workpieces that cannot be clamped with the 3-jaw or 4-jaw independent chuck. The workpiece is clamped by using the clamping shoes.
3-Jaw chuck ø 80 mm

For centrically clamping of round, hexagon and 12-sided workpieces. Square workpieces cannot be clamped centrically with the 3-jaw chuck.

**Clamping capacity**

If the clamping capacity would be exceeded, a tooth-breaking on the clamping jaw is possible. Safety clamping is not guaranteed.

<table>
<thead>
<tr>
<th>mm</th>
<th>10</th>
<th>20</th>
<th>30</th>
<th>40</th>
<th>50</th>
<th>60</th>
<th>80</th>
<th>100</th>
</tr>
</thead>
<tbody>
<tr>
<td>inch</td>
<td>0.04&quot;</td>
<td>0.08&quot;</td>
<td>0.15&quot;</td>
<td>0.20&quot;</td>
<td>0.31&quot;</td>
<td>0.39&quot;</td>
<td>0.39&quot;</td>
<td>0.41&quot;</td>
</tr>
</tbody>
</table>

**Mounting**

Spindle nose and chuck bore must be dust-free. Mount the 3-jaw chuck onto the spindle nose with the 3 screws (M5x40, DIN 912).

Do not use longer screws - this would prevent the correct contact with the spindle nose.

Do not use shorter screws - the screws could break or tear out.

**Note:**

A set of chucks graded outwards and a set graded inwards are included in the delivery. The respective chuck number must be in accordance with the actual groove number.

**Safety tip**

Never exceed the maximum clamping capacity of the chuck.

This could cause the chuck teeth to break - the jaws and the workpiece would be thrown out and could cause severe injuries.

**Working tips - parting-off**

Clamp workpiece with as minimum overhang as possible, so that it is not bent by the pressure of the tool.

The parting-off tool must be clamped at exact center height and at a right angle to the turning axis.

**Supporting long workpieces**

Long workpieces bend through the pressure of the tool and must be supported by the tailstock center.

**Employment of the rolling center punch**

With spindle-speeds more than 550 rev./min the rolling center punch should be used.

**Soft jaws for the chuck**

The steps of the soft jaws must be turned by the user. When turning these steps, clamp a round workpiece to fix the jaws.

**Procedure:**

Clamp a round workpiece and turn the step.

**Safety tip:**

The overhang of the jaws may never be more than 12 mm (1/2"), otherwise the teeth might break. If the teeth break, the jaw could be thrown out and cause severe injuries.

The steps must be turned so deep that the workpiece is clamped securely.
The collet chuck attachment

Clamping capacity 1.5 - 14 mm (1/16" - 35/64") using the collets type ESX 25
Round workpiece can be clamped with highest round-run accuracy using the collets. Collets leave no clamping marks on the workpiece.

Mounting
Mount collet holder (1) onto the spindle nose with the 3 hexagon screws (2).

Clamping the workpiece
Insert collet, loosen clamping nut (3), insert workpiece and re-tighten clamping nut with the socket head key.
Tightening is done clockwise.

Mounting of the collet chucks:
- Insert collet chuck (4) laterally into the clamping nut (3) so that the eccentric ring (5) engages in the groove of the collet chuck.
- Screw collet chuck with clamping nut onto collet chuck holder (1).

Taking out of the collet chuck:
Untighten clamping nut.
Via the eccentric ring in the clamping nut the collet chuck is pressed out when screwing off the clamping nut.

Care/Service
Clean and oil collet holder before and after use - chips and dirt could damage the clamping taper and cone and influence the precision.

Clamping capacities

<table>
<thead>
<tr>
<th>Nominal diameter</th>
<th>Clamping area in mm</th>
<th>Clamping area in inch</th>
</tr>
</thead>
<tbody>
<tr>
<td>2.0</td>
<td>1.5 - 2.0</td>
<td>1/16 - 5/64</td>
</tr>
<tr>
<td>2.5</td>
<td>2.0 - 2.5</td>
<td>3/32</td>
</tr>
<tr>
<td>3.0</td>
<td>2.5 - 3.0</td>
<td>7/64</td>
</tr>
<tr>
<td>4.0</td>
<td>3.0 - 4.0</td>
<td>1/8 - 9/64 - 5/32</td>
</tr>
<tr>
<td>5.0</td>
<td>4.0 - 5.0</td>
<td>11/64 - 3/16</td>
</tr>
<tr>
<td>6.0</td>
<td>5.0 - 6.0</td>
<td>13/64 - 7/32 - 15/64</td>
</tr>
<tr>
<td>7.0</td>
<td>6.0 - 7.0</td>
<td>1/4 - 17/64</td>
</tr>
<tr>
<td>8.0</td>
<td>7.0 - 8.0</td>
<td>9/32 - 19/64 - 5/16</td>
</tr>
<tr>
<td>9.0</td>
<td>8.0 - 9.0</td>
<td>21/64 - 11/32</td>
</tr>
<tr>
<td>10.0</td>
<td>9.0 - 10.0</td>
<td>23/64 - 3/8 - 25/64</td>
</tr>
<tr>
<td>11.0</td>
<td>10.0 - 11.0</td>
<td>13/32 - 27/64</td>
</tr>
<tr>
<td>12.0</td>
<td>11.0 - 12.0</td>
<td>7/16 - 29/64 - 15/32</td>
</tr>
<tr>
<td>13.0</td>
<td>12.0 - 13.0</td>
<td>31/64 - 1/2</td>
</tr>
<tr>
<td>14.0</td>
<td>13.0 - 14.0</td>
<td>33/64 - 17/32 - 35/64</td>
</tr>
</tbody>
</table>
The independent chuck

For clamping round, square, rectangular and uneven shaped workpieces. Each jaw can be adjusted individually. Workpieces can be clamped centrically and eccentrically.

Mounting
Mount the independent chuck to the spindle nose with the 4 screws (M5x25, DIN 912)

Clamping capacities

<table>
<thead>
<tr>
<th>mm</th>
<th>1</th>
<th>2</th>
<th>3</th>
<th>4</th>
<th>5</th>
<th>6</th>
<th>7</th>
<th>8</th>
<th>9</th>
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</thead>
<tbody>
<tr>
<td>mm</td>
<td>1</td>
<td>2</td>
<td>3</td>
<td>4</td>
<td>5</td>
<td>6</td>
<td>7</td>
<td>8</td>
<td>9</td>
<td>10</td>
</tr>
<tr>
<td>inch</td>
<td>0.04&quot;</td>
<td>0.08&quot;</td>
<td>0.16&quot;</td>
<td>0.32&quot;</td>
<td>0.43&quot;</td>
<td>0.55&quot;</td>
<td>0.67&quot;</td>
<td>0.89&quot;</td>
<td>1.10&quot;</td>
<td>1.38&quot;</td>
</tr>
</tbody>
</table>

The clamping plate 90 mm diameter

Clamping capacity using the small T-nut screws: up to 13 mm (1/2").

Clamping capacity using the big T-nut screws: up to 33 mm (1/3").

Often uneven or irregular shaped workpieces cannot be clamped with the 3-jaw chuck or the 4-jaw independent chuck.

Using the T-nut screws and the clamping shoes, uneven or large-dimensioned workpieces can be clamped. The rings turned into the clamping plate serve as an aid for centrical clamping.

Mounting
Mount the clamping plate onto the spindle nose with the 4 socket head screws M5x20.

Safety tip:
Uneven workpieces often cause unbalanced round-run. Therefore always work with low spindle speeds. Be careful of extending parts.
Technological Data

1. Cutting speed ($V_s$)

\[ V_s \text{ (m/min)} = \frac{d \text{ (mm)} \times \pi \times S \text{ (rev./min)}}{1000} \]

$V_s$ = Cutting speed  
$d$ = Dia. of workpiece  
$S$ = Speed of main spindle

The max. acceptable cutting speed depends on:

- **Material of workpiece**
  The higher the strength of the material, the lower the cutting speed.

- **Material of tool**
  Carbide tools allow for a higher cutting speed than HSS tools.

- **Feed**
  The larger the feed the lower the cutting speed.

- **Depth of cut**
  The larger the depth of cut the smaller the cutting speed.

Cutting speed for programming exercises on the COMPACT 5 PC

Workpiece material: automatic aluminium  
Tool: carbide tips  
Cutting speed for turning: 150-200 m/min  
Cutting speed for parting off: 60-80 m/min  
Feed size for turning: 0,02 - 0,1 mm/rev.  
Feed size for parting off: 0,01 - 0,02 mm/rev.

2. Spindle speed ($S$)

The cutting speed and the workpiece dia. enable you to calculate the speed of the main spindle.

\[ S \text{ (rev./min)} = \frac{V_s \text{ (mm/min)} \times 1000}{d \text{ (mm)} \times \pi} \]
Finding the Cutting Values

1. Finding the spindle speed (r.p.m)

You know
- Diameter of workpiece
- Suggested cutting speed

From the chart you can select the spindle speed in rpm.

Example:
Diameter of workpiece: 40 mm
Cutting speed: 150 m/min
Therefore: 1200 rpm
2. Finding the feed speed in mm/min

You know
- Diameter of workpiece
- Feed size in rpm

From the chart you select the feed in mm/min

Example:
Spindle speed: 1200 rpm
Feed: 0.06 mm/rev
Results in feed speed: 70 mm/min
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<th>Ref. No.</th>
<th>DIN</th>
<th>Benennung</th>
<th>Description</th>
<th>Designation</th>
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29
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|      |          |           | Deckel              | Cap                  | Couvercle            |
|      |          |           | Zylinderschraube    | Socket Head Screw    | Vis 6 pans creux     |
|      |          |           | Drehteil            | Pinion               | Pignon               |
|      |          |           | Zahnkranz           | Scroll               | Couronne             |
|      |          |           | Frontplatte         | Front Plate          | Feuille frontal      |
|      |          |           | Sicherungsschraube  | Retaining Screw      | Vis de retoune       |
|      |          |           | Satz Außenhaken     | Outside Stepped jaws | Jeu de mors extérieurs |
|      |          |           | Satz Innenhaken     | Inside Stepped jaws  | Jeu de mors intérieur |
|      |          |           | Schlüsselteil       | Key                  | Cle                  |
|      |          |           | Knopf               | Toggle               | Garret               |</p>
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<td>Spannmeisen</td>
<td>Clamping jaw</td>
<td>Vis de serrage</td>
</tr>
<tr>
<td>5</td>
<td>ZSR 33 0640</td>
<td></td>
<td>Sechskantschraube</td>
<td>Hexagon head screw</td>
<td>Vis hexagonale</td>
</tr>
<tr>
<td>6</td>
<td>ZSR 12 0520</td>
<td></td>
<td>Sechskantschraube</td>
<td>Hexagon head screw</td>
<td>Vis hexagonale</td>
</tr>
<tr>
<td>7</td>
<td>ZSR 25 0560</td>
<td></td>
<td>Zylinderschraube</td>
<td>Socket head screw</td>
<td>Vis a pans creux</td>
</tr>
<tr>
<td>8</td>
<td>46.4 DIN 125</td>
<td></td>
<td>Schraube</td>
<td>Washer</td>
<td>Rondele</td>
</tr>
<tr>
<td>9</td>
<td>ZSR 25 0060</td>
<td></td>
<td>Sechskantschraube</td>
<td></td>
<td></td>
</tr>
<tr>
<td>10</td>
<td>76 DIN 934-6</td>
<td></td>
<td>Schraube</td>
<td>Hexagon nut</td>
<td>Ecrou 6 pans</td>
</tr>
<tr>
<td>Pos.</td>
<td>Ref. No.</td>
<td>DIN</td>
<td>BENENNUNG</td>
<td>DESCRIPTION</td>
<td>DESIGNATION</td>
</tr>
<tr>
<td>------</td>
<td>----------</td>
<td>-----------</td>
<td>-----------------</td>
<td>-------------------------</td>
<td>-------------------------</td>
</tr>
<tr>
<td>1</td>
<td>ASZ 420</td>
<td>200 420</td>
<td>Planscheibe</td>
<td>Independend chuck</td>
<td>Plateau americain</td>
</tr>
<tr>
<td>2</td>
<td>ASZ 420</td>
<td>420 010</td>
<td>Gehäuse</td>
<td>Housing</td>
<td>Corps</td>
</tr>
<tr>
<td>3</td>
<td>A2Z 420</td>
<td>420 020</td>
<td>Satz von 4 Umkehrbacken</td>
<td>Set of 4 reversible jaws</td>
<td>Jeu de 4 mors reversible</td>
</tr>
<tr>
<td>4</td>
<td>A2Z 420</td>
<td>420 040</td>
<td>Spann schraube</td>
<td>Spindle</td>
<td>Broche</td>
</tr>
<tr>
<td>5</td>
<td>ZST 75</td>
<td>75 0460</td>
<td>Schlüssel</td>
<td>Key</td>
<td>Cle</td>
</tr>
<tr>
<td>6</td>
<td>ZSR 12</td>
<td>12 0525</td>
<td>-Knobel</td>
<td>Toggle</td>
<td>Garrot</td>
</tr>
<tr>
<td></td>
<td></td>
<td>M5x25DIN91246.9</td>
<td>Zylinder schraube</td>
<td>Socket head screw</td>
<td>Vis 6 pans creux</td>
</tr>
<tr>
<td>Pos.</td>
<td>Ref. No.</td>
<td>DIN</td>
<td>Benennung</td>
<td>Description</td>
<td>Designation</td>
</tr>
<tr>
<td>------</td>
<td>----------</td>
<td>-----</td>
<td>-----------</td>
<td>-------------</td>
<td>-------------</td>
</tr>
<tr>
<td>1</td>
<td>AEZ 011 000</td>
<td></td>
<td>Gruppe Plotter</td>
<td>Table</td>
<td>Ens. Plotter</td>
</tr>
<tr>
<td>2</td>
<td>AEZ 010 031</td>
<td></td>
<td>Auflage</td>
<td>Bar</td>
<td>Tableau</td>
</tr>
<tr>
<td>3</td>
<td>AEZ 010 050</td>
<td></td>
<td>Halter</td>
<td>Holder</td>
<td>Support</td>
</tr>
<tr>
<td>4</td>
<td>AEZ 010 060</td>
<td></td>
<td>Führung</td>
<td>Gib</td>
<td>Guidage</td>
</tr>
<tr>
<td>5</td>
<td>ZST 51 004</td>
<td>M4x4 DIN 551-5.8</td>
<td>Leiste</td>
<td>Set screw</td>
<td>Lardon</td>
</tr>
<tr>
<td>6</td>
<td>ZNA 76 0142</td>
<td>1.4x2.5 DIN1476-4.6</td>
<td>Gewindestift</td>
<td>Grooved drive stud</td>
<td>Vis pointeau</td>
</tr>
<tr>
<td>7</td>
<td>ZRG 71 1410</td>
<td>W14x1 DIN 471</td>
<td>Kerbbohrer</td>
<td>Retaining ring</td>
<td>Cleu cannelé</td>
</tr>
<tr>
<td>8</td>
<td>ZSR 64 0515</td>
<td>M5x15</td>
<td>Sicherungsring</td>
<td>Knurled screw</td>
<td>Anneau de retenue</td>
</tr>
<tr>
<td>9</td>
<td>AEZ 010 040</td>
<td></td>
<td>Rändelschraube</td>
<td>Axis</td>
<td>Vis moletée</td>
</tr>
<tr>
<td>10</td>
<td>ZRD 66 7070</td>
<td>70 x 70</td>
<td>Achse</td>
<td>Paper roll</td>
<td>Axe</td>
</tr>
<tr>
<td>11</td>
<td>ZSR 12 0525</td>
<td></td>
<td>Papierrolle</td>
<td>Socket head screw</td>
<td>Rouleau à papier</td>
</tr>
<tr>
<td>12</td>
<td>ZSR 12 0812</td>
<td>MBx12 DIN 912-6.9</td>
<td>Zylinderschraube</td>
<td>Socket head screw</td>
<td>Vis 6 pans creux</td>
</tr>
<tr>
<td>13</td>
<td>ZST 99 1000</td>
<td></td>
<td>Zylinderschraube</td>
<td>Plotterstift</td>
<td>Vis 6 pans creux</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>Plotterstift</td>
<td>Plotter pen</td>
<td>Crayon Plotter</td>
</tr>
</tbody>
</table>
B SOFTWARE DESCRIPTION

1. VOCABULARY EXPLANATIONS

bit (b) .......... Binary sign = smallest memory unit of the computer (e.g., current - not current or magnetic - not magnetic)

Byte (B) .......... Memory unit to store a letter, a number or a sign (1 byte = 8 bit)

Kilobyte (K, kB): usual unit (measurement) for the memory capacity of a computer (1 kilobyte = 2^10 bytes = 1024 bytes)

Megabyte (MB): 1 megabyte = 1024 kilobytes

CAD .......... Computer Aided Design = tool construction (see chapter 4.2)

CAM .......... Computer Aided Manufacturing = determining the machining cycle (see chapter 4.3)

CNC .......... Computer Numerical Control

Coproces sor .......... Additional arithmetic unit as a support for the microprocessor

Disk .......... Exchangable, magnetic plastic disk, to store software (memory capacity, e.g., 5½ inches disk with 360 + kB or 1.2 MB or 3½ inches disk with 720 kB or 1.44 MB)

Hard disk .......... Magnetized disks permanently located in the computer, to store software (memory capacity for PC, e.g., up to 80 MB)

Graphics card .......... Shapes the computer signals for the screen

Hardware .......... Are all usable objects

Compatibility .......... Two devices are compatible, if they can operate with each other without any additional equipment or can be exchanged for each other

Menu .......... List of the possibilities offered

Microprocessor .......... Central arithmetic unit of the PC

NC program .......... List of all information, which a machine tool needs to manufacture a work piece

PC .......... Personal Computer = multi-purpose, small computer for one person

Postprocessor .......... Converts a program into information, which the CNC machine tool understands and receives

RAM .......... Random Access Memory = operational memory = component, which loses information, when the device is switched off (memory capacity of the RAM usually amounts to 640 + kB for PC)

Interface .......... Connection element for connecting external devices to the PC

Serial interface: processes 1 bit
Parallel interface: processes 1 byte (= 10-fold information flow speed)

Software .......... The software is a thought-defined product (e.g., a program on a disk), which controls the computer.

System software: basic, administrative program; contains the operating system (e.g., DOS = Disk Operating System) and facilitates the running of the application software

Application software: special operational program (e.g., Unimat PC software). The hardware can carry out the tasks given by this program.
2. SOFTWARE INSTALLATION, ACCESS INTO PROGRAM

2.1 Possible PC configuration

In order to operate with this EMCO software, you require a PC with the following capabilities:

- IBM compatible (PC, PC/XT, PC/AT, PC/AT-386)
- Operating system MS-DOS from version 3.1
- 640 kB RAM (main memory)
- 1 Hercules graphics card with a parallel interface (Centronics) or 1+E GA colour graphics card
- Monochrome screen or EGA colour screen capable of graphics
- 2 disk drives or 1 disk drive + 1 hard disk with 20 MB
- 1 parallel interface for the use of an EGA colour graphics card (for the connection of a printer = option)

An arithmetic coprocessor is not absolutely necessary for the operation with this EMCO software.

This coprocessor is, above all, recommended for PCs with a slow processing speed (e.g., PC/XT with a cycle frequency of 4.77 or 8 MHz), however, since it executes the arithmetic operations much faster.

The use of a coprocessor is not required for PCs with a cycle frequency of over 10 MHz (PC/AT)

Example:

IBM compatible PC/AT with
- 640 kB RAM
- 1 disk drive 1.2 MB
- 1 hard disk 44 MB
- 1 EGA graphics card
- EGA screen capable of graphics
- keyboard
- operating system MS-DOS version 3.3
- 1 parallel interface

Compatibility problems

The software runs on all 100% IBM compatible PCs. Upon request, EMCO informs you of all those processors, on which this EMCO software was tested.

2.2 PC with hard disk and 1 disk drive

Installation

Start DOS (Disk Operating System). If necessary, consult the DOS manual, which was supplied with your computer.

The files INT10.COM and HGC.COM or HGC.EXE must be available on your hard disk (in the main index) and be called up when using a Hercules graphics card in order to initialize this card.

These files may not be supplied by us due to copyright laws.

If you install this EMCO software on a PC with a Hercules graphics card, the recall of these files is automatically written into the file AUTOEXEC.BAT during the installation of the software.

When the DOS prompt "C: \ >" appears, insert the installation disk 1 into the drive A.

Enter the following command:

<table>
<thead>
<tr>
<th>Screen display</th>
<th>Entry</th>
<th>Explanation</th>
</tr>
</thead>
<tbody>
<tr>
<td>C: \ &gt;</td>
<td>A</td>
<td>Change to drive A</td>
</tr>
<tr>
<td>A: \ &gt;</td>
<td>1</td>
<td>Call up installation program</td>
</tr>
</tbody>
</table>

After entering the command "1" and pressing the ENTER key, the registration screen for setting the language appears.
Setting the language
Move the light beam with the arrow keys to the desired language and confirm it with .

Entering the program path (sub-directory)
This EMCO software is installed in the sub-directory COMPACT by pressing .

Choose printer
Choose the right printer of your work station.
If you don’t use a printer, just press .

Altering the program path:
You can also install this EMCO software in a sub-directory determined by you.

Procedure:
- You can delete the suggested sub-directory name letter by letter with the key .
- Enter a new sub-directory name.

Example:
C:\training\ .

Attention:
Do not forget after entering the sub-directory name.
Control menu:

**EMCO**
COMPACT 5-PC INSTALLATION 1.0

CONFIGURE IBM GRAPHIC
UNIT METRIC
PATH C:\COMPACT\n
Are specifications correct?
YES NO

The previous specifications are displayed:
YES... The previous specifications are **correct**, the software is installed.
NO.... The previous specifications are **incorrect**, the installation begins again with "Entering the type of PC".

Select the desired menu point with the arrow keys and confirm it.

If the menu point **YES** was selected and confirmed, the following appears on the screen:

**EMCO**
COMPACT 5-PC INSTALLATION 1.0

The COMPACT 5 PC SOFTWARE is compiled and copied into the given path...
Please wait!

Copying...

C:\COMPACT\n
The individual files are copied from the drive into the sub-directory determined by you.

The following message appears after a short time:

Disk 2 in drive A: insert

Remove the installation disk 1 from the drive A and insert the installation disk 2 and confirm it.

The following appears:

**EMCO**
**Installation is finished**

The PC registers with drive A.

Changing the drive:

<table>
<thead>
<tr>
<th>Screen display</th>
<th>Entry</th>
</tr>
</thead>
<tbody>
<tr>
<td>A: &gt;</td>
<td>C: :</td>
</tr>
<tr>
<td>C: &gt;</td>
<td></td>
</tr>
</tbody>
</table>

The software can be called up (see next page).
Access

After the DOS prompt "C: \ >" appears, enter the following commands:

<table>
<thead>
<tr>
<th>Screen display</th>
<th>Entry</th>
</tr>
</thead>
<tbody>
<tr>
<td>C: \ &gt;</td>
<td></td>
</tr>
<tr>
<td>C: \COMPACT &gt;</td>
<td></td>
</tr>
</tbody>
</table>

* Space bar

In this way, you change to the sub-directory COMPACT.

Calling up the program:

If you have altered the program path (= sub-directory) during the installation of the software, you must enter your selected sub-directory name (here COMPACT).

<table>
<thead>
<tr>
<th>Screen display</th>
<th>Entry</th>
</tr>
</thead>
<tbody>
<tr>
<td>C: \COMPACT &gt;</td>
<td>COMPACT</td>
</tr>
</tbody>
</table>

The title screen appears:

![Title screen image]

Pressing ENTER:

![Pressing enter image]

You are now in the program.
3. EXPLANATIONS FOR THE SOFTWARE

3.1 The differences in the input keyboards

- **Small PC keyboard**

- **Large PC keyboard**

The same key functions are arranged and designated differently on these two types of keyboard.
3.2 Important key functions

SHIFT key
If the SHIFT key is pressed at the same time as the desired key, the upper case of the respective key is selected.

Example
- If the SHIFT key is not active, the lower case (+) is selected.
- If the SHIFT key is pressed, the upper case (*) is selected.

Note
Only the selected key case is shown in these instructions for easier reading.

Preceding zeros
Following zeros
Zeros before a number and after the comma can but do not need to be entered.

Plus/minus sign
Plus signs (+) are not entered. The minus sign (-) must be entered before the number.

Entering large, small letters
Letters can be entered as large or small letters.

Enter key
Inputs are confirmed or stored with the "ENTER" key.

Decimal point
The decimal point is entered with this key.

Separating two entries
Two subsequent entries are separated with the comma key.

Example
For a work piece compilation, the PC requests:
Diameter, work piece length?

Input: 23.5, 46

Error correction
The entry can be corrected with this key. The previously entered character is deleted.

Interrupting selected commands
The selected command is interrupted with this key.
The previously selected menu level can also be returned to with the Esc. key.
3.3 Coordinate system

The piece of information "Move the longitudinal slide towards the head stock" is a long piece of information; it would also be different in every language. Thus, the directions of movement for NC machines are described in a coordinate system.

**Coordinate system of the machine**

- **Z axis** = Axis parallel to the rotary axis
- **X axis** = Axis perpendicular to the rotary axis
- **-Z movement** = Movement of the longitudinal slide towards the head stock
- **+Z movement** = Movement of the longitudinal slide away from the head stock
- **+X movement** = Movement of the cross slide away from the rotary axis
- **-X movement** = Movement of the cross slide towards the rotary axis

**Representing the coordinate system on the screen**

- **Z**
- **X**
3.4 Screen cursor

A cursor (graticule) is shown on the screen. This cursor can be moved on the screen.

Moving the screen cursor
The cursor is moved on the screen by means of the 4 arrow keys.

Further key functions
- [f²][g²] Doubling the step size of the cursor
- [g³][h²] Halving the step size of the cursor
- [a] The cursor jumps to the middle of the screen
- [b] The cursor jumps to the reference point

Step size ... distance of movement each time the key is pressed

Showing the screen cursor
There are two ways of showing the cursor on the screen:

1. Cursor as a graticule
   Normal representation of the cursor

2. Reduced cursor
   A reduced cursor is shown, when the key "<" is pressed.

The cursor is shown as a graticule again, when the key ">" is pressed.
3.5 Menu structure

This EMCO software is divided into menus (= selection possibilities). Divisions into main menu, menus and submenus are used depending on the hierarchy. Jumps back- and forwards between these individual menus can be made without limitations.

Go to the next menu level

Return to the previous menu level
Menu summary

Notes
You can select and activate the individual menu points with the function keys F1 to F10 or with the space bar.

A command can be interrupted or a return to the previous menu level activated with the key Esc.
3.6 Screen display

1. Diagrammatic representation of the working area
2. Displaying the cursor position [mm]
   X, Z ... Position of the cursor
   :::: ... Step size of the cursor (distance travelled every time a key is pressed)
3. Displaying the tool position
   X, Z ... Position of the tool [mm]
   D ... Diameter position of the tool [mm]
   F ... Feed speed [mm/min]
   S ... Main spindle speed [rpm]
4. Displaying the screen messages
5. Menu display

3.7 Selection / deselection of the menu points

There are two possibilities:

Possibility 1
By means of the space bar and 

Example
Activating the PROGRAM menu

| Go to the desired menu point with the space bar |
| Confirm entry and activate PROGRAM menu |
| Return to the main menu |

Possibility 2
By means of the function keys F1 to F10

Example
Activating the PROGRAM menu

Selection and activation of the PROGRAM menu

Return to the main menu

Note
The activation of the individual menu points is described with the function keys in these instructions.
4. MENU POINTS

4.1 Work piece

4.2 Draw
4.2.1 Cursor
4.2.2 Point
4.2.3 Line
4.2.4 Arc
4.2.5 Visible edges
4.2.6 Mirroring
4.2.7 Cleaning
4.2.8 Erasing the geometric element
4.2.9 Erasing all
4.2.10 Hotkeys - draw
Specimen example 1
Specimen example 2
Specimen example 3

4.3 Program
4.3.1 Moving in the rapid
4.3.2 Moving with feed speed
4.3.3 Cycles
Roughing cycle
Back pocket cycle
Follow contour cycle
Cut-in cycle
Threading cycle
4.3.4 Edit (see chapter 6)
4.3.5 Tool change
4.3.6 Erase the last movement
4.3.7 Erasing the machining program
4.3.8 Entering the feed values
4.3.9 Change feed unit
4.3.10 Entering the finishing offsets

4.4 Display
4.4.1 Zoom all
4.4.2 Zoom window
4.4.3 Zoom work piece
4.4.4 Removing, inserting the head stock
4.4.5 Removing, inserting the work piece
4.4.6 Removing, inserting the tool
4.4.7 Removing, inserting the tool path
4.4.8 Inserting, removing the tail stock
4.4.9 Changing the simulation display
4.4.10 Hotkeys - machine

4.5 Set up 0,0

4.6 Manual

4.7 Machine
4.7.1 Automatic
4.7.2 Single
4.7.3 Fast run
4.7.4 Empty cut step
4.7.5 Repeating the program
4.7.6 Moving the tool to the cursor
4.7.7 Shifting the program
4.7.8 Altering the scale program

4.8 Archive
4.8.1 Storing the program
4.8.2 Loading the program
4.8.3 Storing the geometry
4.8.4 Loading the geometry

4.9 Print

4.10 End
4.1 Work piece (F1)

The work piece is defined in this menu, and it is displayed clamped in the chuck.

Unit: [mm]

Example

Screen message

Diameter, work piece length:

22,100

Diameter, length of the drill hole (ENTER = no)

no

yes 4,10

The work piece clamped in the chuck appears on the screen, and the exit from the WORK PIECE menu takes place at the same time.

Note
The reference point = R (point X = 0, Z = 0 of the coordinate system) is situated on the Z axis at the right-hand end of the work piece, when the work piece is called up.
4.2 Draw (F2)

The contour of the work piece is determined in this menu.

Preliminary explanations
You only have to draw the lower half of the work piece contour on the screen, without circumferential edges. Circumferential edges are added after drawing the work piece contour, and by mirroring around the Z + axis, you automatically receive the complete representation of the work piece contour. The compilation of the work piece contour is carried out in the submenus described on the following pages.
Description of the individual submenus

4.2.1 Cursor (F1)

In this submenu, it is determined, how the cursor is to be positioned on the screen.

<table>
<thead>
<tr>
<th>CURSOR</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>F1</td>
<td>CURSOR INC</td>
</tr>
<tr>
<td>F2</td>
<td>CURSOR ABS</td>
</tr>
<tr>
<td>F3</td>
<td>CURSOR R, A</td>
</tr>
<tr>
<td>F4</td>
<td>CURSOR X, A</td>
</tr>
<tr>
<td>F5</td>
<td>CURSOR Z, A</td>
</tr>
</tbody>
</table>

Moving the screen cursor
The cursor is moved on the screen by means of the 4 arrow keys.

Further key functions
- Doubling the step size of the cursor
- Halving the step size of the cursor
- The cursor jumps to the middle of the screen
- The cursor jumps to the reference point

Step size .... distance of movement each time the key is pressed

Showing the screen cursor
There are two ways of showing the cursor on the screen:
1. Cursor as a graticule
   Normal representation of the cursor
2. Reduced cursor
   A reduced cursor is shown, when the key "<" is pressed

The cursor is shown as a graticule again, when the key ">" is pressed.

Calculating functions in the CURSOR submenu
For every menu point in the CURSOR submenu, where a number is prompted, there are many calculating functions available to you for the entry of arithmetical functions. In this way, you possess an aid capable of performance, which gives valuable help, especially for coordinate entries and angle calculations.

The following signs or mathematical functions can be used:

<table>
<thead>
<tr>
<th>Entry</th>
<th>Function</th>
</tr>
</thead>
<tbody>
<tr>
<td>+</td>
<td>Addition</td>
</tr>
<tr>
<td>-</td>
<td>Subtraction</td>
</tr>
<tr>
<td>*</td>
<td>Multiplication</td>
</tr>
<tr>
<td>:</td>
<td>Division</td>
</tr>
<tr>
<td>**</td>
<td>To the power of</td>
</tr>
<tr>
<td>(</td>
<td>Open bracket</td>
</tr>
<tr>
<td>)</td>
<td>Close bracket</td>
</tr>
<tr>
<td>SIN</td>
<td>Sin</td>
</tr>
<tr>
<td>COS</td>
<td>Cos</td>
</tr>
<tr>
<td>TAN</td>
<td>Tan</td>
</tr>
<tr>
<td>DSIN</td>
<td>Sin in degrees</td>
</tr>
<tr>
<td>DCOS</td>
<td>Cos in degrees</td>
</tr>
<tr>
<td>DTAN</td>
<td>Tangent in degrees</td>
</tr>
<tr>
<td>ASIN</td>
<td>Arc sin</td>
</tr>
<tr>
<td>ACOS</td>
<td>Arc cos</td>
</tr>
<tr>
<td>ATAN</td>
<td>Arc tangent</td>
</tr>
<tr>
<td>DASIN</td>
<td>Arc sin in degrees</td>
</tr>
<tr>
<td>DACOS</td>
<td>Arc cos in degrees</td>
</tr>
<tr>
<td>DATAN</td>
<td>Arc tangent in degrees</td>
</tr>
<tr>
<td>SQRT</td>
<td>Square root</td>
</tr>
<tr>
<td>PI</td>
<td>3.1415927</td>
</tr>
</tbody>
</table>

Any arithmetical function can be entered instead of a simple number for numerical entries (= numbers). The use of brackets is allowed. These can be nested as much as is required.

Note
Entered functions must be written in brackets (see example).

Example
You are in the CURSOR submenu. An incremental coordinate is to be calculated.

\[ X = 10 \cdot \frac{\sqrt{2}}{2} \quad , \quad Z = 50 \]

Therefore, enter the following:

\[ F1 \]

\[ 10 \cdot \text{SQRT} \ (3) \ : \ 2 \ . \ 50 \]

A cursor step of 8.66 in X and 50 in Z is the result.
Positioning the cursor incrementally (F1)
Unit: [mm]
The cursor is shifted from the present position by the entered values.

Positioning the cursor absolutely (F2)
Unit: [mm]
The cursor is shifted by the values entered (always measured from the reference point).

Positioning the cursor with the radius and angle (F3)
Unit: [mm], [°]
The cursor is shifted from the present position by the radius and angle entered.
Example: R = 24 mm, A = 30° (clockwise)

Positioning the cursor with X dimension and angle (F4)
Unit: [mm], [°]
Entering the X dimension incrementally
Example: X = 19 mm, A = -45°

<table>
<thead>
<tr>
<th>Screen message</th>
<th>Entry</th>
</tr>
</thead>
<tbody>
<tr>
<td>X, angle movement from the cursor?</td>
<td>19, -45</td>
</tr>
</tbody>
</table>

Positioning the cursor with Z dimension and angle (F5)
Unit: [mm], [°]
Entering the Z dimension incrementally
Example: Z = 15 mm, A = -35° (clockwise)

<table>
<thead>
<tr>
<th>Screen message</th>
<th>Entry</th>
</tr>
</thead>
<tbody>
<tr>
<td>Z, angle movement from the cursor?</td>
<td>15, -35</td>
</tr>
</tbody>
</table>

Determining the step size of the cursor (F6)
Unit: [mm]
The step size is the distance the cursor moves every time a key is pressed.
The step size of the cursor is 1 mm when you call up the software.
Example: Cursor step should amount to 2.5 mm

<table>
<thead>
<tr>
<th>Screen message</th>
<th>Entry</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cursor step 1.000</td>
<td>F6</td>
</tr>
<tr>
<td>New step (ENTER = no change)</td>
<td>2.5</td>
</tr>
</tbody>
</table>

Note: Angle entry
Positive (+) sign = angle in the anti-clockwise direction.
Negative (-) sign = angle in the clockwise direction.
Cursor to the reference point (F7)
The reference point is the origin of the coordinate system shown on the screen (reference point = position $X = 0 / Z = 0$ of the coordinate system).

Position of the reference point
No work piece:
The reference point is situated on the Z axis at the stop of the clamping device.

Find the point of intersection (F9)
Position the cursor by means of the arrow keys near to the point of intersection to be found.

The cursor jumps to the neighbouring point of intersection, when the key F9 is pressed.

Possibilities for the point of intersection
- two lines
- two circles
- a line and a circle

Workpiece compiled:
The reference point is situated on the Z axis at the right-hand edge of the work piece.

The cursor jumps to the reference point, when the key F7 is pressed.

Cursor to the middle of the screen (F8)
The cursor jumps to the middle of the screen, when the key F8 is pressed.
4.2.2 Point (F2)

Secondary points for drawing the work piece contour are determined on the screen in this submenu.
The basis of the definition of the geometry (= contour of the work piece) are secondary points.
E.g., a line is defined by a starting point and an end point.

<table>
<thead>
<tr>
<th>POINT</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>F1</td>
<td>START PNT</td>
</tr>
<tr>
<td>F2</td>
<td>END POINT</td>
</tr>
<tr>
<td>F3</td>
<td>CENTRE PNT</td>
</tr>
<tr>
<td>F4</td>
<td>FIND POINT</td>
</tr>
<tr>
<td>F5</td>
<td>NEW REF PT</td>
</tr>
<tr>
<td>F6</td>
<td>TO REF PNT</td>
</tr>
<tr>
<td>F7</td>
<td>INTERSECT</td>
</tr>
<tr>
<td>F8</td>
<td>TRIM BITS</td>
</tr>
<tr>
<td>F9</td>
<td></td>
</tr>
<tr>
<td>F10</td>
<td></td>
</tr>
</tbody>
</table>

Determining the starting point (F1)
The point, on which the cursor is located, is defined as the starting point of an element of geometry (line, circle or arc) by pressing the key F1.

The active starting point is shown on the screen by the symbol " > ".

Determining the end point (F2)
The point, on which the cursor is located, is defined as the end point of an element of geometry (a line, circle or arc) by pressing the key F2.

The active end point is shown on the screen by the symbol " < ".

Determining the centre point (F3)
The point, on which the cursor is located, is defined as the centre point of a circle or an arc by pressing the key F3.

The active centre point is shown on the screen by the symbol "o".

Example:
The cursor is located at the starting point of the line.

Find point (F4)
Position the cursor by means of the arrow keys near to the point found.
The cursor jumps to the neighbouring point, when the key F4 is pressed.

Purpose:
If machining is to continue from an available point, this must be approached exactly with F4.

Re-defining the reference point (F5)
The point, on which the cursor is located, is defined as the new reference point by pressing the key F5.
Reference point (R) = origin of the coordinate system (X = 0 / Z = 0).

Cursor to the reference point (F6)
The cursor returns to the reference point, when the key F6 is pressed.

Find the point of intersection (F7)
Position the cursor by means of the arrow keys near to the point of intersection to be found.
The cursor jumps to the neighbouring point of intersection, when the key F7 is pressed.

Representation of a starting point, centre point and end point
Trim bits (F8)

Trim bits = deleting protruding parts of an element of geometry

Example
Two intersecting lines should result in a bit.

Position the cursor by means of the arrow keys near to the bit to be trimmed.

<table>
<thead>
<tr>
<th>F8</th>
</tr>
</thead>
</table>

Screen message

Is this the desired side of the element (ENTER = yes)

- yes
- no

* Pressing any key except for Esc. or F8.

Is this the desired side of the element (ENTER = yes)

- yes
- no

* any key
4.2.3 Line (F3)

Lines are drawn, altered or erased in this submenu.

<table>
<thead>
<tr>
<th>LINE</th>
<th>DRAW</th>
<th>SEARCH</th>
<th>SPLIT</th>
<th>ERASE</th>
<th>PARALLEL</th>
<th>PERPENDIC</th>
<th>TANGNT P/A</th>
<th>TANGNT A/A</th>
<th>CHAMFER</th>
</tr>
</thead>
<tbody>
<tr>
<td>F1</td>
<td>F2</td>
<td>F3</td>
<td>F4</td>
<td>F5</td>
<td>F6</td>
<td>F7</td>
<td>F8</td>
<td>F9</td>
<td>F10</td>
</tr>
</tbody>
</table>

Drawing a line (F1)

A line is drawn, whose starting and end points are already determined.

Example
Starting point: \( X = 35 \text{ mm}, Z = 65 \text{ mm} \)
End point: \( X = 25 \text{ mm}, Z = 55 \text{ mm} \)

A line between the two points is drawn by pressing the key F1.

Searching for a line (F2)

Position the cursor by means of the arrow keys near to the line to be searched for.
The cursor jumps to the neighbouring line, when the key F2 is pressed.

Purpose: If a line is to be machined further, this must first be determined with F2.

Splitting a line (F3)

Position the cursor by means of the arrow keys on the splitting point of the line.

This line is divided into two lines, when the key F3 is pressed. (The point of splitting is invisible.)

Purpose: If only a part of a line is to be machined further, this part must be split from the rest.

Erasing a line (F4)

Position the cursor by means of the arrow keys near to the line to be erased and press the key F4.

Drawing a parallel line (F5)

Unit: [mm]
A parallel line is drawn to an existing line (e.g., distance = 5 mm).

Input offset for the parallel line

Is this the correct side for the parallel line (ENTER = yes)

Any key except for Esc. or \( \rightarrow \)

Is this the correct side for the parallel line (ENTER = yes)
Drawing a perpendicular (90°) to a line (F6)

A perpendicular (90°) is drawn to an existing line.

Move the cursor to the point, where the perpendicular should start.

---

Drawing a tangent point/arc (F7)

A tangent from the current cursor position to an arc is drawn.

---

Screen message

Position cursor on the desired line.

Move the cursor near to the line.

Is this the desired tangent (ENTER = yes)

---

Any key except for Esc or Enter
Drawing a tangent arc/arc (F8)
A tangent from an arc to a second arc is drawn.

Adding a chamfer (45°) (F9)
Unit: [mm]
Condition:
1. Both lines contact each other at this point (do not intersect).
2. The cursor must be positioned near to this bit.
Example: chamfer = 3 x 3 mm

<table>
<thead>
<tr>
<th>Screen message</th>
<th>Entry</th>
</tr>
</thead>
<tbody>
<tr>
<td>F9</td>
<td></td>
</tr>
<tr>
<td>Size of the chamfer</td>
<td>3</td>
</tr>
<tr>
<td>Is the chamfer correct</td>
<td>ENTER = yes</td>
</tr>
</tbody>
</table>

Possibilities:
ENTER = Confirming the desired chamfer
Any other key = interruption of this command "Adding a chamfer".

63
4.2.4 Arc (F4)

Arcs are drawn, altered or erased in this submenu.

<table>
<thead>
<tr>
<th>ARC</th>
<th>F1</th>
<th>DRAW</th>
</tr>
</thead>
<tbody>
<tr>
<td>F2</td>
<td>SEARCH</td>
<td></td>
</tr>
<tr>
<td>F3</td>
<td>SPLIT</td>
<td></td>
</tr>
<tr>
<td>F4</td>
<td>ERASE</td>
<td></td>
</tr>
<tr>
<td>F5</td>
<td>CIRCLE</td>
<td></td>
</tr>
<tr>
<td>F6</td>
<td>ARC 3 PTS</td>
<td></td>
</tr>
<tr>
<td>F7</td>
<td>FILLET</td>
<td></td>
</tr>
<tr>
<td>F8</td>
<td>FILL 2 ELE</td>
<td></td>
</tr>
<tr>
<td>F9</td>
<td></td>
<td></td>
</tr>
<tr>
<td>F10</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Searching for an arc (F2)

Position the cursor by means of the arrow keys near to the arc to be searched for. The cursor jumps to the neighbouring arc, when the key F2 is pressed.

Purpose

If an arc is machined further, this must be defined with F2 first.

Splitting an arc (F3)

Position the cursor by means of the arrow keys on the splitting point of the arc. The arc is split, when the key F3 is pressed. (The splitting point is not visible.)

Purpose:

If only a part of an arc is to be machined further, this part must first be split from the rest.

Application example:

You must split arcs over 90°, since a starting point of the back pocket must be determined in the program menu (for back pocket).

Erasing an arc (F4)

Position the cursor by means of the arrow keys near to the arc to be erased and press the key F4.

Attention!

The command "Erase" can no longer be reversed, after it has been carried out!
**Drawing a complete circle (360°)** (F5)

Unit: [mm]
Position the cursor by means of the arrow keys on the centre point of the desired complete circle.
Press F5, enter the radius of the circle and confirm it.

**Example:**
Constructing a complete circle $R = 15$ mm

<table>
<thead>
<tr>
<th>Screen message</th>
<th>Entry</th>
</tr>
</thead>
<tbody>
<tr>
<td>Circle radius 10.000 (ENTER = no change):</td>
<td>15</td>
</tr>
</tbody>
</table>

![Diagram of a complete circle]

**Adding a fillet (F7)**

Unit: [mm]
1. Both lines must contact at this point.
2. The cursor must be positioned near to this bit.

**Example:** Radius = 5 mm

<table>
<thead>
<tr>
<th>Screen message</th>
<th>Entry</th>
</tr>
</thead>
<tbody>
<tr>
<td>Radius for the corner?</td>
<td>5</td>
</tr>
<tr>
<td>Is the radius correct (ENTER = yes)</td>
<td></td>
</tr>
</tbody>
</table>

**Possibilities:**
ENTER = confirming the desired radius
Any other key = interruption of this command "Adding the fillet".

![Diagram of adding a fillet]

**Drawing an arc with three points (F6)**

Determine the starting point and the end point.
Position the cursor on the circumference of the desired arc (= third point).
An arc is drawn through the starting, end point and cursor position, when the key F6 is pressed.

**Note:**
Arcs are always drawn anti-clockwise.
You can define the position of the arc by the selection of the starting and end points.

![Diagram of drawing an arc with three points]

**Example:**
Starting point: $X = 25$ mm, $Z = 36$ mm
End point: $X = 16$ mm, $Z = 25$ mm
Cursor position: $X = 18$ mm, $Z = 32$ mm

The arc is drawn, when F6 is pressed.

![Diagram of an arc with three points drawn]

**Fill two elements (F8)**

Geometric elements (points, lines, circles or arcs) are filled tangentially by an arc.

**Note:**
If you want to fill a circle or an arc, the prompt from the system for the type of filling appears.
There are two possibilities.

**Filling 1: in front of the circle**

![Diagram of filling in front of a circle]

**Filling 2: including the circle**

![Diagram of filling including a circle]
Example 1
Filling the point of one line with a point of another line.

Define element nr. 1

Position the cursor on the desired point.

Define element nr. 2

Position the cursor on the desired point.

Radius for the corner?:

Is this the desired side? (ENTER = yes)

Any key except for Esc or Enter

Example 2
Filling the point of a line with a line.

Define element nr. 1

Position the cursor on the desired point.

Define element nr. 2

Position the cursor on the desired line.

Radius for the corner?:

Is this the desired side? (ENTER = yes)

Any key except for Esc or Enter
Example 3
Filling the point of a line with an arc.

Define element nr. 1
→ Position the cursor on the desired point.

Filleting tangential to: 1 = point, 2 = line, 3 = arc:

Filleting type?: 1 = before the arc, 2 = include the arc:

Define element nr. 2
→ Position the cursor on the desired circle.

Radius for the corner?:

Move the cursor near to the centre point.

Is this the desired side? (ENTER = yes)

---

Example 4
Filling a straight line with an arc.

Define element nr. 1
→ Position the cursor on the desired line.

Filleting tangential to: 1 = point, 2 = line, 3 = arc:

Filleting type?: 1 = before the arc, 2 = include the arc:

Define element nr. 2
→ Position the cursor on the desired circle.

Radius for the corner?:

Move the cursor near to the centre point.

Is this the desired side? (ENTER = yes)
4.2.5 Drawing visible edges (circumferential edges) (F5)

Drawing in the visible edges is not required for the production on a lathe; it only serves to create a complete representation according to the standards.

Procedure:
- The cursor was positioned near to the desired visible edge.
- The visible edge is drawn up to the Z axis, when the key F5 is pressed.
- This procedure is repeated for every visible edge.

![Diagram of visible edges](image)

4.2.6 Mirroring the work piece contour (F6)

Only the lower half of the work piece must be drawn on the screen for the production on a lathe.
The upper half of the work piece can be created by mirroring around the Z axis.

Procedure
Press F6 key
The command F6 - mirroring remains. This means, that all contour parts programmed after this function are also mirrored.

The command is deselected again, when "F6" is pressed again.

![Diagram of mirrored contour](image)

4.2.7 Cleaning the work piece contour (F7)

At the beginning of a geometric definition, it will often be the case that two or more contour elements are cut uncleanly. For the machining of the work piece, however, continuous contours are required. The points of intersection must be "cleaned" (for example, see next page).

Note:
The prompt from the system for the type of contour appears during the cleaning. There are two possibilities.

Possibility 1: open contour

![Diagram of open contour](image)

Possibility 2: closed contour

![Diagram of closed contour](image)
4.2.8 Erasing the geometric element (F8)

The cursor was positioned near to the element be erased (line, circle or arc).
The neighboring geometric element is erased, when the key F8 is pressed.

Attention!
The command "Erase" can no longer be reversed, after it has been carried out.

4.2.9 Erasing all (F9)

All the drawing elements shown on the screen are erased.

Attention!
The command "Erase" can no longer be reversed, after it has been carried out.

<table>
<thead>
<tr>
<th>Screen message</th>
<th>Entry</th>
</tr>
</thead>
<tbody>
<tr>
<td>Are you sure? (ENTER = yes)</td>
<td>F9</td>
</tr>
</tbody>
</table>

Possibilities:
ENTER = drawing is erased
Any other key = erasion command is interrupted
Specimen example 1

Creating a work piece with F1

\[ \Phi = 22 \text{ mm, length } = 100 \text{ mm, no bore hole} \]

Adding the visible edges with F2, submenu F5

The work piece is enlarged over the whole of the screen surface by means of the hotkey \( \text{F} \)

Creating the lower half of the work piece contour with F2

Reflecting the work piece contour with F2, submenu F6

Adding the radii and chamfers with F2

Storing the work piece contour with F8
Specimen example 2

Creating a work piece with F1
\( \varnothing = 22 \text{ mm}, \text{ length} = 100 \text{ mm}, \text{ no bore hole} \)

The work piece is enlarged over the whole of the screen surface by means of the hotkey \( z \).

Adding the visible edges with F2, submenu F5

Reflecting the work piece contour with F2, submenu F6

Creating the lower half of the work piece contour with F2

Adding the radii and chamfers with F2

Storing the work piece contour with F8
Specimen example 3

Creating a work piece with F1
\( \varnothing = 22 \text{ mm}, \text{ length} = 100 \text{ mm}, \text{ no bore hole} \)

Adding the visible edges with F2, submenu F5

The work piece is enlarged over the whole of the screen surface by means of the hotkey Z.

Creating the lower half of the work piece contour with F2

Reflecting the work piece contour with F2, submenu F6

Adding the radii and chamfers with F2

Storing the work piece contour with F8
4.3 Program (F3)

The machining cycle is determined for a workpiece drawn and simulated on the screen in this menu. The tool path is shown graphically. The machining program is compiled automatically.

<table>
<thead>
<tr>
<th>PROGRAM</th>
</tr>
</thead>
<tbody>
<tr>
<td>F1</td>
</tr>
<tr>
<td>F2</td>
</tr>
<tr>
<td>F3</td>
</tr>
<tr>
<td>F4</td>
</tr>
<tr>
<td>F5</td>
</tr>
<tr>
<td>F6</td>
</tr>
<tr>
<td>F7</td>
</tr>
<tr>
<td>F8</td>
</tr>
<tr>
<td>F9</td>
</tr>
<tr>
<td>F10</td>
</tr>
</tbody>
</table>

Possibilities PROGRAM

4.3.1 Moving in the rapid (F1)

Moving in the rapid is a movement without chip removal and only serves to position the tool. The slides move with the highest possible speed (200 mm/min).

Representation on the screen:

The tool moves to the cursor position in the rapid, when the key F1 is pressed.

4.3.2 Moving with feed speed (F2)

The slides move with the programmed feed speed (= machining movement, see F9).

Representation on the screen:

4.3.3 CYCLES (F3)

A cycle is a pointed tool movement, which is enclosed and composed of many parts. A cycle is composed of the rapid and feed movements or thread-cut movements.

\[
\begin{align*}
S &= \text{Starting point} \\
E &= \text{End point} \\
V_F &= \text{Feed speed} \\
V_E &= \text{Rapid speed}
\end{align*}
\]
Roughing cycle (F1)

The roughing cycle is a movement sequence, where the "coarse contour" of the work piece is machined with the greatest possible chip removal.

If your work piece is designed in such a way that the diameter of the work piece contour decreases to the left, this is not taken into consideration by the roughing cycle. This work piece area must be back pocketed in its own machining procedure.

Condition
The work piece contour created in the menu draw may not be interrupted, since otherwise an interruption of the roughing cycle takes place.

Procedure
1. Position the tool in the rapid (F1) or with the feed speed (F2) on a sensibly selected starting point (A) of the cycle and press F3.

2. Determining the starting point
The starting point (S) of the roughing cycle must always be the outermost point on the work piece contour in the Z direction.

Examples: Starting point for roughing cycles

If F3 - roughing cycle is pressed, the point nearest to the cursor is suggested by the program as the starting point.
Possibilities
- Confirm the starting point
- Another point is suggested as the starting point.

3. Determining the contour points
After the starting point has been determined, the contour points (1, 2, ...) of the work piece contour drawn must be determined. These contour points are suggested to you.

Possibilities
- Confirm the contour point
- Display the next contour point in the opposite direction
- Omit the suggested contour point
- End of the contour point determination, if all contour points have + been made known to the program.

You can also confirm the points of a back pocket, but these are not taken into account by the roughing cycle and must be machined with back pocket cycles.
4. Entering the technological data

After the contour points have been determined, the following prompts appear on the screen one after the other.

<table>
<thead>
<tr>
<th>Screen display</th>
<th>Entry example</th>
</tr>
</thead>
<tbody>
<tr>
<td>Finishing offsets [mm]</td>
<td>X = 0, Z = 0</td>
</tr>
<tr>
<td></td>
<td>0.1, 0.2</td>
</tr>
<tr>
<td>In-feed per cut [mm]</td>
<td>0.8</td>
</tr>
<tr>
<td>Feed speed [mm/min]</td>
<td>150</td>
</tr>
</tbody>
</table>

Either confirm the suggested values with ENTER or enter new values.

The values confirmed here are suggested for the following machining variants (back pocket, follow contour).

The data for X values refer to the radius and not to the diameter of the work piece.

After entering the feed speed, the finishing cycle is processed on the screen. If it is not processed, there are the following causes of errors:

1. No enclosed contour (line draw).
2. Incorrect definition of the contour points.
3. The finishing offset is larger than the contour to be machined.
4. The cutting depth is larger than the contour to be machined.

Example - Roughing cycle

Call up the specimen example 2 (from page 72). Position the tool near to the work piece. Position the cursor near to the starting point.

Screen message

Define start point, (ENTER = accept) any other key = continue

yes no

Contour points are suggested by the computer and must be confirmed with ENTER.

1 = opposite direction, 2 = omit point, 3 = end (ENTER = accept)

Offset in X, Z 0.000 0.000 (ENTER = no change):

0.1, 0.2

Cutting depth = 1 (ENTER = no change):

0.8

Feed = 150 (ENTER = no change)
**Back pocket (F2)**

Machining a work piece area, which was not taken into consideration by the roughing cycle (work piece diameter decreases to the left).

![Diagram of back pocket](image)

**Condition**
The work piece contour created in menu draw may not be interrupted, since otherwise an interruption of the back pocket takes place.

**Procedure**
1. Position the work piece on a sensibly selected starting point (A) in the rapid (F1) or in the feed speed (F2) and press F4.

**Note**
If a cycle was previously machined, the following message appears on the screen:

New or last contour (ENTER = last):

- Re-machine the last defined contour.
- Defining a new contour.

2. **Determining the starting point**
The starting point (S) of the back pocket must always be the outermost point of the machined contour in the Z direction.

![Diagram of starting point](image)

If F2 - back pocket is pressed, the point next to the cursor is suggested by the program as the starting point.

**Possibilities:**
- Confirm the starting point
- Another point is suggested as the starting point.

**Examples - Starting point for back pockets**

![Example diagrams](image)

**Special case for turning out an arc with two different tools**

**Procedure**
- Split the arc (point T)
- Draw the auxiliary line (H) from the splitting point (T) to the starting point (S1).
  
  **Reason:** The tool would otherwise cut above the arc and collide.
- Put an additional point (P) on the arc (or on the line).
  
  **Reason:** In this way, you can determine whether the tool is to travel the path S1 - T (= arc) or the path S1 - P - T (= line) during the determination of the contour points.
- Carry out the back pocket with the right lateral tool.
- Starting point .... S1
  
  Following contour points .... T, P, S1

![Diagram of tool path](image)

- Change the tool and move to the new starting point (S2).
- Machine the rest from T to S1 with the roughing cycle (there is no more back pocket).
  
  **Starting point .... S2**
  
  Following contour points .... T, P, S1

![Diagram of tool path](image)
Attention!
Arrows larger than 90°, which are back pocketed, must be split before the machining (see page 64).

Reason
The system only recognizes the starting and end points of the arc. A new starting point must be defined for the back pocket. (The starting point of the back pocket is the point, which has come into being, when the arc was split.)

3. Determining the contour points

After the starting point was determined, the contour points (1, 2, ...) of the back pocket drawn must be determined. These contour points are suggested to you.

Possibilities
1. Confirm the contour point
2. Display the next contour point in the opposite direction
3. Omit the suggested contour point
4. Finish the contour point determination

The last contour point of the back pocket must lie on the same level in the X direction or higher than the starting point.

Example - Back pocket
The specimen example 2 (from page 72) is called up. The menu point roughing was carried out. Move the tool near to the starting point of the back pocket. Position the cursor near to the starting point.

4. Entering the technological data
This is carried out in the same way as described in the chapter "roughing cycle".
Follow contour cycle (F3)

If a finishing offset was determined in the menu points roughing or back pocket, this is machined with the follow contour cycle.

Finishing = Dimension-accurate finishing of the work piece contour

Procedure

1. Position the tool near to the starting point (S) in the rapid (F1) or with the feed speed (F2) and press F3.

Note
If a cycle was previously machined, the following message appears on the screen:

New or last contour [ENTER = last]:

Re-machine the last defined contour

Define the new contour.

2. Determining the starting point

The starting point of the follow contour cycle must always be the outermost point on the machined contour in the Z direction.

5 ............... Starting point

If F3 - follow contour is pressed, the point nearest to the cursor is suggested as the starting point.

Possibilities

Confirming the starting point

Another point is suggested as the starting point.

3. Determining the contour points (1, 2, 3, 4, 5)

After the starting point has been determined, the contour points of the work piece contour drawn must be determined. These contour points are suggested to you.

Possibilities

Confirming the contour point
Displaying the next contour point in the opposite direction
Omitting the suggested contour point
Ending the contour point determination

Note
Only the points of the machining, which can be finished with the selected tool, are confirmed as contour points.

E.g., the holes (point 3, 4, 7, 8) may not be confirmed.

4. Entering the technological data

The input of the finishing offset and feed speed is carried out exactly as described in the chapter "roughing cycle".
Cut-in cycle (F4)

With this cycle a cut-in can be produced.

Procedure:
1. Select cut-in tool
   (see menu PROGRAM/CHANGE TOOL - F5)
2. Place the cut-in tool with rapid motion (F1) or
   feed speed (F2) at the level (direction X) of the
   initial point of the cycle (A) and press F3.
   Note:
   You have to place the cut-in tool only in
   direction X at the initial point (A) of the cut-in
   cycle. Before working-off the cycle the tool
   moves automatically to the initial point in
   direction Z.
3. F4 - select cut-in cycle
4. Determine the starting point
   If the key F4 was pressed, the following message
   appears on the screen:
   Identify starting point for cut-in
   By using the cursor keys move next to the starting
   point (S) and confirm with ENTER.
5. Determine final point:
   After determining the starting point the following
   message appears:
   Determine final point for cut-in
   By using the cursor keys move next to the final
   point (E) and confirm with ENTER.
6. Enter technological data:
   After having determined the starting and the final
   point of the cut-in off the following inquiries
   appear on the screen in series:

<table>
<thead>
<tr>
<th>Screen message</th>
<th>Input</th>
</tr>
</thead>
<tbody>
<tr>
<td>Enter cutter width</td>
<td>3</td>
</tr>
<tr>
<td>Enter feed in mm/min = 150</td>
<td>70</td>
</tr>
<tr>
<td>Enter infeed depth</td>
<td>1</td>
</tr>
</tbody>
</table>

7. Confirm inputs:
   After entering the technological data the
   following message appears on the screen:
   End of input (ENTER = accepted).
   Possibilities:
   - The cut-in cycle is worked off.
   - Exit
Example cut-in cycle:

Training example 3 is called up. Menu point 3 roughing and contour sequences have been executed. The cut-in tool has been selected and moved next to the starting point of the cycle.

Identify starting point for cut-in

Move cursor to the starting point and confirm with $\text{确认}$

Enter final point for cut-in

Move cursor to the final point and confirm with $\text{确认}$

Enter width of the cutter

3 $\text{确认}$

Enter feed in mm/min = 150 (ENTER = unchanged):

70 $\text{确认}$

Enter depth of advance

1 $\text{确认}$

End of input (ENTER = accepted)

82
Threading cycle (F5)

Possible threads:
- With this machine you can tap and thread right-hand and left-hand threads.
- Possible thread pitches:
  PC/AT: 0.5 - 3 mm (0.025" - 0.11")
  PC/XT: 0.5 - 1,5 mm (0.025" - 0.062")
- Metric threads:
  PC/AT: M3 - M24
  PC/XT: M3 - M10
- Inch threads:
  PC/AT: 0.112" - 3/4"
  PC/XT: 0.112" - 3/8"
- Flank angle 60° (with threading tool supplied)
- Speed: Smallest speed range

Theoretical knowledge

Function of thread-cutting
At each workpiece revolution the threading tool has to advance at a certain length (= threading pitch P). For this the main spindle and the slide feed have to be synchronized.

Finding of thread turn
A thread is always cut in several operations. At the start command for thread-cutting the main spindle must have a certain angular position. At the start command for the next screw the main spindle must have the same angular position, so that the threading tool finds its way into the thread turn.
Synchronization of speed and feed

Hand-operated lathe
With a hand-operated lathe the slide feed is carried out from the main spindle via toothed belts, translating gear wheels and leadscrew to the longitudinal slide. There is a closed, mechanical power flux. If the main spindle turns slower, e.g. because of load, the main spindle turns slower at the same rate. The thread pitch always remains the same.

CNC lathe
At the spindle there is an aperture disk with light barrier (= encoder). The encoder reports the respective speed and angular position of the main spindle to the computer. The computer converts this information and provides the necessary impulses for start and feed speed to the feed motor of the longitudinal slide.

Thread design

When conforming to standard metric ISO threads a separate radius of curvature (R1) is assigned to each thread pitch. This means that for each pitch a separate threading tool is needed.
Solution:
On this machine we use a threading tool with a radius $R_2 = 0.04 \text{ mm}$ for all pitches from 0.5 to 2 mm.

Disadvantage:
The radius of curvature $R_2$ does not conform to standard. The thread turns become a little deeper, thus resulting in a smaller core diameter (see tables) than with standard threads. These threads naturally can be screwed with standard screws and nuts.
3. Design of a thread

During the design of a thread mind the following items:

Thread dimensions

The threads cut in accordance with this table can be screwed with standardized screws and nuts.

Metric threads (dimensions in mm)

<table>
<thead>
<tr>
<th>Thread designation</th>
<th>Pitch P</th>
<th>Bolt</th>
<th>Nut</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Nominal diameter D₁</td>
<td>Thread height H₁</td>
<td>Core diameter D₂</td>
</tr>
<tr>
<td>M3</td>
<td>0.3</td>
<td>3.00</td>
<td>0.237</td>
</tr>
<tr>
<td>M3.5</td>
<td>0.5</td>
<td>3.50</td>
<td>0.416</td>
</tr>
<tr>
<td>M4</td>
<td>0.7</td>
<td>4.00</td>
<td>0.490</td>
</tr>
<tr>
<td>M4.5</td>
<td>0.75</td>
<td>4.50</td>
<td>0.529</td>
</tr>
<tr>
<td>M5</td>
<td>0.8</td>
<td>5.00</td>
<td>0.551</td>
</tr>
<tr>
<td>M6</td>
<td>1.0</td>
<td>6.00</td>
<td>0.717</td>
</tr>
<tr>
<td>M8</td>
<td>1.25</td>
<td>8.00</td>
<td>0.907</td>
</tr>
<tr>
<td>M10</td>
<td>1.5</td>
<td>10.00</td>
<td>1.100</td>
</tr>
<tr>
<td>M12</td>
<td>1.75</td>
<td>12.00</td>
<td>1.285</td>
</tr>
<tr>
<td>M14</td>
<td>2.0</td>
<td></td>
<td></td>
</tr>
<tr>
<td>M16</td>
<td>2.0</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

* M. stands for metric standard threads

Inch threads according to US-standard (dimensions in inches)

<table>
<thead>
<tr>
<th>Thread designation</th>
<th>Turns per inch</th>
<th>Pitch P</th>
<th>Bolt</th>
<th>Nut</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Nominal diameter D₁</td>
<td>Thread height H₁</td>
<td>Core diameter D₂</td>
<td>Thread height H₂</td>
</tr>
<tr>
<td>1/16</td>
<td>40</td>
<td>0.0250</td>
<td>0.1120</td>
<td>0.0174</td>
</tr>
<tr>
<td>1/8</td>
<td>40</td>
<td>0.0250</td>
<td>0.1250</td>
<td>0.0174</td>
</tr>
<tr>
<td>3/32</td>
<td>32</td>
<td>0.0313</td>
<td>0.1380</td>
<td>0.0243</td>
</tr>
<tr>
<td>1/8</td>
<td>32</td>
<td>0.0313</td>
<td>0.1640</td>
<td>0.0243</td>
</tr>
<tr>
<td>1/4</td>
<td>24</td>
<td>0.0417</td>
<td>0.1900</td>
<td>0.0330</td>
</tr>
<tr>
<td>5/32</td>
<td>24</td>
<td>0.0417</td>
<td>0.2160</td>
<td>0.0330</td>
</tr>
<tr>
<td>5/32</td>
<td>20</td>
<td>0.0360</td>
<td>0.2500</td>
<td>0.0386</td>
</tr>
<tr>
<td>3/32</td>
<td>18</td>
<td>0.0556</td>
<td>0.3125</td>
<td>0.0447</td>
</tr>
<tr>
<td>1/2</td>
<td>16</td>
<td>0.0625</td>
<td>0.3750</td>
<td>0.0502</td>
</tr>
<tr>
<td>1/4</td>
<td>14</td>
<td>0.0714</td>
<td>0.4375</td>
<td>0.0577</td>
</tr>
<tr>
<td>5/32</td>
<td>13</td>
<td>0.0769</td>
<td>0.4875</td>
<td>0.0632</td>
</tr>
<tr>
<td>9/32</td>
<td>12</td>
<td>0.0833</td>
<td>0.5140</td>
<td>0.0676</td>
</tr>
<tr>
<td>5/16</td>
<td>11</td>
<td>0.0909</td>
<td>0.5315</td>
<td>0.0713</td>
</tr>
</tbody>
</table>

*" = 25.4 mm
Chamfer

Start and end of a thread are usually provided with a chamfer of 45° or 60° to avoid a burr during thread-cutting. The 30° chamfer can still be turned with the right lateral tool and saves additional changing of the turning tool.

Design of core diameter for bolts

- Draw one straight line between starting point (S) and final point (E) with the correct thread height H1 (see table)
- Search intersecting point (X) and delete projecting line

Thread lead-in - Thread lead-out

At the start and end of a thread-cutting procedure, the slides (with threading tool) have to be accelerated or decelerated.

This acceleration path (approx. 3 mm) and deceleration path (approx. 1 mm) has no constant thread pitch and therefore must be outside of the cutting process. The necessary free space for the turning tool has to be taken into account during the design of the workpiece.

Design of nominal diameter for nut

Similar to description for core diameter of bolt.
4. Machining data

Tool change
Select tool for thread-cutting (see menu program - F3/change tool - F6).

Right-hand thread - left-hand thread
If the tool is at the right side of the thread (A) a right-hand thread is cut. If you move the tool (in rapid motion) to the left side of the thread (B) a left-hand thread is cut.

Call-up thread cycle
Select the key F3 in the menu program and the submenu CYCLES appears.
Select the thread cycle with F4.

Enter number of machine cuts
After selecting the thread cycle the following message appears at the screen:

Enter number of machine cuts (10)
(ENTER = accept)

The recommended number of machine cuts is 10 to 20 according to thread height (H).
The software adjusts the feed depth so that at each cut the chip cross-section has the same size.
The feeds are carried out only in X-direction.

Thread lead-in - thread lead-out
Screen message:

Enter thread lead-in = 3.000, lead-out = 1.000
(ENTER = no change)

For thread lead in a length of at least 3 mm should be entered because the slide (with thread tool) needs an acceleration path. For thread lead-out enter approx. 1 mm. At left-hand threads these values must be provided with a negative sign.
Left-hand thread

---

**Acknowledge inputs**

End of input (ENTER = accepted)

You have two possibilities:

- The thread cycle is worked off on the screen.
- Any key | Exit from the thread cycle. The values entered last are suggested at the next call-up of the thread cycle.

**Thread pitch**

Screen message:

Pitch = 1.000 (ENTER = no change):

Thread-cutting tools offered are designed for pitches of $P = 0.5 \, \text{mm}$ or 11-40 turns per inch. You can see the pitches for standardized threads from the table of the chapter "thread dimensions".

---

**Notes for working off the thread cycle at the machine**

Speed:
Adjust the smallest speed range ($BC1 = 200 \, \text{rpm}$).

---

**Indicate nominal and core diameter**

Enter nominal diameter element:

Place the cursor to the nominal diameter and acknowledge with ENTER. The following message appears:

Enter core diameter element:

Place the cursor to the core diameter and acknowledge with ENTER.
Example: Generation of a special screw

- Unmached part: Ø22,100 with bore Ø3,5
- Drawing:

  ![Diagram of a special screw]

  Chamfers: 1x45°

- Roughing
- Back-off
- Execute contour cycle
- Select thread tool
- Position thread-cutting tool at the right side of the thread
- Select submenu “thread”

Program (Threading cycle)

1. Enter number of machine cuts (10) (ENTER = accepted):
   - 15

2. Enter thread lead in = 3.000, lead out = 1.000 (ENTER = no change):
   - 1.25

3. Enter pitch = 1.000 (ENTER = no change):
   - 1.000

4. Enter nominal diameter element:
   - Cursor to nominal diameter and acknowledge with Enter core diameter element:
   - Cursor to core diameter and acknowledge with

End of input (ENTER = accepted)

Important: During machining and particularly during thread-cutting the work-piece is to be supported in any case by a lathe center.
4.3.4 Edit (F4)

By pressing the key F4 you enter the "Edit" program. In Edit you can work in the same way as with the original CNC machine and set up NC programs according to standards (acc. to DIN 66025 and ISO 1056). For an exact description see chapter 6 "EDIT".

Machining possibilities
(Survey)

Workpiece data

CAD (design on screen)

EDIT
(determine machining with CNC program acc. to DIN 66025 and ISO 1056)

| N0000/G67/F3 |
| N0010/G94/T200/T01 |
| N0020/G50/X20/Z1 |
| N0030/G84/X16.1/Z-44.8/R3.800/F180 |
| N0040/G80/X16.1/Z1 |
| N0050/G84/X12.1/Z-24.8/R3.800/F180 |
| N0060/G50/X12/Z1 |
| N0070/G01/Z2.5 |
| N0080/G01/X16 |
| N0090/G01/Z-45 |
| N0100/G01/X20 |
| N0110/G00/X40/Z20 |
| N0120/M30 |

Ref. 1: The machining process (CAM) determined graphically can be transformed into NC programs and changed there (in the editor).

Ref. 2: The NC-program entered in the screen is transformed by pressing a key and is simulated automatically on the screen. The machining process determined in the editor can also be changed graphically again and in the following be executed on the lathe.
4.3.5 Tool change (F5)

Tool change during the compilation of the machining program

Procedure
- Move the current tool to a tool change position (with F1 = rapid)
- Press F6, a tool range appears on the screen.
  - Select the tool (e.g., 3)
  - The machining program to be compiled can be continued with the new tool after the tool change.
  - The travelling movements of the new (active) tool are shown in light blue, those of the old tool in dark blue.

Tool change during the processing of a machining program

The machining program remains on the machine during the processing and automatically stops before the tool change on the PC (= intermediate stop).

1. Carry out the tool change on the PC
2. Press F6
3. Enter the desired tool number and confirm with Enter
4. Carry out the tool change on the machine
5. Change the tool by hand
6. Select the menu setup and re-synchronize the machine - PC
7. Select automatic
8. Press enter

4.3.6 Erasing the last movement (F6)

The previously entered movement is erased, when the key F7 is pressed.

4.3.7 Erasing the machining program (F7)

The complete program is erased.

4.3.8 Entering the feed values (F8)

The set feed value for F2 (= moving with feed speed) can be altered, when the key F8 is pressed.

<table>
<thead>
<tr>
<th>Screen message</th>
<th>Entry</th>
</tr>
</thead>
<tbody>
<tr>
<td>Feed = 30 (ENTER = no change)</td>
<td>40</td>
</tr>
</tbody>
</table>

4.3.9 Change feed unit (F9)

A feed value can be entered in two different units:
- in mm/min (= G94)
- in μm/r (= G95)

\[ F \text{ (mm/min) } = \frac{F \text{ (mm/r) } \times 5}{r \text{ (r/min)}} \]

By pressing the F9 key the feed unit on the screen changes. The adjusted nominal value remains the same.

Example:
- \( F = 80 \text{ mm/min} \): The cutting tool travels 80 mm in one minute, no matter how often the workpiece turns.
- \( F = 80 \text{ μm/r} \): The cutting tool travels 0.08 mm during one workpiece revolution.

At a speed of e.g. 200 rpm there is a feed of \( 0.08 \text{ mm} \times 200 \text{ rpm} = 16 \text{ mm/min} \).

4.3.10 Entering the finishing offsets in X and Z (F10)

The set finishing offsets can be altered, when the key F10 is pressed.

Note
The entry of the finishing offset in the X direction refers to the radius of the work piece.

<table>
<thead>
<tr>
<th>Screen message</th>
<th>Entry</th>
</tr>
</thead>
<tbody>
<tr>
<td>Offset in X, Z = 0.160, 0.200 (ENTER = no change)</td>
<td>0.05, 0.1</td>
</tr>
</tbody>
</table>
4.4 DISPLAY (F4)

The screen display is determined or altered in this menu:

<p>| | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>DISPLAY</td>
<td></td>
</tr>
<tr>
<td>F1</td>
<td>ZOOM ALL</td>
</tr>
<tr>
<td>F2</td>
<td>ZOOM WINDW</td>
</tr>
<tr>
<td>F3</td>
<td>ZOOM PIECE</td>
</tr>
<tr>
<td>F4</td>
<td>HEAD STOCK</td>
</tr>
<tr>
<td>F5</td>
<td>WORK PIECE</td>
</tr>
<tr>
<td>F6</td>
<td>TOOL</td>
</tr>
<tr>
<td>F7</td>
<td>TOOL PATH</td>
</tr>
<tr>
<td>F8</td>
<td>TAIL STOCK</td>
</tr>
<tr>
<td>F9</td>
<td>CHANGE SIM</td>
</tr>
<tr>
<td>F10</td>
<td></td>
</tr>
</tbody>
</table>

### 4.4.1 Zoom all (F1)

Everything shown on the screen (head stock, work piece, work piece contour, ...) is enlarged, so that it can still be displayed within the screen.

[F3] → The complete screen area is enlarged.

### 4.4.2 Zoom window (F2)

A “screen window” is defined and enlarged across the whole of the screen area.

Two diagonal bits are determined with the cursor keys and ENTER. The right-hand bit defined in this way is then enlarged across the whole of the screen surface.

Example

```

Screen message

Position cursor. ENTER = starting point:

Move the cursor to the 1st bit point (X = 3 / Z = -4 mm).

Move cursor. ENTER = accept position:

Move the cursor to the 2nd diagonal bit point (X = 10 / Z = 17 mm).
```

---

92
4.4.3 Zoom work piece (F3)
The work piece shown on the screen is enlarged, so that it is still shown within the screen, when the key F3 is pressed.

4.4.5 Removing, inserting the work piece (F5)
The work piece shown on the screen can be removed with the key F5.
The work piece can be re-inserted, when F5 is pressed again.

4.4.4 Removing, inserting the head stock (F4)
The head stock shown on the screen can be removed with the key F4.
The head stock is re-inserted, when F4 is pressed again.

4.4.6 Removing, inserting the tool (F6)
The tool shown on the screen can be removed with the key F6.
The tool is re-inserted, when F6 is pressed again.
4.4.7 Removing, inserting the tool path (F7)
The tool path shown on the screen can be removed with the key F7.
The tool path is re-inserted, when F7 is pressed again.

4.4.8 Inserting, removing the tail stock (F8)
The tail stock can be inserted on the screen with the key F8.
The tail stock is removed again, when F8 is pressed again.

4.4.9 Changing the simulation display (F9)
You can select two simulation displays with the key F9.
1. Displaying the tool path
   (= basic setting)

2. Simulating the cutting
### 4.4.10 Hotkeys - machine

You can move the slides and influence the machining cycles by means of these keys.

<table>
<thead>
<tr>
<th>Key</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>↑</td>
<td>Move the slides in the -X direction</td>
</tr>
<tr>
<td>↓</td>
<td>Move the slides in the +X direction</td>
</tr>
<tr>
<td>←</td>
<td>Move the slides in the -Z direction</td>
</tr>
<tr>
<td>→</td>
<td>Move the slides in the +Z direction</td>
</tr>
<tr>
<td>Equal</td>
<td>Enlarge the travel path of the stepping motors</td>
</tr>
<tr>
<td>Plus</td>
<td>Reduce the travel path of the stepping motors</td>
</tr>
<tr>
<td>&gt;</td>
<td>Increase the feed</td>
</tr>
<tr>
<td>&lt;</td>
<td>Reduce the feed</td>
</tr>
<tr>
<td>Space bar</td>
<td>Stop the slides ( = intermediate stop)</td>
</tr>
<tr>
<td>Esc</td>
<td>Interrupt the machining</td>
</tr>
</tbody>
</table>

#### Travel path of the stepping motors

<table>
<thead>
<tr>
<th>Travel path in mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>10 mm ( = largest travel path)</td>
</tr>
<tr>
<td>5 mm</td>
</tr>
<tr>
<td>1 mm ( = switch-on condition)</td>
</tr>
<tr>
<td>0.5 mm</td>
</tr>
<tr>
<td>0.1 mm</td>
</tr>
<tr>
<td>0.05 mm</td>
</tr>
<tr>
<td>0.01 mm ( = smallest travel path)</td>
</tr>
</tbody>
</table>

#### Altering the programmed feed

<table>
<thead>
<tr>
<th>Feed alteration</th>
<th>Percentage</th>
</tr>
</thead>
<tbody>
<tr>
<td>&gt; &gt; &gt;</td>
<td>200 %</td>
</tr>
<tr>
<td>&gt; &gt; &gt;</td>
<td>150 %</td>
</tr>
<tr>
<td>&gt; &gt; &gt;</td>
<td>120 %</td>
</tr>
<tr>
<td>&gt; &gt; &gt;</td>
<td>100 % ( = switch-on condition)</td>
</tr>
<tr>
<td>&lt; &lt; &lt; &lt;</td>
<td>80 %</td>
</tr>
<tr>
<td>&lt; &lt; &lt; &lt;</td>
<td>60 %</td>
</tr>
<tr>
<td>&lt; &lt; &lt; &lt;</td>
<td>50 %</td>
</tr>
<tr>
<td>&lt; &lt; &lt; &lt;</td>
<td>40 %</td>
</tr>
<tr>
<td>&lt; &lt; &lt; &lt;</td>
<td>30 %</td>
</tr>
<tr>
<td>&lt; &lt; &lt; &lt;</td>
<td>20 %</td>
</tr>
<tr>
<td>&lt; &lt; &lt; &lt;</td>
<td>10 %</td>
</tr>
<tr>
<td>&lt; &lt; &lt; &lt;</td>
<td>5 %</td>
</tr>
<tr>
<td>&lt; &lt; &lt; &lt;</td>
<td>0 %</td>
</tr>
</tbody>
</table>
4.5 Set up 0,0 (F5)

The measuring system of the machine and the PC must be synchronized with one another. This is carried out with the "scratching" (on the diameter and the length) of the clamped work piece.

Note
You must synchronize the machine and PC, before you select the menu points MANUAL or MACHINE.

Procedure
- Press F5
- Switch on the main spindle
- Move the tool with the arrow keys (see hotkeys - machine) to the diameter of the clamped work piece (in rapid) and "scratch" the work piece.

Note
In order to position the work piece exactly, you must reduce the step size with the key.

- After reaching the desired diameter, press the enter key.
- Enter the X value (diameter values) of the work piece and confirm it.
- Move the tool with the arrow keys to the face of the clamped work piece and "scratch" the face of the work piece.

Note
In order to position the tool exactly, you must reduce the step size with the key.

- After reaching the desired length, press enter.
- Enter the Z value (length) of the work piece.

- The measuring system of the machine and PC is now synchronized. You can process your compiled machining program on the machine.

Example
Workpiece Ø 20 mm, length = 100 mm

Screen message

Tool with ↑↓ to the diameter aligning pos.
Step = 1.00 (ENTER = end):

Move the tool to the diameter and reduce the step size with , until the tool is positioned exactly on the aligning diameter.

Input diameter for this tool position:

20

Tool with ↑↓ to the length aligning pos.
Step = 1.00 (ENTER = end)

Move the tool to the aligning length and reduce the step size with , until the tool is positioned exactly on the length of the work piece.

Input Z value for this tool position

100
4.6 Manual (F6)

Moving the machine in "manual mode". You can move the tool in rapid on the machine and screen at the same time by means of the arrow keys (see hotkeys - machine).

Condition
The machine was aligning (menu aligning).

Procedure

F6

Screen message

Move the tool with the cursor keys, step = 1.00:

Move the tool. The step size can be altered with pgdn or pgup.

The respective position of the tool is displayed on the screen.
4.7 Machine (F7)

Processing the compiled machining program on the machine

Condition
The machine was aligning (menu aligning).

<table>
<thead>
<tr>
<th>MACHINE</th>
</tr>
</thead>
<tbody>
<tr>
<td>F1</td>
</tr>
<tr>
<td>F2</td>
</tr>
<tr>
<td>F3</td>
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<td>F6</td>
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<td>F7</td>
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<tr>
<td>F8</td>
</tr>
<tr>
<td>F9</td>
</tr>
<tr>
<td>F10</td>
</tr>
</tbody>
</table>

4.7.1 Automatic (F1)

The machining program compiled on the program menu is processed automatically.

Affecting the machining

- > ..... Increasing the feed
- < ..... Reducing the feed
- Space bar ..... Intermediate stop, the slides stop
- Esc ..... Interruption of the machining

4.7.2 Single (F2)

The machining program is processed in blocks. Every program block must be confirmed with the enter key before the processing.

You exit from this menu point with the Esc key.

4.7.3 Fast run (F3)

The complete machining program is automatically processed in the rapid.

Application
Testing a machining program without a work piece

4.7.4 Empty cut step (F4)

Move to the desired machining step with the arrow key. The machining program can be started from this block.

Procedure

Position at desired program steps with + ↑ keys (ENTER = end):

Possibilities

- ↑ ..... Searching block by block from the start of the program
- ↓ ..... Searching block by block from the end of the program
- → ..... Return block by block
- ← ..... Forwards block by block
- Esc ..... Confirm the desired block

The machining program can be started from this desired block.
(Automatic, single or fast run)

Application
Re-machining of certain contour parts

E.g., finishing the fit on a tool with overmeasure. Measure the fit on the clamped tool after the machining.
Move to the fit with "F4 empty cut step".
Process the required differential measure in Single in the X direction with "F7 shift program".
4.7.5 Repeating the program (F5)

Unit: [mm]
A machining program can be shifted in the X and Z direction (X = radius dimension) and be repeated. The number of the steps determines how often the machining program is to be shifted and repeated.

Application
Finishing several, similar parts from one work piece

Procedure
Screen message
Shift program in X, Z:
0, -43

Number of steps:
1

4.7.6 Moving the tool to the cursor (F6)

The tool is moved from its present position to the cursor position with the set feed, whereby the machine moves along the same movement.

This movement is not copied into the machining program.

4.7.7 Shifting the program (F7)

Unit: [mm]
A machining program can be shifted in the X and Z direction (X = radius measurement).

Application
Re-turning the work piece contour

4.7.8 Altering the scale program (F8)

A machining program can be enlarged or reduced. The altered scale is assumed as the new scale M1:1 after the enlargement or reduction.

Examples:
Reduction
Input: 0.5 = M1:2

Enlargement
Input: 2 = M2:1

Procedure
Screen message
Input factor for increasing program size:
2

Attention!
Observe the size of your work piece, if you alter the machining program in the scale.
4.8 Archive (F8)

The programs compiled by you are stored or recalled in this menu.

Drawings created by you or machining programs must be stored as files before leaving the program.

4.8.1 Storing the program (PRG) (F1)

<table>
<thead>
<tr>
<th>Screen message</th>
<th>Entry</th>
</tr>
</thead>
<tbody>
<tr>
<td>Input file name to be stored:</td>
<td>demo1</td>
</tr>
</tbody>
</table>

The machining program is stored under the name "demo1".

In the sub directory (e.g. COMPACT) a program is stored in two files:

DEMO1.GEO
DEMO1.NCP

DEMO1 is the name you have choosen (max. 8 signs) and an automatic addition (.GEO resp. NCP).

.GEO in this file there are the informations about workpiece, drawing (CAD) and tool path (CAM).

.NCP in this file the NC-program is stored.

4.8.2 Loading the program (PRG) (F2)

A stored machining program can be recalled.

Example 1: Call-up of a program

<table>
<thead>
<tr>
<th>Screen message</th>
<th>Entry</th>
</tr>
</thead>
<tbody>
<tr>
<td>F2</td>
<td></td>
</tr>
</tbody>
</table>

Input file name to be retrieved: demo1

The machining program "demo 1" is loaded.

Example 2: Listing all stored programs

All stored programs are displayed in the area menu display, when the sign * is entered.

<table>
<thead>
<tr>
<th>Screen message</th>
<th>Entry</th>
</tr>
</thead>
<tbody>
<tr>
<td>F2</td>
<td></td>
</tr>
</tbody>
</table>

Input file name to be retrieved: *

The stored programs are displayed and can be selected by means of the keys and recalled with .
4.8.3 Storing the geometry (GEO) (F3)

A work piece drawing can be stored.

<table>
<thead>
<tr>
<th>Screen message</th>
<th>Entry</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>F3</td>
</tr>
</tbody>
</table>

Input file name to be stored: part 1

The work piece drawing is stored under the name "part 1".

The work piece geometries are stored under the name entered by you in your sub-directory (e.g.: COMPACT) and are automatically provided with the suffix .DXF.
The suffix .DXF means that the work piece geometries are stored in the DFX format. i.e.: you can read AUTOCAD drawings in the DFX format into this software or work piece geometries created with this software can be copied into the AUTOCAD software.

4.8.4 Loading the geometry (GEO) (F4)

A stored work piece drawing can be recalled.

<table>
<thead>
<tr>
<th>Screen message</th>
<th>Entry</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>F4</td>
</tr>
</tbody>
</table>

Input file name to be retrieved: part 1

The work piece drawing "part 1" is loaded.

Listing all stored work piece drawings works as with programs (chapter 4.8.2).

Erasing the stored programs and geometries

- Exit the software (remain in the sub-directory COMPACT).
- All files in the sub-directory COMPACT are listed by means of the DOS command "DIR".
- Erasing the respective file (see DOS manual)

4.9 Print (F9)

The respective screen display is printed.

Condition
The printer is connected, switched on and set in the IBM graphics mode (see printer manual).

<table>
<thead>
<tr>
<th>Screen message</th>
<th>Entry</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>F9</td>
</tr>
</tbody>
</table>

Is the printer connected and on "line"? (ENTER = yes)

Possibilities
ENTER = printing
Any other key = interruption

4.10 End (F10)

Exit from the program

Attention!
You must store the programs compiled by you beforehand (archive menu).

<table>
<thead>
<tr>
<th>Screen message</th>
<th>Entry</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>F10</td>
</tr>
</tbody>
</table>

Are you sure? (ENTER = yes)

Possibilities
ENTER = exit from the program
Any other key = remaining in the program

The title screen appears again:

... Return to DOS
5. SPECIMEN EXAMPLES

Chess figures

These specimen examples serve to re-inforce the knowledge acquired concerning the programming of this EMCO software.

The creation of the contour of these examples is explained step by step on the following pages.

We recommend you to use aluminium and brass with a diameter of 20 and a length of 50-70 mm for the chess figures due to chip removal reasons.

You will find the technological data, like
- max. main spindle speeds
- max. feed
- max. cutting depths
in chapter A "machine description".

The figures are designed in such a way that the back-off cycles can be worked off with the right lateral steel.

When preparing the program it is advantageous to execute the roughing cycle at the extreme right as last processing cycle. Thus workpieces can be supported with the lathe center until the last working cycle.

The lathe center has to be removed in time in the last working cycle to avoid a collision with the tool.
Pawn

1. Creating a work piece
(See work piece (F1))
Ø = 20 mm, length = 52 mm, center hole = 4,5

Drawing aid
The work piece is enlarged across the whole of the screen surface by means of the hotkey [z].

2. Drawing the work piece contour
(See submenu point, line/hotkeys)
Note
Only the lower half of the work piece contour must be drawn.

3. Adding the radii and chamfers

4. Cleaning

5. Spliiting the arc (F4)

6. Adding the visible edges (F5)

7. Mirroring the work piece contour (F6)

<table>
<thead>
<tr>
<th>Contour points</th>
<th>X direction</th>
<th>Z direction</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
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</tr>
<tr>
<td>8</td>
<td>10</td>
<td>-37</td>
</tr>
</tbody>
</table>

8. Storing the work piece contour
(See ARCHIVE (F8))
1. Creating a work piece
(See work piece (F1))
\( \phi = 20 \) mm, length = 85 mm, center hole = 4.5

Drawing aid
The work piece is enlarged across the whole of the screen surface by means of the hotkey 2.

2. Drawing the work piece contour
(See submenu point, line/hotkeys)
Note
Only the lower half of the work piece contour must be drawn.

<table>
<thead>
<tr>
<th>Contour points</th>
<th>X direction</th>
<th>Z direction</th>
</tr>
</thead>
<tbody>
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</tr>
<tr>
<td>14</td>
<td>10</td>
<td>-65</td>
</tr>
</tbody>
</table>

3. Cleaning

4. Adding the radii and chamfers

5. Splitting the arc (F4)

6. Adding the visible edges (F5)

7. Mirroring the work piece contour (F6)

8. Storing the work piece contour
(See ARCHIVE (F8))
1. Creating a work piece
(See work piece (F1))
Θ = 20 mm, length = 87 mm, center hole = 4,5

Drawing aid
The work piece is enlarged across the whole of the screen surface by means of the hotkey $\text{Z}$. 

2. Drawing the work piece contour
(See submenu point, line/ hotkeys)
Note
Only the lower half of the work piece contour must be drawn.

<table>
<thead>
<tr>
<th>Contour points</th>
<th>X direction</th>
<th>Z direction</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
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<tr>
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<tr>
<td>19</td>
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</tbody>
</table>

3. Cleaning

4. Adding the radii and chamfers

5. Adding the visible edges (F5)

6. Mirroring the work piece contour (F6)

7. Storing the work piece contour
(See ARCHIVE (F8))
King

1. Creating a work piece
(See work piece (F1))
\( \Theta = 20 \text{ mm}, \text{length} = 90 \text{ mm}, \text{center hole} = 4,5 \)

Drawing aid
The work piece is enlarged across the whole of the screen surface by means of the hotkey \( \text{Z} \).

2. Drawing the work piece contour
(See submenu point, line/hotkeys)
Note
Only the lower half of the work piece contour must be drawn.

<table>
<thead>
<tr>
<th>Contour points</th>
<th>X direction</th>
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<td>-66</td>
</tr>
<tr>
<td>15</td>
<td>10</td>
<td>-72</td>
</tr>
</tbody>
</table>

3. Adding the radii and chamfers

4. Adding the visible edges (F5)

5. Mirroring the work piece contour (F6)

6. Storing the work piece contour
(See ARCHIVE (F8))
1. Creating a work piece
   (See page work piece (F1))
   Ø = 20 mm, length = 65 mm, center hole 8.5, 5
   Drawing aid
   The work piece is enlarged across the whole of the
   screen surface by means of the hotkey [Z].

2. Drawing the work piece contour
   (See submenu point, line/hotkeys)
   Note
   Only the lower half of the work piece contour
   must be drawn.

<table>
<thead>
<tr>
<th>Contour points</th>
<th>X direction</th>
<th>Z direction</th>
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</tbody>
</table>

3. Adding the radii and chamfers

4. Adding the visible edges (F5)

5. Mirroring the work piece contour (F6)

6. Storing the work piece contour (See ARCHIVE (F8))

Note on inside turning

- Since inside turning is carried out in over-
  mounted form (without center punch support), feed (F) and advance should be as
  small as possible.
  F = approx. 20 mm/min
  Advance approx. 0.2 mm

- For inside turning of small diameters the inside cutting tool has to be set obliquely to
  avoid collisions (A). However, mind in any case that a clearance angle remains behind the
  tool tip to guarantee a perfect cut.
Knight

1. Creating a work piece
(See work piece (F11))
\( \Omega = 20 \text{ mm, length} = 80 \text{ mm, center hole} = 4.5 \)

Drawing aid
The work piece is enlarged across the whole of the screen surface by means of the hotkey [2].

2. Drawing the work piece contour
(See submenu point, line/hotkeys)
Note
Only the lower half of the work piece contour must be drawn.

<table>
<thead>
<tr>
<th>Contour points</th>
<th>X direction</th>
<th>Z direction</th>
</tr>
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<tbody>
<tr>
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</tr>
</tbody>
</table>

3. Adding the radii and chamfers

4. Adding the visible edges (F5)

5. Mirroring the work piece contour (F6)

6. Storing the work piece contour
(See ARCHIVE (F8))

Extension for the knight

Working with the vertical equipment
Tool: roughing mill \( \Omega 8 \text{ mm} \)
6. EDIT

Introduction

With the COMPACT 5 PC software you have not only an efficient CAD/CAM software, but you can also work like at a normal CNC machine and set up standard (DIN 66025 and ISO 1056) NC programs.

Explanation of term EDIT
The procedure of entering data (numbers and letters) into a PC or in a control is also called edit.

Example:
An NC program is entered into the computer (edited). This is carried out in a certain part of the COMPACT 5 PC software, the EDIT. EDIT = mode for program input.

What is programming
Programming = communicating data in a settled sequence and language which the computer can understand and transform. The NC-programming language and the NC-program structure was determined by experts in DIN 66025 and ISO 1056.

Setting up an NC-program
When you are setting up an NC-program you have to give exactly the same information and instructions to the computer as are needed by someone for machining a workpiece on a hand-operating machine who has no idea of turning.

This information is:
1. Geometrical data
   You find these geometrical data (dimensions) on the drawing of the workpiece.
2. Technological data
   Feed, spindle speeds, tools, etc.
3. Machine functions
   These are described in this chapter (see G, M-functions)
4. Program instructions
   When setting up an NC program certain instructions on sequences of commands (see G, M-functions) have to be adhered to.

[Diagram of NC-program flowchart]
Geometrical Data

Coordinate system
The information "move longitudinal slide in direction headstock" is a very long one. Besides that, in each language it would be different. That’s why the traverse path movements with machine tools are described within the coordinate system.

Lettering of drawing
The geometrical information is in the technical drawing. Drawings can be done according to the incremental or to the absolute system. In many cases you find a combination of these two systems: incremental and absolute.

Absolute system
There is one point of reference.

Incremental system
Each measurement is based on the previous one.

Combined system
The measurements 1 and 2 are absolute ones, i.e., based on one point of reference. The measurements 3 and 4 are incremental ones.

Methods of programming
In the program you have describe in each block the path of the turning tool. Basically there are two methods to describe this path.

1. Absolute value programming:
The points which the turning tool has to approach are indicated by a zero point with X and Z. The X value is a diameter value.

2. Incremental dimension programming:
Here the incremental dimensions are entered with U and W. The initial point for each path description is the actual position of the turning tool. The U value is a radius value.
The zero point of the workpiece = reference point
The reference point (R) is on the Z axis at the right
blank edge.

Attention:
A new blank has to be set up before editing an
NC-program.
Reason:
Otherwise all the values entered into the NC
program do not refer to the reference point (R)
but to the machine zero point (M).

Technological Data

The feed (F)
The feed can be programmed in mm/min or in
micr (=μm/r). For further information see
chapter G94/G95.

Tool programming (T)
The call-up of tools and the tool change are
programmed with the letter T and a two-digit number
  e.g. T01
The T is the abbreviation of the English word
"Tool".
The two-digit number indicates the tool number.

Tool number:
T01  right side tool
T02  neutral side tool
T03  left side tool
T04  parting-off tool
T05  cut-in tool for locking rings
T06  left thread-cutting tool
T07  right thread-cutting tool
T08  inside boring tool
T09  inside cut-in tool for locking rings
T10  right inside thread-cutting tool
T11  left inside thread-cutting tool
T12  not occupied

Note
A G00 (rapid motion) has to be programmed as
next travel motion after each new tool call-up.
Possibility 1:  in the same block
      N .../T02/G00/X .../Z ....
Possibility 2:  in the next block
      N .../T02
      N .../G00/X .../Z ....
Program Structure

Parts of the NC program

1. The program
All essential data for the manufacture of a work piece are filled in.
The structure of such a program is standardized.

| N0000/G67/Z3 | N0100/G94/F150/101 |
| N0200/G00/X25/Z2 | N0300/G01/Z2/F100 |
| N0400/G84/X16Z-100/O2 = 500/F100 | N0500/G00/X35/Z10 |
| N0600/G56 | N0700/M30 |

2. The block
The program consists of blocks. A block contains all data necessary to execute an operation.

| N0300 / G01 / X21 / Z1 / F100 |
| Word | Word | Word | Word |
| Block |

3. The word
Each block consists of various words. Each word has a special meaning.
A word consists of a letter and a combination of numbers. The letter is called address.

| G01 | Word |
| Adress | Combination of numbers |

The words of the Compact 5 PC

N:
N indicates the block number. Practicable block numbers are N0000 up to N9999. It is appropriate to number the program blocks in steps of tens.

G:
G is a symbol for the path information. Each figure is allocated to a certain kind of motion. e.g.
G01 = move in straight line 03 move in circle, etc.

X:
X means indication of the absolute position of the X axis. The numerical value may have the operational sign " + " or " - " (X = diameter value).
Input: mm

Z:
Z means absolute indication of the position of the Z axis. The numerical value may have the operational sign " + " or " - ".
Input: mm

U:
U means incremental indication of the position of the X axis. The numerical value may have the operational sign " + " or " - " (U = radius value).
Input: mm

W:
W means incremental indication of the position of the Z axis. The numerical value may have the operational sign " + " or " - ".
Input: mm

Note: The addresses X, Z, U, W can also be programmed mixed in one block.

I:
I means an incremental path indication in direction X with circle movements (G02/G03). I is an auxiliary indication for the calculation of the circular traverse motion. The numerical value may have the operational sign " + " or " - ".
Input: mm

K:
K means an incremental path indication in direction Z at with circle movements (G02/G03). K is an auxiliary indication for the calculation of the circular traverse motion. The numerical value may have the operational sign " + " or " - ".
Input: mm

F:
Under the F address different information can be programmed:
1. F in connection with G94:
   Under the F-address the feed is programmed in mm/min.
2. F in connection with G95:
   Under the F-address the feed is programmed in µm/min.
3. F in connection with G85:
   Under the F-address the thread pitch is programmed in µm/min.
4. F in connection with G67:
   Under the F-address the colour of the tool path is determined (for graphic simulation).

T:
With T a certain tool can be called up. Possible tool addresses are T01 up to T11

M:
M is the abbreviation of the English word "miscellaneous". Switching and additional functions are determined with M.
Note: On the Compact 5 PC only M30-program end can be programmed.
On industrial machines functions such as e.g. "COOLANT ON/OFF", CLAMPING DEVICE OPEN/CLOSE" are programmed with M-functions.
The parameters of the Compact 5 PC

With the parameters P and D additional information for working off the cycles (G84, G85, G86) are communicated to the PC.

e.g. with G84 a cone can be programmed with P9 in \( \pm \) X direction.

The D-parameters must be entered in each case. The P-parameters have to be programmed only if the value is not 0.

Survey of G and M functions

G00 Rapid motion
G01 Feed motion (straight line interpolation)
G02 Circle interpolation in clockwise direction
G03 Circle interpolation in counterclockwise direction
G05 Deselection of reference point offset
G07 Call-up of reference point offset
G08 Indicate colour of tool path
G09 Longitudinal turning and facing cycle
G84 Thread cycle
G85 Cut-in cycle
G90 Reference point offset
G94 Feed speed in mm/min
G95 Feed speed in \( \mu \)m/r

M30 Program end

Self-holding functions, words

* G and M functions and also other words are self-holding. That means that they are active until they are overwritten or selected.

Example:
N100/
N110/G00/X50.000/Z220.000
N120/X40.000/Z18.000
N130/G01/X30.000/Z15.000/F100
N140/...

Explanation:
G00 is also effective in block 120 and is overwritten with G01 in block 130.

* X(U), Z(W), F, T word contents are taken over in the following blocks:

Example:
N200/
N210/G01/X40.000/Z25.000/F120
N220/Z12.000
N230/G00/X35.000/Z32.000
N240/...

Explanation:
In block 220 G01, X = 40 and F120 is effective. F120 remains effective until another value is programmed under the F address.

Specifications on the sequence of words:

Apart from the X(U), Z(W) sequence in the cycle G84 there is no absolute rule on the word sequence. However, so as to obtain a clear program structure, you should observe the following sequence:

* Each block starts with the block number N.
* The G-function should be programmed after the block number.
* Words for the coordinates X(U), Z(W). Observe the reversal of the X(U), Z(W) sequence in the cycle G84.
* Where G02, G03 is programmed, the interpolation parameter \( I, K \) should be programmed after X(U), Z(W).
* Where cycles are programmed, the parameters should be programmed after the X(U), Z(W) addresses.
* The F-word (feed thread pitch).
* The T-word (tool address).
* The M-word (additional functions).
G-Codes, their formats and description of formats

Specific addresses are assigned to most G-codes.

Example:
G00/X±.../Z±...
or
G01/X±.../Z±.../F...
For a short and easy to understand description of pertaining addresses (format description) the data are encoded.

Code:
1) Instead of giving the possible inputs, the number of decades is given.
   Example:
   Instead: N from 0 to 9999
   or N... we write N4.
   \[ N_{\ldots} \rightarrow N4 \]

2) The specification of the possible decades before or after a decimal point is coded with two figures.
   \[ X_{\ldots} \rightarrow X43 \]
   The first figure: Decade before decimal point
   The second figure: Decade after decimal point

3) If the values could be negative or positive a ± sign is written between address and number.
   \[ X \pm 43 \]
   Remark: For better determination quite often a ± sign is written (X ± 43). Underneath the input format there are the different dimensions shown.

Example:

\[
\begin{array}{|c|c|c|c|}
\hline
\text{N4} & \text{G01} & \text{X±43} & \text{Z±43} & \text{F4} \\
\text{[mm]} & \text{[mm]} & \text{[mm/min]} & \text{[mm/min]} & \text{[mm/min]} \\
\hline
\end{array}
\]

N4: four digits without decimal point and sign

X, Z, U, W: ± sign possible, four digits before decimal point, three digits after decimal point

F4: four digits without decimal point and sign

Guidelines for working in EDIT

On the following pages you can find the description of the functions with which you are able to set up NC programs.

The G functions are arranged in rising order (G00 up to G95). If you are learning this kind of programming you should mind the following:

1. Guideline for program start and program end:

Program start:
G67/F → determine colour of tool path
G94(G95) → feed in mm/min or μm/r
F → feed programming
T → tool programming
G00 → rapid motion
After each tool call-up the 1st traverse movement must be a G00 block.

Program end:
M30 → means end of program. M30 don’t have to be programmed at this software.

2. Sequence for beginners for learning how to program:

G67 determine colour of the tool path
T tool programming
F feed programming
G94/G95 feed in μm/r, mm/min
G00 rapid motion
G01 feed movement
G84 longitudinal turning cycle
G84 facing cycle
G86 cut-in cycle
G85 threading cycle
G02/G03 circular interpolation
G92/G59
G56 offset position

Also study all the exercises for the individual G-functions. These are set up in such a way that you are introduced to programming step by step.

For the G-functions there is a specific summary. This is framed in grey and serves also as a short description.
G00 - Rapid motion

Input format:

<table>
<thead>
<tr>
<th>N</th>
<th>G00</th>
<th>X</th>
<th>Z</th>
</tr>
</thead>
<tbody>
<tr>
<td>4</td>
<td></td>
<td>±43</td>
<td>±43</td>
</tr>
</tbody>
</table>

- N ...... Block number
- G00 .... Rapid motion
- X(U)  Absolute (incremental) coordinates
- Z(W)  of the target point Z

The positioning of the turning tools, i.e. movement of same without chip removal, must be done with highest possible speeds (rapid motion) for economic reasons.

The slides move simultaneously in X and Z direction.

Rapid motion speed:
- PC/AT: 700 mm/min
- PC/XT: 350 mm/min

G00 (rapid motion) is merely a traversing movement - no working movement!

Notes:
- It does not matter in which sequence X (U), Z (W) are written.
- They can also be programmed mixed in one block (absolute and incremental)
  e.g.: G00/X44.000/W-9.000

Example:

absolute:  N...G00/X30/Z2
incremental: N...G00/U-6/W-9
**G01 - Straight line interpolation**

**Input format:**

<table>
<thead>
<tr>
<th>N</th>
<th>G01</th>
<th>Z</th>
<th>F</th>
</tr>
</thead>
<tbody>
<tr>
<td>4</td>
<td></td>
<td>43</td>
<td>4</td>
</tr>
</tbody>
</table>

- **N**: Block number
- **G01**: Straight line interpolation
- **X(U)**: Absolute (incremental) coordinates of the target point Z
- **Z(W)**: Feed

G01 is a linear operating movement. The feed must be programmed. It can be input in [mm/min] (G94) or in [μm/min] (G95). The feed (F) is self-holding.

- **X**: diameter value
- **U**: radius value

**Possibilities of G01:**

1. **Turning in Z direction (longitudinal turning)**
   - Longitudinal turning with defined feed speed. The X movement is zero. No value is entered for X (U).

   ![Diagram](image1)

   N. JG01-Z (-W/F).

2. **Turning in direction X (facing)**
   - Facing with defined feed speed. The Z movement is zero. No value is entered for Z(W).

   ![Diagram](image2)

3. **Turning in X and Z direction (taper turning)**
   - With taper turning, longitudinal and lateral slides must move simultaneously. In accordance with the taper angle, the slides have to traverse at a certain ratio. The computer (PC) calculates a lot of intermediate values referring to this straight line and transmits the respective traverse commands to the slides.

   ![Diagram](image3)

   This finding of intermediate values of a straight line is called straight line interpolation.

   The straight line can have any angular position. With longitudinal turning and facing no interpolation takes place.

**Example:**

![Diagram](image4)

- **absolute:**
  - N100:
  - N110:G00/U22/22
  - N120:G00/X18
  - N130:G01/Z50/F
  - N140:G01/X20/Z-52/F...
  - N150:G00/X22/22
  - N160:

- **incremental:**
  - N100:
  - N110:G00:
  - N120:G00/X-2 (Radius)
  - N130:G01/W-52/F...
  - N140:G01/U1/W-2/F
  - N150:G00/Y/W4
  - N160:

116
1. General
- With circle turning longitudinal and lateral slide must move at the same time. In contrast to the straight line interpolation the ratio X:Z is changing continuously. The computer (PC) calculates a lot of intermediate values referring to the circular arc and transmits the respective traversing commands to the slides. This finding of intermediate values of a circle is called circle interpolation.
- In one block, arcs up to a maximum of 180° can be programmed.

2. G02/G03
- Rotation G02 clockwise
- Rotation G03 counterclockwise

3. Target point coordinates X,Z/U,W
With X, Z the target point (Z) of the circular arc is described (absolute) from the reference point (R). X is a diameter value.

With U, W the target point (Z) of the circular arc is described from the starting point (S) (incremental). U is a radius value.

---

**Block format:**

<table>
<thead>
<tr>
<th>N</th>
<th>G02</th>
<th>G03</th>
<th>X ± 43</th>
<th>Z ± 43</th>
<th>I ± 43</th>
<th>K ± 43</th>
<th>F ± 43</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td>[mm]</td>
<td>[mm]</td>
<td>[mm]</td>
<td>[mm]</td>
<td>[rpm]</td>
</tr>
</tbody>
</table>

N ....... Block number
G02... Arc interpolation clockwise
G03... Arc interpolation counterclockwise
X (U) ... Absolute (incremental) coordinates of the target point
Z (W) ... Arc centre point coordinates
I, K .... Feed
4. Coordinates of the center of the circle I, K

The computer knows the starting point (S) and the target point (Z) but not yet the value of the radius. Therefore the coordinates of the center of the circle are described (I, K).

Imagine the I, K system of coordinates in the center of the circular arc and describe from there the starting point of the circular arc.

The coordinates I, K are programmed always incremental.

Example 1

| absolute: | N...G03/X20/Z-35/A-S/K 0/F... |
| incremental: | N...G03/SW-S/50-S/K 0/F... |

Example 2

| absolute: | N...G02/X20/Z-43/A-I/K 3/F... |
| incremental: | N...G02/SW-S/30-S/K 3/F... |

Example 3

| absolute: | N...G03/Z-43.33/A-20/I/K 9.16/F... |
| incremental: | N...G03/SW-S/18.33/I-20/K 9.16/F... |
G56  Deactivation of the reference point offset

Input format:

N4 G56

Explanation see G92 "The reference point".

G59  Activation of the reference point offset

Input format:

N4 G59

Explanation see G92 "The reference point".

G67  Colour of the tool path

Input format:

N4 G67 F2

F....Colour code see table

For the simulation of your NC-program it is possible to change the colour of the tool path with G67.

The block with G67 has to be programmed before that block which describes the tool path. G67 is self-holding and can be used in the program as often you want.

When using a black-and-white screen (Herkules board) the function G67 is of no significance.

<table>
<thead>
<tr>
<th>Series 1: dark</th>
<th>Series 2: clear</th>
</tr>
</thead>
<tbody>
<tr>
<td>F0 black</td>
<td>F8 dark grey</td>
</tr>
<tr>
<td>F1 dark blue</td>
<td>F9 light blue</td>
</tr>
<tr>
<td>F2 dark green</td>
<td>F10 light green</td>
</tr>
<tr>
<td>F3 turquoise</td>
<td>F11 light blue</td>
</tr>
<tr>
<td>F4 dark red</td>
<td>F12 light red</td>
</tr>
<tr>
<td>F5 lilac</td>
<td>F13 violet</td>
</tr>
<tr>
<td>F6 orange</td>
<td>F14 yellow</td>
</tr>
<tr>
<td>F7 grey</td>
<td>F15 white</td>
</tr>
</tbody>
</table>

The colours can be a little different on each screen.

Example:
N... G67/F6
N... G00/X... ← orange tool path
N... G67/F14
N... G84/X.../Z... { yellow tool path

119
G84 - Longitudinal turning cycle

Input format:

<table>
<thead>
<tr>
<th>N</th>
<th>G84</th>
<th>X ± 43</th>
<th>Z ± 43</th>
<th>P0</th>
<th>P2</th>
<th>D3</th>
<th>F4</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>(mm)</td>
<td>(mm)</td>
<td>(mm)</td>
<td>(mm)</td>
<td>(µm)</td>
<td>(µm/r)</td>
</tr>
</tbody>
</table>

N ...... Block number
G84 ...... Longitudinal turning cycle
X(U) ...... Absolute (incremental) coordinates
Z(W) ...... of the contour corner point
P0 ...... Taper dimension in X (radius value)
P2 ...... Taper dimension in Z
D3 ...... Cut division
F ...... Feed

Cycle definition
A cycle is a movement sequence of the tool which consists of a series of individual movements.

- G00 Movement with rapid motion
- G01 Movement with programmed feed speed (F) in mm/min or µm/r.

A cycle always has a closed movement sequence: starting point (S) = final point (E)
The starting point (S) is approached in the block before G84.

Contour corner point (K)
The movement sequence of a cycle is defined by starting point (S) and contour corner point (K). In accordance with the position of S and K to each other there are four kinds of cycle that you get as a result.
K is described with X,Z absolute or with U,W starting from S (incremental).
Cut distribution ($D_3$)
Frequently, a cycle is worked off in several cuts. This is indicated with cut distribution $D_3$. The movement sequence consists of the steps 1 to 12.

Taper overmeasure ($P_0, P_2$)
A cycle can be produced with an additional taper overmeasure in X-direction ($P_0$) and (or) in Z-direction ($P_2$).

The taper overmeasures $P_0, P_2$ are programmed always incremental.

The input for taper overmeasure $P_0, P_2$ must be carried out in the feed direction. For the example drawn below $P_0$ and $P_2$ must be a negative value, otherwise alarm 31 is effected.

To obtain the same taper, a larger value has to be inserted if starting point $S$ is before the workpiece edge (right).

Example 1
Longitudinal turning cycle without cut distribution

Example 2
Longitudinal turning cycle with cut distribution

Example 3
Longitudinal turning cycle with cut distribution and taper overmeasures
G84 Face turning cycle

**Input format:**

<table>
<thead>
<tr>
<th>N</th>
<th>G84</th>
<th>Z</th>
<th>X</th>
<th>P1</th>
<th>P2</th>
<th>D3</th>
<th>S</th>
<th>F</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>±43</td>
<td>±43</td>
<td>±43</td>
<td>±43</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>[mm]</td>
<td>[mm]</td>
<td>[mm]</td>
<td>[mm]</td>
<td>[mm]</td>
<td>[mm]</td>
<td>[mm]</td>
<td>[mm]</td>
<td></td>
</tr>
</tbody>
</table>

N ....... Block number
G84 .... Face turning cycle
Z(W) .... Absolute (incremental) coordinates of the contour corner point (K)
P1 ....... Taper dimension in X (radius value)
P2 ....... Taper dimension in Z
D3 .... Cut distribution
F ....... Feed

If there is no P1 or P2, it need not be programmed.

**Difference between longitudinal turning and facing cycle:**

With the longitudinal turning cycle X(U) is programmed before Z(W) - thus the first movement is carried out in X-direction.

With the facing cycle Z(W) is programmed before X(U) - thus the first movement is carried out in Z-direction. As for the rest, longitudinal turning and facing cycle are similar.

**Example 1**

Facing cycle without cut distribution

```
K
1
S
```

absolute: N...G84/Z-1/X6/D3 1000/F80
incremental: N...G84/W-1/U-8/D3 1000/F80

**Example 2**

Facing cycle with cut distribution

```
K
1
S
```

absolute: N...G84/Z-2/X6/D3 600/F100
incremental: N...G84/W-2/U-8/D3 600/F100

Cut distribution D3 = 0,6mm (= 600μm)
3 x 0,6 mm ............ 1,8 mm
Rest (= finishing cut) .......... 0,2 mm
Total advance ........... 2 mm

**Example 3**

Facing cycle with cut distribution and taper overmeasures

```
K
1
S
```

absolute: N...G84/Z 3X10/P0,133/P2,1 12
          /D3 700/F80
incremental: N...G84/Z 3A6/P0,133/P2,1 12
             /D3 700/F80
G85 Thread cycle

Input format:

<table>
<thead>
<tr>
<th>N</th>
<th>G85</th>
<th>X (mm)</th>
<th>Z (mm)</th>
<th>P2 (mm)</th>
<th>D2 (mm)</th>
<th>D4 (mm)</th>
<th>F (mm)</th>
</tr>
</thead>
</table>

N ... Block number
G85 ... Thread cycle
X (U) ... Absolute (incremental) coordinates of the final thread point (K)
P2 ... Thread lead-out
D2 ... Cutting depth of the first cut
D4 ... Thread depth
F ... Pitch

Contour corner point (K)

The movement sequence of a cycle is defined by starting point (S) and contour corner point (K). In accordance with the position of S and K to each other there are four kinds of cycle that you get as a result.

K is described with X,Z absolute or with U,W starting from S (incremental).

External right-hand thread

External left-hand thread

Internal right-hand thread

Internal left-hand thread

Definition

A cycle is a movement sequence of the tool which consists of a series of individual movements.

- G00 Movement with rapid motion
- Movement with programmed pitch (F) in µm/r

A cycle always has a closed movement sequence: starting point (S) = final point (E)
The starting point (S) is approached in the block before G85.
Thread lead-in (A) - thread lead-out (P_z)

During start of thread-cutting the Z-slide has to be accelerated. At the end of the thread the Z-slide has to be decelerated. The thread pitch is not constant in the acceleration and deceleration phase. Therefore this phase must be placed outside the workpiece.

The starting point (S) has to be determined in such a way that there is a necessary thread lead-in (A) of approx. 3 to 4 mm.
For the thread lead-out (P_z) approx. 1 to 2 mm should be programmed. The threading tool moves out obliquely.

Thread depth (D_y)

You can find the thread depth for the turning tools used here in the tables of the chapter "thread-cutting".

Threading depth of the first cut (D_z)

A thread is always cut in several sequences. The first threading depth is programmed with D_z in μm.
The further threading depths are calculated by the computer in such a way that the chip cross-section remains constant.
The advance for the individual cuts is carried out in X direction only.

Thread pitch (F)

The thread pitch is programmed in μm;
e.g. 1.25 mm pitch; input = F1250
You can find the right thread pitch for standardized threads in the tables of the chapter "thread-cutting".

Example:

<table>
<thead>
<tr>
<th></th>
<th>absolute:</th>
<th>incremental:</th>
</tr>
</thead>
<tbody>
<tr>
<td>Z</td>
<td>N.../GBS/7.8/2/20/F_z/2/D_z 600</td>
<td>N.../GBS/7.8/2/20/F_z/2/D_z 600</td>
</tr>
<tr>
<td>D_z</td>
<td>/D_z 1100/F 1500</td>
<td>/D_z 1100/F 1500</td>
</tr>
</tbody>
</table>
**G86 Cut-in cycle**

Input format:

<table>
<thead>
<tr>
<th>N</th>
<th>G86</th>
<th>X ± 43</th>
<th>U</th>
<th>Z ± 43</th>
<th>W</th>
<th>D1 S</th>
<th>D2 S</th>
<th>F 4</th>
</tr>
</thead>
</table>
|   |     | (mm)   |   | (mm)   |   | (µm) | (µm) | (µm/)

N ... Block number  
G86 ... Cut-in cycle  
X(U) ... Absolute (incremental) coordinates  
Z(W) ... of the contour corner point (K)  
D1 ... Advance per cut (radius value)  
D2 ... Tool width  
F ... Feed

---

**Cut-in width = tool width**
The tool movement is carried out in X direction. The tool advances by a measure of D₁, moves a little back (for chip breaking), advances again by a measure of D₂ etc., until point K is reached.

**Cut-in width larger than tool width**
If the width of the programmed cut-in is larger than the tool width, the control system grades the remaining cut-in width after the first cut-in into partial cut-ins with the same chip width. Overlapping of the individual partial cut-ins is at least 1/10 mm.

---

Each cut-in movement (1,4,7) is graded additionally by D₂ (see previous drawing).

**Tools used:**

<table>
<thead>
<tr>
<th>Parting-off tool:</th>
<th>Cut-in tool:</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tool width = 3mm</td>
<td>Tool width = 1.2 mm</td>
</tr>
<tr>
<td>max cut-in depth = 1.5</td>
<td></td>
</tr>
</tbody>
</table>

---

The cut-in cycle consists of several single motions.

- **G00** Movement with rapid motion speed
- **G01** Movement with programmed feed speed (f) in mm/min or µm/τ.

**Contour corner point (K)**
The cut-in depth and width is defined by starting point (S) and contour corner point (K). S is traversed in a block before G86. K is described with X, Z absolute or with U, W from S (incremental).

---

When adjusting the tool (chapter 4,5) the left cutting edge has to be adjusted.
Example 1
Cut-in for Seeger circlip ring
Speed with aluminium = 1500 rpm

Example 2
Cut-in with 8 mm width in aluminium
Speed = 950 rpm

Cut-in values for sealing rings according to DIN 471

<table>
<thead>
<tr>
<th>d</th>
<th>d₁</th>
<th>m</th>
</tr>
</thead>
<tbody>
<tr>
<td>9</td>
<td>8,6</td>
<td>1,2</td>
</tr>
<tr>
<td>10</td>
<td>9,6</td>
<td>1,2</td>
</tr>
<tr>
<td>12</td>
<td>11,5</td>
<td>1,2</td>
</tr>
<tr>
<td>14</td>
<td>13,4</td>
<td>1,2</td>
</tr>
<tr>
<td>15</td>
<td>14,3</td>
<td>1,2</td>
</tr>
<tr>
<td>17</td>
<td>16,2</td>
<td>1,2</td>
</tr>
<tr>
<td>18</td>
<td>17</td>
<td>1,3</td>
</tr>
<tr>
<td>20</td>
<td>19</td>
<td>1,3</td>
</tr>
<tr>
<td>25</td>
<td>23,9</td>
<td>1,3</td>
</tr>
<tr>
<td>30</td>
<td>28,6</td>
<td>1,6</td>
</tr>
<tr>
<td>35</td>
<td>33</td>
<td>1,6</td>
</tr>
<tr>
<td>40</td>
<td>37,5</td>
<td>1,85</td>
</tr>
<tr>
<td>50</td>
<td>47</td>
<td>2,15</td>
</tr>
<tr>
<td>60</td>
<td>57</td>
<td>2,15</td>
</tr>
</tbody>
</table>
The reference point (R)

Position:
After setting up a blank, the reference point is automatically on the extreme right end of the blank on the center line.

Meaning:
All absolute dimension values on the workpiece refer to the reference point. By special dimensioning of the workpiece it may be useful to set off the reference point during machining.

Offset:
With G92 the offset values for the reference point (R) are indicated. With G59 the offset indicated in block G92 is activated.
With G56 the offset is reversed - R is again in the original position. G56 is not necessary at program end - when calling up a new program, the reference point offset is cancelled automatically.

G92 Data for reference point offset

Input format:

<table>
<thead>
<tr>
<th>N</th>
<th>G92</th>
<th>X</th>
<th>U</th>
<th>Z</th>
<th>W</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>±43</td>
<td>±43</td>
</tr>
</tbody>
</table>

X, Z (or U,W) are the offset values. The new reference point (R1) is offset by these values from the old reference point (R).

If there is no reference point (R) the offset values refer to the machine starting point (M).

X is a diameter value
U is a radius value

Example:

absolute:    N. G92/X0/Z 30
incremental: N. G92/U0/W 30
G94 / G95  Feed unit

Input format:

<table>
<thead>
<tr>
<th>N4</th>
<th>G94</th>
</tr>
</thead>
<tbody>
<tr>
<td>N4</td>
<td>G95</td>
</tr>
</tbody>
</table>

- Switch-on state is G94
- G94 and G95 are self-holding until they are cancelled
- G94, G95 can be programmed as often and wherever one wants to

For the feed size or feed speed the letter F is used.

1. **Feed programming with G94**
   - path of turning tool per minute
   - \( F \) [mm/min]

2. **Feed programming with G95**
   - path of turning tool per main spindle revolution
   - \( F \) [\( \mu m/r \)] \( \ldots 1 \mu m = 1/1000 \) mm

**Conversion:**

\[
F (\text{mm/min}) = S (\text{rpm}) \times F (\text{mm/r})
\]

\[
F (\text{mm/r}) = \frac{F (\text{mm/min})}{S (\text{rpm})}
\]

\( S \ldots \) Main spindle speed
7. NOTES FOR THE SOFTWARE COMPILATION

Design:
The power supply unit and the stepping motor control of the Compact 5 PC are accommodated in a smaller control cabinet. These components are identical to those of the Compact 5 PC and therefore the same spare parts can be employed. The Compact 5 PC must be controlled by an external computer. The Compact 5 PC is to be connected to this computer like a peripheral, such as a printer, plotter or a paper tape reader/puncher. The computer must be fitted with a Centronics interface for connection to the Compact 5-PC. This interface is a parallel interface, i.e. data is transmitted on eight lines simultaneously (Centronics is the company name of an American printer manufacturer and the definition of this printer interface has become a quasi-standard worldwide).
The connector provided on the Compact 5 PC is a 25-pin D subminiature jack connector with the following pin assignment:

<table>
<thead>
<tr>
<th>Pin No.</th>
<th>Signal designation</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>STROBE</td>
</tr>
<tr>
<td>2</td>
<td>data bit 0</td>
</tr>
<tr>
<td>3</td>
<td>data bit 1</td>
</tr>
<tr>
<td>4</td>
<td>data bit 2</td>
</tr>
<tr>
<td>5</td>
<td>data bit 3</td>
</tr>
<tr>
<td>6</td>
<td>data bit 4</td>
</tr>
<tr>
<td>7</td>
<td>data bit 5</td>
</tr>
<tr>
<td>8</td>
<td>data bit 6</td>
</tr>
<tr>
<td>9</td>
<td>data bit 7</td>
</tr>
<tr>
<td>10</td>
<td>speed pulse light barrier (100 p/rev)</td>
</tr>
<tr>
<td>11</td>
<td>emergency-off and chip protection door</td>
</tr>
<tr>
<td>12</td>
<td>synchronous pulse light barrier</td>
</tr>
<tr>
<td>18-25</td>
<td>earth</td>
</tr>
</tbody>
</table>

This interface is connected via a small interface pc board directly to the stepping motor card and the light barrier. This interface board accommodates a 4-fold DIP switch with which the user can set various modes of operation.

Signal description:
The signal inputs only process TTL signals and the signal outputs offer TTL signals.
The strobe input serves for the synchronisation of the data lines. If a pulse is transmitted on this line, the data which are offered at this time to the data lines bit 0 – bit 7 are accepted as being valid. On many computers this signal is automatically produced by the hardware, on other computers the programmer has to generate this signal in the software.
The signal emergency-off and chip protection door is a signal output and is set to “Low” when the emergency-off button is pressed or if the chip protection door is open. (The limit switch for the chip guard is not installed as a standard feature. Merely the connection for it is provided!).

The signal speed pulse is a signal output and provides 100 pulses per revolution of the main spindle. The pulse duty factor is not defined and also depends on the speed.
The signal synchronous pulse is a signal output and provides one pulse per revolution of the main spindle. The length of the pulse depends on the speed and the pulse is not synchronised with the slopes of the speed pulses.
The meaning of the data signals depends on the setting of the 4-fold DIP switch. These signals, however, always serve to trigger the stepping motors.

In order to picture the operation of the stepping motor, it is a good idea to imagine a coordinate system with the four cardinal points. These points correspond to the directions of the magnetic fields in the stepping motor and one magnetic field can be produced with one winding (when an electric current is allowed to pass through the winding). If more than one winding is switched on at the same time, the direction and strength of the magnetic field are derived by vectorial addition. An example: If the windings “North” and “South” are activated at the same time, the two magnetic fields cancel each other out and the resultant magnetic field has zero strength and the direction is undefined. However, if the windings “South” and “West” are switched on simultaneously, the direction of the resultant magnetic field is “South-West” and the strength is 1.41 times that of a single field. (Diagonal of a square).

The rotor of a stepping motor is designed so that it always tries to align itself in the direction of the magnetic field produced by the stator. Therefore, if the current is suitably switched on and off in the windings of the motor, the rotor rotates about a certain angle and it thus moves stepwise from one set magnetic field direction to the next.

There are two ways in which the windings can be triggered:

1) Full-step mode
   - 1st step: S-W
   - 2nd step: W-N
   - 3rd step: N-E
   - 4th step: E-S

2) Half-step mode
   - 1st step: S-W
   - 2nd step: W
   - 3rd step: W-N
   - 4th step: N
   - 5th step: N-E
   - 6th step: E
   - 7th step: E-S
   - 8th step: S
The direction of rotation depends on whether one controls from 1 to 2 etc., or, for example, from 1 to 8, from 0 to 7 etc.
The advantages of the half-step mode of operation lie in the double resolution with the same motor design, the disadvantage is a loss of torque because only one winding is active at each intermediate step and only about 70% of the maximum torque is available. Moreover, more stringent demands have to be placed on the computing speed owing to the higher resolution.

The Centronics interface has eight data lines. As four windings per motor have to be triggered, the windings can be directly controlled by two motors.

If the sequence of winding control no longer has to be performed directly by the connected computer, two lines per axis drive are, in principle, sufficient, i.e. one line where the direction of rotation is determined and a second line where the steps are output. (One pulse on the second line means that the stepping motor is to move one step in the direction or rotation specified on line one.)

Abbreviations:
VS ... full step
HS ... half step
T/R ... step/direction signal
dir ... direct winding control
RL ... cw
LL ... ccw

Table for the 4-fold DIP switch:

<table>
<thead>
<tr>
<th>Mode</th>
<th>1</th>
<th>2</th>
<th>3</th>
<th>4</th>
</tr>
</thead>
<tbody>
<tr>
<td>VS T/R RL RL</td>
<td>on on on on</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>VS T/R LL RL</td>
<td>on off on on</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>VS T/R RL LL</td>
<td>on on off on</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>VS T/R LL LL</td>
<td>on off off on</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>VS dir RL RL</td>
<td>off on on on</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>VS dir LL RL</td>
<td>off off on on</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>VS dir RL LL</td>
<td>off on off on</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>VS dir LL LL</td>
<td>off off off on</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>HS dir RL RL</td>
<td>off on on off</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>HS dir LL RL</td>
<td>off off on off</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>HS dir RL LL</td>
<td>off on off off</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>HS dir LL LL</td>
<td>off off off off</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>HS T/R RL RL</td>
<td>on on on off</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>HS T/R LL RL</td>
<td>on off on off</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>HS T/R RL LL</td>
<td>on on off off</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>HS T/R LL LL</td>
<td>on off off off</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Characteristics of the axis drives for the Compact 5 PC:
The specified values relate to full-step control and are to be converted for half-step control accordingly.
The given values relate to the slide movements.

Resolution:
One step corresponds to 1000/72 micrometre.

Speed:
100 Hz correspond to 83.33 mm/min feed rate

Maximum speed:
840 Hz corresp. to 770 mm/min rapid motion

Start-stop frequency:
598 Hz corresp. to 499 mm/min feed rate

Acceleration time:
from 0 to 598 Hz 0 sec
from 598 to 840 Hz 1 sec (linear acceleration)

"dir" mode:
The data lines D0 to D3 are assigned to the stepping motor in the X-axis (cross slide). The sequence of the windings is "E", "S", "W", "N".
The data lines D4 to D7 are assigned to the stepping motor in the Z-axis (longitudinal slide). The sequence of the windings is the same as for the X-axis.

"T/R" mode:
The data lines
D0 is direction motor X
D1 is steps motor X
D2 is direction motor Z
D3 is steps motor Z
Menu summary

Notes
You can select and activate the individual menu points with the function keys F1 to F10 or with the space bar.

A command can be interrupted or a return to the previous menu level activated with the key Esc.
Hotkeys - draw

In order to facilitate a more efficient programming, so-called "hotkeys" were introduced in this software. Hotkey = single-key commands, which are effective in every menu level. You can display a work piece contour on the screen more quickly with the use of these hotkeys.

Example: Constructing a line

<table>
<thead>
<tr>
<th>Possibility 1 - Menu</th>
<th>Possibility 2 - hotkeys</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. F2 Recall - menu DRAW</td>
<td>1. Moving the cursor to the starting point</td>
</tr>
<tr>
<td>2. F2 Recall - submenu POINT</td>
<td>2. S Determining the starting point</td>
</tr>
<tr>
<td>3. Moving the cursor to the starting point</td>
<td>3. Moving the cursor to the end point</td>
</tr>
<tr>
<td>4. F1 Determining the starting point</td>
<td>4. + Drawing the line to the cursor position, a new starting point at the same time</td>
</tr>
<tr>
<td>5. Moving the cursor to the end point</td>
<td></td>
</tr>
<tr>
<td>6. F2 Determining the end point</td>
<td></td>
</tr>
<tr>
<td>7. Esc Exit from the submenu POINT</td>
<td></td>
</tr>
<tr>
<td>8. F3 Recall - submenu line</td>
<td></td>
</tr>
<tr>
<td>9. F1 Drawing a line</td>
<td></td>
</tr>
</tbody>
</table>

Summary - hotkeys

<table>
<thead>
<tr>
<th>Key</th>
<th>Cursor commands</th>
</tr>
</thead>
<tbody>
<tr>
<td>I</td>
<td>Position the cursor incrementally</td>
</tr>
<tr>
<td>/</td>
<td>Position the cursor by entering the radius and angle</td>
</tr>
<tr>
<td>pos</td>
<td>Cursor to the middle of the screen</td>
</tr>
<tr>
<td>ref</td>
<td>Cursor to the reference point</td>
</tr>
<tr>
<td>[&gt;]</td>
<td>Doubling the step size of the cursor</td>
</tr>
<tr>
<td>[&lt;]</td>
<td>Halving the step size of the cursor</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Key</th>
<th>Searching commands</th>
<th>Point commands</th>
<th>Geometric commands</th>
</tr>
</thead>
<tbody>
<tr>
<td>[P]</td>
<td>Finding the point</td>
<td>S Determining the starting point</td>
<td></td>
</tr>
<tr>
<td>[L]</td>
<td>Searching for the line</td>
<td>E Determining the end point</td>
<td></td>
</tr>
<tr>
<td>[A]</td>
<td>Searching the circle, arc</td>
<td>M Determining the centre point</td>
<td></td>
</tr>
<tr>
<td>[X]</td>
<td>Searching any point of intersection</td>
<td></td>
<td></td>
</tr>
<tr>
<td>[R]</td>
<td>Adding a fillet</td>
<td></td>
<td></td>
</tr>
<tr>
<td>[C]</td>
<td>Adding a chamfer (45°)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>[Y]</td>
<td>Cleaning the bit</td>
<td></td>
<td></td>
</tr>
<tr>
<td>[+]</td>
<td>Drawing a line to the cursor</td>
<td></td>
<td></td>
</tr>
<tr>
<td>[-]</td>
<td>Erasing the element</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Note:
Letters can be entered as capitals or small letters.
Hotkeys - machine

You can move the slides and influence the machining cycles by means of these keys.

<table>
<thead>
<tr>
<th>Key</th>
<th>Function</th>
</tr>
</thead>
<tbody>
<tr>
<td>↑</td>
<td>Move the slides in the -X direction</td>
</tr>
<tr>
<td>↓</td>
<td>Move the slides in the + X direction</td>
</tr>
<tr>
<td>←</td>
<td>Move the slides in the -Z direction</td>
</tr>
<tr>
<td>→</td>
<td>Move the slides in the + Z direction</td>
</tr>
<tr>
<td>⌘</td>
<td>Enlarge the travel path of the stepping motors</td>
</tr>
<tr>
<td>⌘</td>
<td>Reduce the travel path of the stepping motors</td>
</tr>
<tr>
<td>&gt;</td>
<td>Increase the feed</td>
</tr>
<tr>
<td>&lt;</td>
<td>Reduce the feed</td>
</tr>
<tr>
<td>Space bar</td>
<td>Stop the slides ( = intermediate stop)</td>
</tr>
<tr>
<td>Esc</td>
<td>Interrupt the machining</td>
</tr>
</tbody>
</table>

Travel path of the stepping motors

<table>
<thead>
<tr>
<th>Key</th>
<th>Travel Path</th>
</tr>
</thead>
<tbody>
<tr>
<td>PgUp</td>
<td>10 mm ( = largest travel path)</td>
</tr>
<tr>
<td>PgUp</td>
<td>5 mm</td>
</tr>
<tr>
<td>⌘</td>
<td>1 mm ( = switch-on condition)</td>
</tr>
<tr>
<td>PgUp</td>
<td>0,5 mm</td>
</tr>
<tr>
<td>PgUp</td>
<td>0,1 mm</td>
</tr>
<tr>
<td>PgUp</td>
<td>0,05 mm</td>
</tr>
<tr>
<td>PgUp</td>
<td>0,01 mm ( = smallest travel path)</td>
</tr>
</tbody>
</table>

Altering the programmed feed

<table>
<thead>
<tr>
<th>Key</th>
<th>Percentage</th>
</tr>
</thead>
<tbody>
<tr>
<td>&gt;</td>
<td>200 %</td>
</tr>
<tr>
<td>&gt;</td>
<td>150 %</td>
</tr>
<tr>
<td>&gt;</td>
<td>120 %</td>
</tr>
<tr>
<td>⌘</td>
<td>100 % ( = switch-on condition)</td>
</tr>
<tr>
<td>&lt;</td>
<td>80 %</td>
</tr>
<tr>
<td>&lt;</td>
<td>60 %</td>
</tr>
<tr>
<td>&lt;</td>
<td>50 %</td>
</tr>
<tr>
<td>&lt;</td>
<td>40 %</td>
</tr>
<tr>
<td>&lt;</td>
<td>30 %</td>
</tr>
<tr>
<td>&lt;</td>
<td>20 %</td>
</tr>
<tr>
<td>&lt;</td>
<td>10 %</td>
</tr>
<tr>
<td>&lt;</td>
<td>5 %</td>
</tr>
<tr>
<td>&lt;</td>
<td>0 %</td>
</tr>
</tbody>
</table>