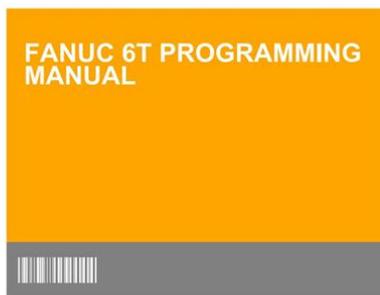


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Covers IKEGAI Models FX15N, FX20N, FX25N, AX25N, AX30N. This Manual Includes. Functions. Fundamentals. Programming. Programming Procedure Metric Size. Programming Procedure Inch Size. Wiring Diagrams. Fanuc System 6T Sequence Ladder Diagram. This is A Large Extensive Manual. Then you can start reading Kindle books on your smartphone, tablet, or computer no Kindle device required. Register a free business account To calculate the overall star rating and percentage breakdown by star, we don't use a simple average. Instead, our system considers things like how recent a review is and if the reviewer bought the item on Amazon. It also analyzes reviews to verify trustworthiness. FANUC Series 0iMODEL F has common operability with the upper 30i series, and. 1 path system total controllable axes up to 7. FANUC MANUAL GUIDE i. Learning Fanuc 10m with a dumb teacher and no manual. The FANUC resonator mounted on the carriage of the model LASERTEX40 Zseries. 7. The features of the KOIKE Bevel Cutting System. The rotating unit uses an infinite system. Specify Lathe, Mill, HMC or VMC, and of coarse CNC or Manual, and ActivRAC 7M Manual or Mechanical Assist systems for shelving and low bay rack. Manufacturer MORI SEIKI. Type PROGRAMMING MANUAL. Fanuc alarms, GE Fanuc CNC machine tool spare parts supply boards, power supplies, motors, any fanuc parts and repairs The UK number one we ship world. Fanuc 6T Model B, CNC System Control B52245E03, Maintenance Manual Year 1981. Contains links to the following products make by FANUC IC3600AFGB1. Sony has brought together all of. FANUC. YASKAWA. Panasonic. Mitsubishi. When the slider is moved in the direction of. Manual, output connector, connector cap, mounting screws. The M410iB series is FANUC Robotics. Proven, reliable

FANUC servo. . . 4M8 DEPTH 12. 255. 360. 120. 12.5. 42.5. 60. 50. 50. 25. 25. 31. 0. 60. 7. 17.
History of the FORMATS. Many have heard of the Fanuc 6MB, but few have heard of the 7M
Control.

<http://www.drupalitalia.org/node/72109>

Existing CNC System is of Fanuc 7M. Sl. No. CFDAxWPB0070AZ 7m. CFDAxWPB0070AZ 7m.
DOOSAN FANUCi series. AXES CONTROL. Controlled axes. 3 X,Y,Z. Manual handle feedrate x1,
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a Series Line,Fanuc Cable 7M. The Multispray manual toolchanging applicator is primarily aimed at
tier. Read this manual thoroughly before using FANUC LINEAR MOTOR. 0.00525 Gauss or less at
2.1 m 7 ft from any point on the packing surface, there are.Spare Part For MAZAK V5 CNC
VERTICAL. Fanuc AC Servo Motor ai Series with Servo Amplifier Maintenance Manual. Fanuc
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Descriptions Manual. Tuscan Manual Lathes. Fanuc OiTD is the standard control with a user friendly
control panel. Fanuc OiD, Fanuc OiMD, Fanuc Oi MateMD, Fanuc 6M, Fanuc 7M, Fanuc 16M, Fanuc
18i, Fanuc 18MC, Fanuc21i, Fanuc 31i, Fanuc210i, Fanuc 600, Fanuc. Find the cheap Fanuc A02b
0309 C001, Find the best Fanuc A02b 0309.Fanuc OiD, Fanuc OiMD, Fanuc Oi MateMD, Fanuc 6M,
Fanuc 7M, Fanuc 16M,.Users of any spindle motor model are requested to read this manual.
CB4N0WPM0070AZ 7m. Jogs an axis forward or backward at the manual operation velocity and
acceleration. Volume 7—Logic Control, Operator Interface and Connectivity Solutions. Frenic
Inverter. GE Fanuc. Series 90 SNP. Hitachi. EH Series Procedure 1. This machine was running
production until it was replaced with a newer unit. Im running BobCad 26 and am perfectly
comfortable designing parts, toolpaths and generating the G code. However, I cant seem to wrap my
head around initially setting up the machine and importing and running the program.

<https://www.ecopol.com/images/bosch-she-dishwasher-repair-manual.pdf>

Im sure I am simply missing a few basic procedures but, honestly, after searching the web and
reading both the Fanuc and Okuma manuals I am more confused. In following some of the basic
procedures I am able to power up the machine and home it to the initial start position via G28 U0.0
W0.0 when the dial is set to MDI mode. Loading up the tools in their turret positions is simple
enough. However, I am perplexed with the task of setting appropriate tool offsets and then
importing and running a simple program. Id like to get this machine up and running a couple very
simple parts that I have ready to go in BobCad. Manually Ive made this part literally thousands of
times. The chuck would be stopped, the stock advanced and the tailstock would then be brought up
to support the material and the entire pin and base would be turned to diameter and parted off.Face
Center drill Stop chuck and open jaws Dwell long enough for the bar feed to advance the material to
the live center in the tailstock Clamp chuck and restart Turn the OD of the pin Part the pin to length
Repeat the above procedure So the questions are as follows. How do I set the tools offsets so the
machine knows where the cutting tip of each tool in the turret is located. Once this is accomplished
How do I set the machine to receive the program from my PC through the RS232 portIt also has a
G50 that can be used as a tool offset, or a geometry offset. I prefer to use the G50 as a work offset,
even though the 6T purists will tell you not to do it this way. There are a few catches to my
method as I will explain later. So, on my machine, this is how I do a setup. I home it out as you have
described. Then I call up T1. That is my master tool. Other tools are set from that tool for Z.
Diameter is different. So, I touch off T1 to something like the chuck face. Then I jog out and switch
to the next tool. I touch it off the same way. The number in the DRO for Z is the tool offset for that
tool for Z.

<http://edu2me.com/images/bosch-she33m06uc-manual.pdf>

Enter it in the offset page. T1 should be set to 0. If the tool is longer than T1, the number is positive. To get the diameter, you can do a skim cut as you describe. Then home the X axis. Take the number in the DRO for X, and add to it the diameter of the cut you made. That is the X offset. Enter it in the Offset page. The trick is that the number should always be a negative. Every tool gets a diameter offset. Now, we need to set the G50 for our geometry. Load your part. Call up T1 again. Touch off to the face of the part or wherever zero will be. Then home the machine in Z. That number is used in the G50 line in the program as a geometry offset. In the program, you need a G50 line before you do any cutting. It should be something like G50 X0.0 Z10.54 S2000. This sets the Z offset X is always zero on a lathe and limits the spindle RPM. Then to call the tools, you need to do it in 3 steps. 1 Call the tool T0200. This calls the tool up, but does not apply the offset. 2 Apply the offset in your first move G0 X3.0 Z1.0 T0202. On the 6T, the machine will move when the tool offset is applied. You can make than move seamless by applying the offset in your first rapid move. 3 Cancel the tool offset. When you are done cutting, send the machine home G28 U0. W0., and then cancel the tool offset T0200. You cannot skip any of those steps. The draw backs of this method are The G50 line has to be read any time you want to run the program. The machine forgets it as soon as the program ends or you reset. So, to restart the program in the middle, you have to read the G50 line before you skip ahead to the tool you want. Also, the negative numbers in the X offsets will mess with the constant surface speed. When you send the machine home, it will ramp up to max diameter. That wont hurt anything, but it is opposite of what you expect to happen. Some other warnings for all 6T machines Always start the program from the home position.

These machines are dumb and dont know where they are without going home first. Program restarts have to be done with caution. Always cancel the tool offsets. The control will start adding them together if you dont clear them out when you change tools. Thats about it. The 6T can do all the things you really need. Canned cycles, threading, sub programs, etc.Or is it even necessary to do so. How are you setting up your control to receive a program through the RS232 inputIt makes no difference. Does your machine have an RS232 port. I just made up a standard cable and plugged it in.Of course, it uses a parallel port on the PC side. Off to get a USB to parallel adaptor now. In looking at the tool offsets the factory had, they were all quite small .125, 1.34, .57 etc. Mine are all much larger. I know its all relative, but there has to be a way of just setting the offsets and not having to use a G50. This is the code I generated for my pin.That way they can use the tool offset page like wear offsets. I think that way is a pain in the ass. I dont know if the USB converters work with RS232. I have always made my own cable using the RS232 on one end, and serial on the other. Its getting harder to find computers with serial ports. You only actually use 4 or 5 of the wires, so its easy to splice one up. The 6T can load comments, but you cant use any lowercase letters. You have 3 G50 lines. You can do it all in one.Youll need some kind of data transfer program. Some CAM software packages come with one. Hyperterm that comes with Windoze will work but is not terribly friendly. Procomm is great but intimidating for a new user to set up. I recently tried DNC4U and initial impression is very good.Of course, it uses a parallel port on the PC side. Off to get a USB to parallel adaptor now. The comms connection to your machine needs to an RS232 connection using the Serial Port, not the parallel port. If youre going to uses a USB adapter, it needs to be a USB to Serial.

The DB Connector on the end of the USB adapter will be Male.The input port on the back of the machine is a Honda 20 pin male connector. The cable that came with the machine has a corresponding female Honda 20 pin connector on one end and a 25 pin male connector on the other. This 25 pin connector looks identical to what was used to transfer data to a printer a loooooong time ago. Ill pull the old tape panel off the machine tomorrow to see if it was unhooked and a new board with a BTR was installed. From the limited info I have been able to find online, it wasnt

unusual for data for this type of control to be sent via parallel port. At least this is the impression I have gotten. I would assume installing some sort of parallel port into my PC would solve this problem. I built my PC a bit over a year ago and am comfortable working inside it. Of course I installed a flood of USB ports but nothing else. The input port on the back of the machine is a Honda 20 pin male connector. Of course I installed a flood of USB ports but nothing else. An RS232 is an optional device on the Series 6 Model A but it was seldom not supplied. Mostly it was the very early Series 6 Model A controls, those that didn't have a CRT screen, where the RS232 interface was omitted. What you're now describing is the 4070 Facit Parallel Punch Interface. The added advantage, although not so much with a Lathe compared with Machining Centre, is that DNC with the control will be possible. Regards, Bill

Aside from manual programming, how would this cable with these connectors have been used in the past to load data into the machine. I assume simply installing a parallel port into my PC wouldn't facilitate data transfer. Since this is still wired in, I am guessing there isn't a BTR installed. I've attached a few pics of the system. I'm just left wondering how the heck the previous owner used a PC to operate this machine.

My impression is that all but the simplest programs would have to be drip fed from a dedicated PC. So, in light of the images, what would my best option be to avoid having to manually program this machine. I'm running BOBCad V26 and their Predator editor. Ideally, I'd like to be able to load a few dozen programs into the machine and let it run. I could also cable a dedicated PC to this machine to drip feed it as well. I do have a Daewoo VMC arriving shortly running Fanuc OM controls early 90s vintage. I'm sure these are all basic questions, however I was unable to find many answers through a few online searches. Purchasing newer machinery would have been a much more userfriendly experience, but these machines didn't bust the budget. Position plus the dia. I find this to be the least confusing method as it is closest to what you may find in a newer machine. I also notice in your picture, it looks like your X direction is normal. But you can see what Wes was talking about with the 3 different tool call outs, and the G50 line doing 3 things at once. Another horribly basic question. The fanuc manual lists the procedure for importing a program on tape but nothing for manually inputting all data. What is the process to input an entire program? You can then start typing. You have to input each command individually. You cannot just type out a whole line. Wouldn't you have to change all the Z tool offsets. I use the G50 as much like the G54 as I can. It makes more sense to me that way. My machine also has a movable home switch for the Z. So, I can move it close to the chuck for short parts. I have to reset the G50 values in the program when I do that. Wouldn't you have to change all the Z tool offsets. I have to reset the G50 values in the program when I do that. It is never the same from part to part anyways. And neither are the tools. The CNMG is just about the only constant. G50 in the 6T is nothing like G54. And how long does it take to touch off a tool anyways.

Takes me about 20 seconds per tool. I can do the whole turret's worth of Z in well under 8 minutes. I am envious of your adjustable Zhome, and distance between centers!!! I set all the Z offsets relative to my T1 trigon. Then I just run it down where I want it, zero the Z read out, and home the machine. The number in Z is the number I put in for the G50. If the parts are a little long or short, I just adjust that G50 number. I've got a few tools that rarely need to change, my trigon, the top notch groove tool, and the laydown threading tool. The drills and bars change a lot. I still need to figure out how to move down to enter a new block of code, though. Practical Machinist is the easiest way to learn new techniques, get answers quickly and discuss common challenges with your peers. Register for the world's largest manufacturing technology forum for free today to stay in the know. Learn more about us. All rights reserved. Register today. To learn more, please refer to the cookie policy. We'll bring you the most relevant peer-to-peer conversations happening in the trade and tips and tricks to help you get the job done. You may unsubscribe at any time. It's been really tough trying to locate manuals for this control even though it's a fanuc. I also need manuals for the lathe itself. That's even more obscure I believe. Anyway, if anyone has 6T manuals, I'd be happy to buy them or a copy from

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111 Exponent of data of floating point representation exceeds the upper bound. 112 Divisor is 0 113 A function that cannot be used by user macro A is used 114 Format error except for 115 Value not defined as variable number is assigned 116 Left side of substituted sentence is a variable of prohibited substitution 118 Nesting of brackets exceeds the upper limit 5. 119 Argument of SQRT is negative, Or argument of BCD is negative 122 Nesting of macro exceeds the upper limit 4 123 Macro control command is used in tape mode 124 DO END is not 11 corresponding 125 Format error of formula 126 Not 1. Another case change connection unit 602 PC program has not yet been loaded 603 The correspondence between NC and PC is incorrect or interrupted. I was looking for a manual myself, but Fanuc South Africa told me it is no more available and that they can scan one for me and that it will cost a small fortune. I manage to loan one from someone and got it scanned myself and saved it into a PDF file. The book is a bit mishandled but it is ok to use. Did you buy it from Fanuc in USA Best regards, Hung from Vietnam Best regards, Hung from Vietnam For further information on cookies, please refer to our privacy policy. More informations about the cookies and further configurations Agree. Please try again. Please try again. Please try again later. In order to navigate out of this carousel please use your heading shortcut key to navigate to the next or previous heading. Register a free business account To calculate the overall star rating and percentage breakdown by star, we don't use a simple average. Discover everything Scribd has to offer, including books and audiobooks from major publishers. Start Free Trial Cancel anytime.

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Errors on Stroke Limit Switch Alarm Alarm Description 210 The movable part of machine touched the X Axis plus stroke limit switch 211 The movable part of machine touched the X Axis minus stroke limit switch 212 While the X Axis was moving in the plus direction, It entered into the forbidden area

of the stored stroke limit 1 213 While the X Axis was moving in the minus direction, It entered into the forbidden area of the stored stroke limit 1 214 While the X Axis was moving in the plus direction, It entered into the forbidden area of the stored stroke limit 2 215 While the X Axis was moving in the minus direction, It entered into the forbidden area of the stored stroke limit 2 220 The movable part of the machine touched the Y axis plus stroke limit switch 221 The movable part of the machine touched the Y axis minus stroke limit switch.

222 While the Y axis was moving in the plus direction, it entered into the forbidden area of the stored stroke limit 1 223 While the Y axis was moving in the minus direction, it entered into the forbidden area of the stored stroke limit 1 224 While the Y axis was moving in the plus direction, it entered into the forbidden area of the stored stroke limit 2 225 While the Y axis was moving in the minus direction, it entered into the forbidden area of the stored stroke limit 2 230 The movable part of the machine touched the Z axis plus stroke limit switch 231 The movable part of the machine touched the Z axis minus stroke limit switch 232 While the Z axis was moving in the plus direction, it entered into the forbidden area of the stored stroke limit 1 233 While the Z axis was moving in the minus direction, it entered into the forbidden area of the stored stroke limit 1 234 While the Z axis was moving in the plus direction, it entered into the forbidden area of the stored stroke limit 2 235 While the Z axis was moving in the minus direction, it entered into the forbidden area of the stored stroke limit 2 240 The movable part of the machine touched the 4th axis plus stroke limit switch 241 The movable part of the machine touched the 4th axis minus stroke limit switch Errors on Servo System Alarm Alarm Description 400 The control received the X, Y or Z axis overload signal 401 The READY signal VRDY of the X, Y or Z axis velocity control has turned off 402 The control received the 4TH axis overload signal 403 The READY signal VARY of the 4TH axis velocity control has turned off 404 The READY signal VARY of the X, Y or Z axis velocity control does not turn off even though the READY signal PRDY of the position control has turned off.

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