

CNCmakers Limited

Address: No.168, Xiadu Road, Haizhu District, Guangzhou, China 510300

Email: info@CNCmakers.com Website: www.CNCmakers.com Tel: +86-138-24444158 Fax: +86-20-84185336

1000TII TURNING CNC CONTROLLER

1000TII from CNCmakers Limited, is a superior turning machine CNC system with high performance 32-bit microprocessor, new structure design and open PLC process. It is employed with 8.4 inch color LCD display. It can control 4 feeding axes, 4 simultaneously controlled axes. It can be matched with SD or YASKAWA Digital AC servo driver. 1000TII is suitable for full function CNC Turning Machine.



- Adopt 32-bits powerful CPU to achieve high-speed, high-precision control. The maximum speed reaches up to 30 m/min
- 7.5/8.4 inch TFT LCD with the resolution of 640x480.
- Six layer main board applying custom-build FPGA, high integration technology, perfect structure design ensures that the system has high reliability and high anti-interference capability.
- Support the open-style PLC function to meet the secondary development of the machine tool builder.
- Two types of machine control panels including the standard panel with film-buttons and one with pushed buttons are available. On the later one the functions of the 50 pushed buttons and 50 lamps are able to be defined by custom.
- Remote I/O modules based on CAN bus can be used to extend the number of I/O points up to 512/512.
- English operation interface and full help information make the operation more convenient.
- Perfect self-diagnosis function. Display the internal and external states in real time and alarms will be issued timely when some abnormality happens.
- Powerful instruction execution ability to achieve the high-speed, small-line-section machining
- 640 kB internal program memory space. U-disk port can be used to extend the space of program and to perform DNC machining.
- Rich NC functions: macro program B, rigid tapping, local coordinate system, coordinate system rotation, coordinate scaling, polar coordinate system, etc.

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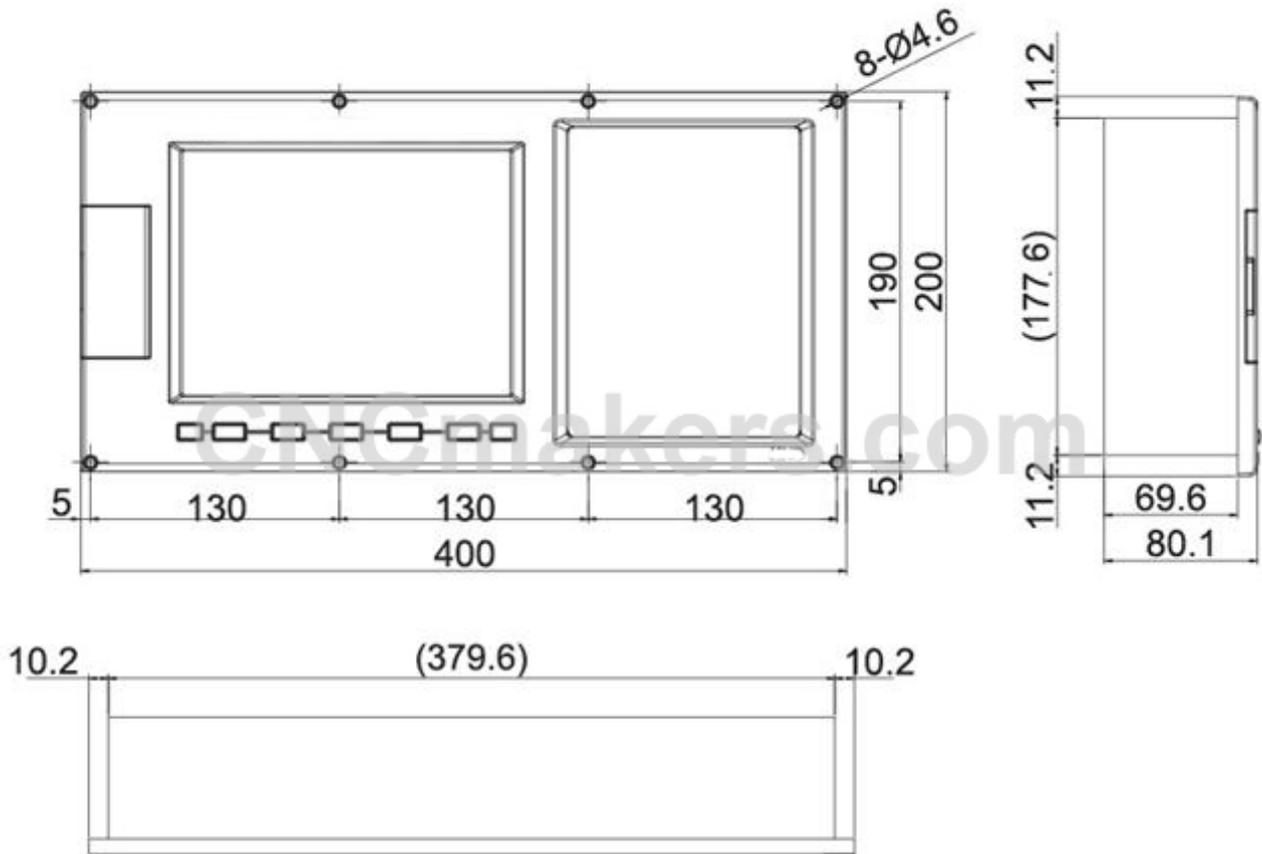
Function	Specification	Function	Specification
NC axis number	2 axes (X, Z)	English and metric unit exchanging	Provided
Interpolation axis number	2 axes (X, Z)	Communication	RS232
Interpolation	Linear interpolation arc interpolation		
Least setting unit	0.001 mm or 0.0001 inch	Remote control	Transmitting PLC program, machining program, parameters, etc.
Largest command dimension	±99999.999 mm	U-disk interface	Provided
Maximum rapid traverse rate	30000 mm/min	Macro program	Provided
Maximum feed rate	15000.000 mm/min 30000 mm/min (optional)	Emergency stop and stroke limit	Standard PLC program supports three emergency stop signals. Both stored stroke limit and hardware stroke limit are available.
Feed rate override	JOG/AUTO: 0~150%	Alarm	PS alarm, Servo driver alarm, Exceed stroke limitation alarm, System error alarm, External alarm
Program memory space and electric disk	640 kB/128/3 640 kB/512/3(optional)	Acceleration/deceleration control	Linear and exponential type control
Interface	7.5/8.4 inch TFT LCD	Reference position return	Provided
	Revolution: 640×480	Electrical gear ratio	1~127, 1~127
Additional interface	Additional panel, Independent operation box	Machine control	Machine lock Feed hold Block skip
Display	Coordinate value, machining time, workpiece count, date, feed rate, etc.	Feed control	AUTO, JOG, STEP, HANDLE
Graphic function	Tool path displaying	DI/DO	DI: 40 DO: 24 DI/DO points can be extended by CAN bus
PLC	Open-style PLC	Driver	Digit AC servo driver
Tool compensation	Tool length compensation Tool tip radius compensation	Measuring function	Provided
Backlash compensation Pitch-error compensation	Provided	Canned cycle	Provided
Spindle function	Gear shifting control Analog spindle control Rigid tapping control	Thread cutting	Straight thread, cone thread, end-face thread, variable-pitch thread
Miscellaneous functions	Control the spindle rotation, coolant, lubrication, in JOG /MDI /AUTO mode	Diameter/Radius programming	Provided
		Feed per minute Feed per revolution	Provided
Program	Absolute / incremental mixture programming. Decimal point function in programming	Constant surface speed control	Provided
Workpiece coordinates	G54~G59	Tool length compensation	16
Subprogram calling function	Provided	Tool control	Controlled by PLC

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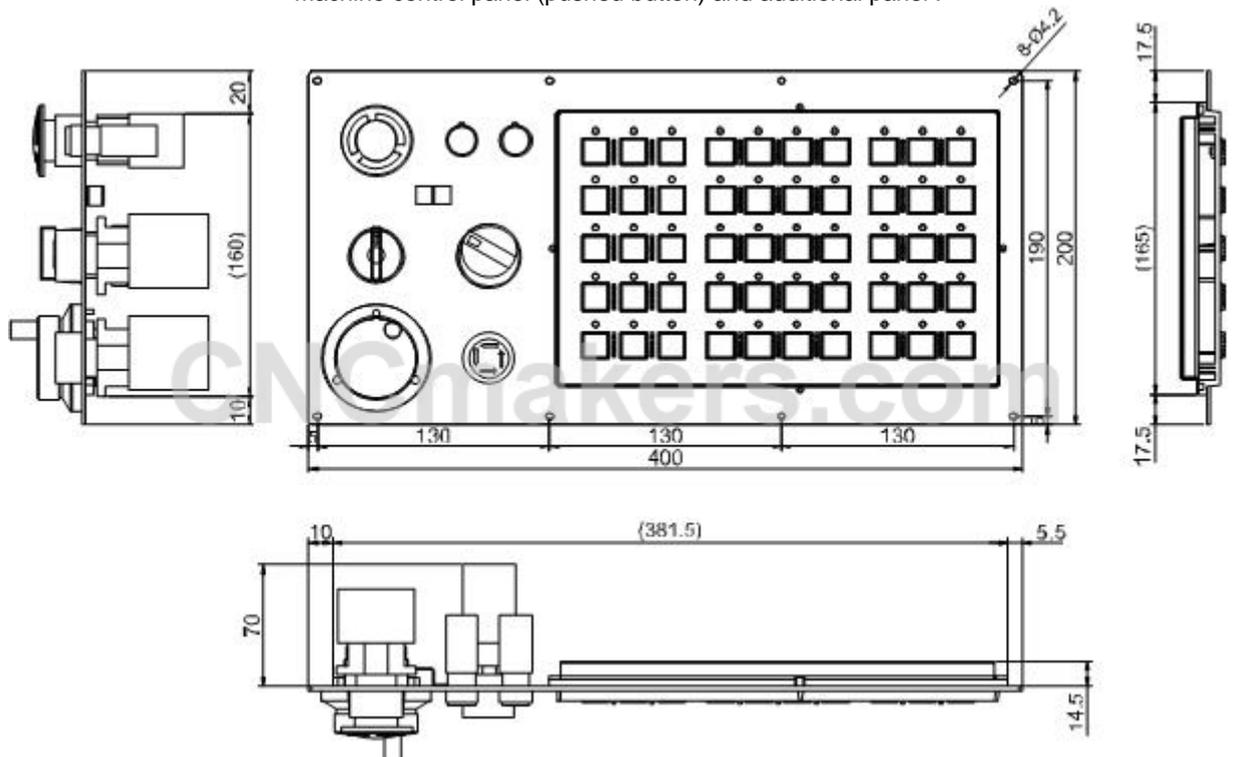
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1000TII Turning CNC Control Dimension



Machine control panel (pushed button) and additional panel :

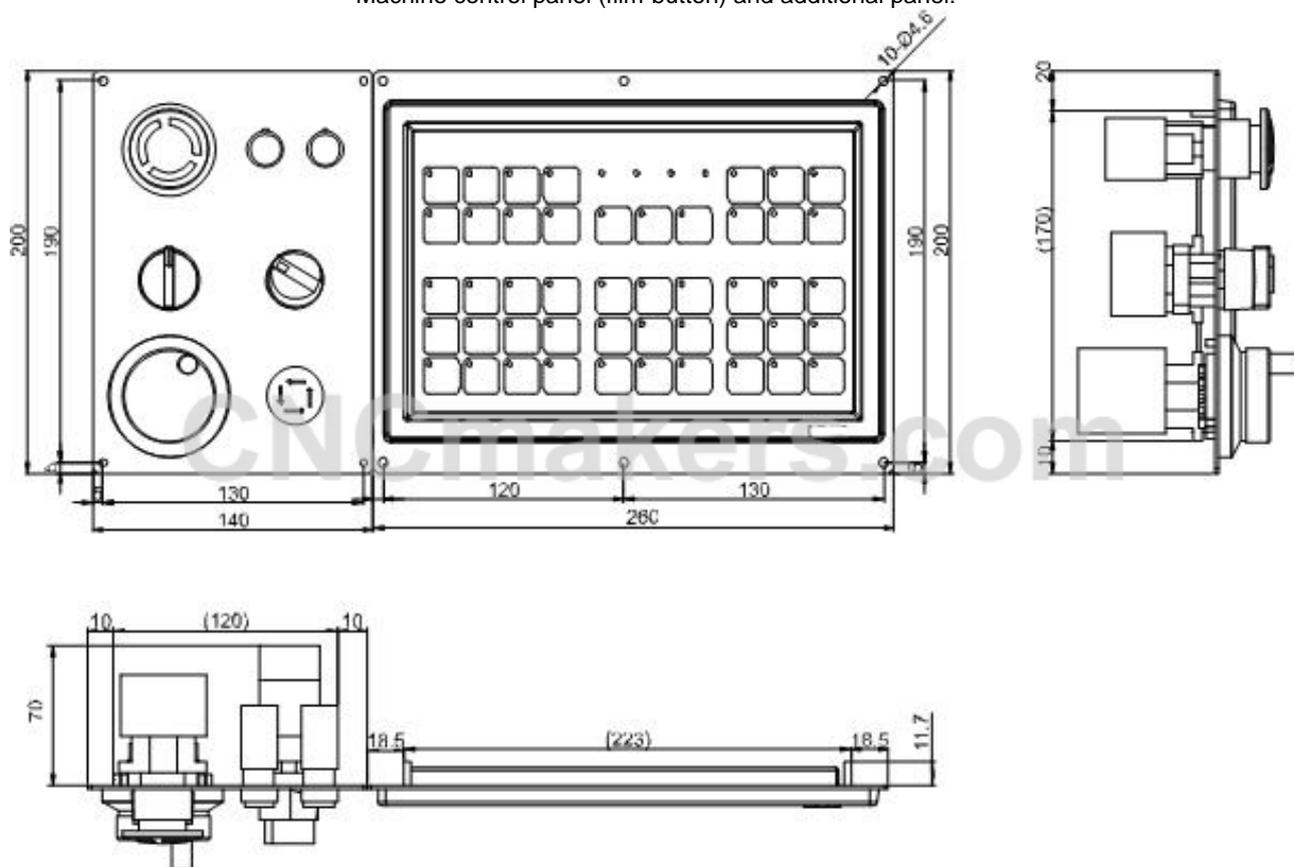


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Machine control panel (film-button) and additional panel:



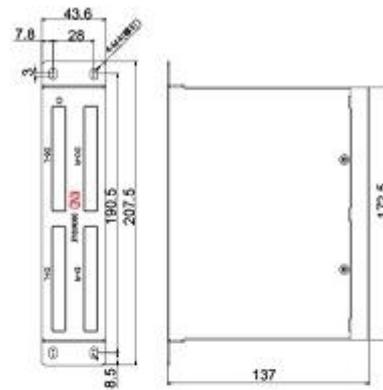
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Remote IO module:

Remote IO module D1/D2



Remote IO module A1/A2

