

CM-800ZNC

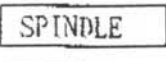
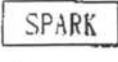


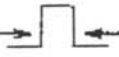
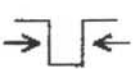
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1. PANEL INTRODUCTION

- (1)  -   : Number key & decimal point key.
- (2)  : +/- switch. Under parameter input mode, it is parameter select key.
- (3)    : X · Y · Z axis key and lamp.
- (4)  : Cordination save key and lamp.
- (5)  : Cancel key and lamp.
- (6)  : Enter key and lamp.
- (7)    : Zero set key.
- (8)  : Edge finding switch and lamp.
- (9)  : Auto Z machining Zero set switch and lamp
- (10)  : Depth set switch and lamp.
- (11)  : Center finding switch and lamp.
- (12)  : Z UP switch. During inputing, it is increase switch.
- (13)  : Z Down swich. During inputing, it is decrease switch.
- (14)  : Pump switch and lamp.
- (15)  : Spindle and lamp.
- (16)  : Spark switch and lamp.
- (17)  : Auto spark switch and lamp.

- (18) XYZ/EDM : XYZ/EDM change over switch and lamp.
RED : XYZ MODE GREEN : EDM MODE
- (19) mm/inch : mm/inch conversion key and lamp.
RED : mm GREEN : inch
- (20) ABS/INC : Absolute/Incremental coordination switch and lamp.
RED : absolute coordination
GREEN : incremental coordination
- (21) CLR : Clear key and lamp. Clear present program and parameters.
- (22) BANK : Page change switch.
Display block : 0 ~ 9
- (23) SIZE : Electrode Dia. Adjustment switch and display block. Block : 0.2mm ~ 3.0mm OR 0.2mm ~ 6.3mm (Set by parameter 14)
- (24)  : HIV switch and display block.
Block : 1 ~ 3
(1 : 100V 2 : 125V 3 : 150V)
- (25)  : LV switch and display block.
Block : 0 ~ 25A OR 0 ~ 50A
(Set by parameter 14)
- (26)  : Pulse on switch & display block.
Block : 00 ~ 99
- (27)  : Pulse off switch & display block.
Block : 00 ~ 99

- (28)  : Capture adjustment switch & display block.
Block : 00 ~ 15
- (29)  : Spindle speed switch & display block
Block : 0 ~ 7
- (30)  : Gap switch & display block.
Block : 00 ~ 99
- (31)  : Z axis feed switch & display block.
Block : 00 ~ 99
- (32) MAIN MENU : X Y Z MODE : X : X Cordination
Y : Y "
Z : Z "
EDM MODE : X : Z axis cordination
Y : distance to machining depth
Z : depth set
DEPTH MODE : X : depth set
Y : estimated wear
Z : total depth
PARAMETER MODE : X : previous parameter
Y : present parameter
Z : next parameter
- (33) VOLTAGE METER : Voltage display.
- (34) AMPERE METER : Ampere display.

2. OPERATION

(1) Cordination Input :

Choose axis direction, and then the lamp lights. Input parameter by number key. The values show on display menu. If confirm to input, please press **ENT**. If cancel, please press **CE**. If it is wrong, controller clears input value automatically. If the last code of input value does not fit resolution, controller can correct.

EX : Input value : 555.321 DRO Resolution : 5μ

Controller can correct as 555.320 .

(2) DEPTH Input :

Press **DEPTH SET** to enter wanted depth. The value shows on X menu. Press **ENT** to enter. Press **CE** to cancel. Enter expected wear the value shows on Y menu. Press **ENT** to enter. Press **CE** to cancel. At this time, total depth shows on Z menu for 2 seconds. Later, go back to DRO display mode, depth input is finished.

(3) Center Finding :

Determine the axis. Press **1/2** and lamp lights. At this time, **EDGE** starts automatically. Make electrode contact workpiece. Then buzzer sounds. Press **ENT** or press number key to enter the value. It is the first point. Besides, make electrode contact the other side of workpiece. Press **ENT** to enter the 2ND point. Instantaneously, one value shows on the screen. Move ram to make the value as "0". Center finding is finished. If press **CE** during operating. Center finding will be gone. :

3. SYSTEM PARAMETER SETTING :

Pressing **[CE]** , and then enter "2776498". Parameter shows on main menu. Press **[↑]** **[↓]** to choose parameter NO. The decimal point of choosen parameter can sparkle. Press **[+/-]** to change parameter value. Press **[ENT]** to enter.

System parameter as bellow :

P01 : X direction count setting (0 , 1)	Expected Value : 0	:
P02 : Y	" (0 , 1)	" : 0
P03 : Z	" (0 , 1)	" : 1
P04 : 3 axis DRO type (40, 20, 4)	"	" : 20
P05 : 3 axis DRO rate (1, 2, 4)	"	" : 4
P06 : First key duration (0, 1, 2, 3, 4)	"	" : 3
P07 : Key board repeat speed (1, 2, 3, 4, 5)	"	" : 4
P08 : Servo speed (1, 2, 3, 4, 5)	"	" : 4
P09 : Edge sensity (0, 1, 2, 3, 4, 5, 6, 7, 8, 9)	"	" : 8 (4)
P10 : Sound switch (1, 0)	"	" : 1(ON)
P11 : As soon as depth reach, Z auto rise (1, 0)	"	" : 1(ON)
P12 : As soon as depth reach, pump and spindle are drsed auto matically. (1, 0)	"	" : 1(ON)
P13 : Auto Z Zero return during sparking (1, 0)	"	" : 1(ON)
P14 : Auto current change during sparking (1, 0)	"	" : 1(ON)
P15 : Is machine 25A or 50A? (1, 0)	"	" : 0(25A)
P16 : Clear all parameter? (1, 0)	"	" : 0(keep)

If pressing **[CE]** and then press "2704960". All system parameter is expected value.

P17 = 6
P18 = 4
P19 = 1
P20 = 4
P21 = 1
P22 = 1
P23 = 2
P24 = 1
P25 = 90
P26 = 1

4. SIMPLE OPERATION STEPS

- (1) Check power, connection cable.
- (2) Press "ON" switch to start.
- (3) Set electrode.
- (4) Select BANK and SIZE.
- (5) Enter sparking parameter (It will be saved automatically)
- (6) Z axis surface Zero return.
- (7) Depth setting.
- (8) Press **PUMP** to start pump. Adjust adequate pressure.
- (9) Press **SPINDLE** . Adjust adequate spindle speed.
- (10) Press **SPARK** to spark.
- (11) Adjust GAP, SERVO until V-meter is stable.
- (12) Reach depth. Electrode raises. Machining is finished.
- (13) Clean work table.
- (14) Press "OFF" to turn off.

ECTRODE E DIA	HV	LV	on-time	off-time	capacitor	spindle speed	GAP	SERVU	1/CN water pressure
0.2	1	05	15	16	00	5	10	56	100
0.3	1	09	18	17	00	5	10	60	100
0.4	1	12	20	18	00	5	10	70	100
0.5	1	14	20	16	00	5	10	85	90
0.6	1	15	22	16	00	5	10	85	90
0.7	2	17	22	18	00	5	25	45	80
0.8	2	21	22	16	00	5	24	50	80
0.9	2	24	26	20	00	5	24	50	80
1.0	3	25	30	20	00	6	24	50	75
1.1	3	25	32	20	00	6	24	50	75
1.2	3	25	34	22	00	6	24	47	75
1.3	3	25	36	23	00	6	25	42	70
1.4	3	25	37	24	00	6	25	38	70
1.5	3	25	38	25	00	7	25	35	65
1.6	3	25	38	25	00	7	24	36	60
1.7	3	25	39	25	00	7	23	36	50
1.8	3	25	40	25	00	7	22	37	50
1.9	3	25	41	25	00	7	21	37	40
2.0	3	25	42	25	00	7	20	38	40
2.1	3	25	44	25	00	7	20	38	40
2.2	3	25	44	25	00	7	20	38	40
2.3	3	25	46	25	00	7	20	39	35
2.4	3	25	48	25	00	7	20	40	35
2.5	3	25	50	26	00	7	17	42	30
2.6	3	25	52	27	00	7	18	44	30
2.7	3	25	55	27	00	7	18	45	25
2.8	3	25	58	28	00	7	18	46	25
2.9	3	25	62	30	00	7	17	48	25
3.0	3	25	65	30	00	7	16	50	25

Brass → SKD 11 ~ TECHNOLOGY TABLE.



Anotronic-SKM EDMs
Manual, ZNC, CNC



Anotronic-Ocean
EDM Drilling Machines
Manual, ZNC, CNC



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5axis cnc Milling

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- Sale of Standard Electric Discharge Machines (Manual, ZNC & CNC) to take components up to 2500mm x 1200mm x 700mm.
- Design, Manufacture & Sale of Electrochemical Deburring Machines (ECM)
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- ECM Sub-Contract Service.
- Wire EDM Sub-Contract Service with cutting areas up to 500mm x 320mm x 420mm HIGH.
- EDM small hole drilling Machines and Sub-Contract Service.
- EDM/ECM Consultancy Service.

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