Stepping Controller FOR NC ROTARY TABLE

- Easy operation, saving space of macine shop.
- Connecting with CNC Rotary Table to M-Code of CNC M/C for equal division indecing machining.
- The best solution for conventional M/C which could not retrofitted 4th axis.
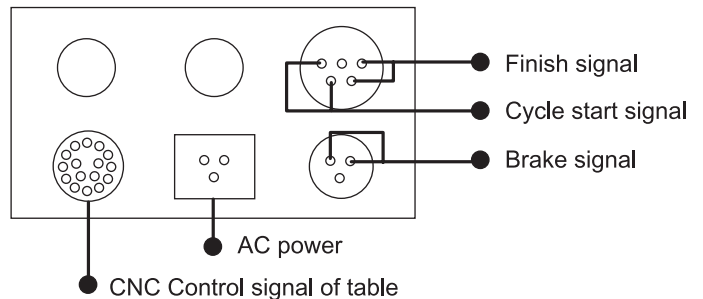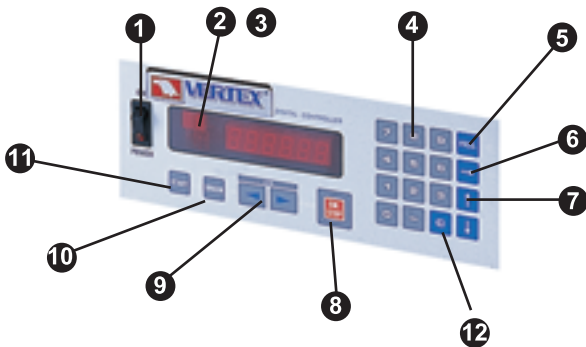- Program Capacity = 3 sets, minimum increment 0.01°

Suitable Rotary Table:

VNCM-150	VNCX-10
VNCM-220	VPX-6A
VNCM-250	VPX-8A
VNCM-320	VTNC-201
VNCM-400	

ITEM	SPECIFICATION	ITEM	SPECIFICATION
Min. Increment	0.01°	key-Lock function	Set Parameter #7 to (1)
Proframmable Angle	1-540°	Mode Selection After Power On	Program mode / Run mode
Max. Equal Dividing	±2-999 equal dividing	Backlash Adjustment	Parameter #17
Emeraency Stop	Whole system stop	Previous Step Display function	Pushing "WRITE" key
Input System	key board	Next Step Display	Pushing "READ" key
Zero Return	Soft ware zero retum	Standard Parameter Function	Parameter #1-17 can be set easily
Feedrate	F1~F30(degree/sec.)	Motor	DC Stepping motor with feed back unit
Program Capacity	Three programs(0,1,2),99 steps for each program		For input power/pulse coder, motor power cycle start/finish signal/brake signal
Jump Function	Jump to srb-program (code. 95)	Input Power	AC 240V/50Hz/signal phase
Loop Count	Up to 999 time per step		

Example

Step 1	Turn (Power) switch on.	Step 5	Push PROG to feed-rate (F), input "30"
Step 2	Push and hold PROG and release display becomes blinking	Step 6	Push FUNC to loops (L), input "4"
Step 3	Push and hold CLR for 5 sec. or "00" display	Step 7	Push PROG display become no blinking
Step 4	Key in "9000"	Step 8	Push START table start rotating 4 times

Finish signal
Cycle start signal
Brake signal
AC power
CNC Control signal of table

ON POWER

1. **POWER SWITCH**
2. **PROGRAM STEP DISPLAY SCAN**
3. **DATA DISPLAY SCAN**
   To show either position, step angle feedrate or loop count.
4. **DATA ENTER KEYS**
   Enter in data of program
5. **MODE BUTTON**
   To select in the PROGRAM or RUN mode
   - If th edisplay is steady, you are in RUN mode.
   - If it is flahing on and off, you are in PROGRAM mode.
6. **FUNCTION BUTTON**
   To view the piece of data in the display scan ofthe controller.
7. **STEP READ or WRITE BUTTON**
   - Scans step number from 1-99.
   - To read or write prevenient or next step.

8. **EMERGENCY STOP BUTTON**
   To select in the PROGRAM or RUN mode
   If th edisplay is steady, you are in RUN mode.
   If it is flahing on and off, you are in PROGRAM mode.
9. **JOG BUTTON**
   To jog the movement at single step, holding for rapid movement after 150 pulse.
10. **ZERO RETURN BUTTON**
    In the RUN mode, push the button will return the table to Zero Point.
11. **CYCLE START BUTTON**
    The table rotates as programmed.
12. **CLEAR BUTTON**
    - In the RUN mode, it resets the "P" display to zero.
    - In the PROGRAM mode, it is used to clear the current line or collect the error