

Technical data of C-88

Type of control:	Path control for 2-8 servo- and/or stepper motors	
Design:	19" modular housing, 483x134x360mm W/H/D + connectors and cables	
Keyboard:	Membran keys with contact point, IP 55	
Display:	LCD, TFT 10",14",15 ",19"/6HE housing	
Data storage:	512 KB RAM accumulator buffer; option 1-4 MB memory expansion	
Inputs/Outputs: (opto de coupling)	Limit switch, spindle, cooling, clamping, reference input, position transducer or glass measuring	
Interface:	2 x serial V24, 1 x USB	
Regulator output:	+/- 10V for servo amplifier	
Controller output:	step and direction for stepper motor	
Signal input:	max. 64 pieces, 24V,	opto de coupling (Option)
Signal output:	max. 64 pieces, 24V, 0,5A,	opto de coupling (Option)
Power:	230V ~, 120VA max.	

LIST OF G-FUNCTIONS CNC SERIES C-88

DIN 66025

G 00 RAPID TRAVERSE	G 53 DISPLACEMENT OFF
G 01 LINEAR INTERPOLATION	G 54 DISPLACEMENT ON
G 02 CIRCLE CW	G 55 DISPLACEMENT
G 03 CIRCLE CCW	G 58 MEMORIZE ZERO POINT
G 04 DWELL TIME	G 59 PUT T IN MEMORY
G 05 CIRCLE WITH RADIUS CW	G 67 SOFTWARE LIMIT SWITCH -
G 06 CIRCLE WITH RADIUS CCW	G 68 SOFTWARE LIMIT SWITCH +
G 07 CIRCLE WITH ANGLE	G 74 REFERENCE POINT
G 08 ASYNCHRONOUS MOVEMENT	G 75 SCALE FACTOR ON
G 09 SKIP REST OF TRAVEL	G 76 SCALE FACTOR OFF
G 10 CORNER ROUNDING (OPTION)	G 78 FREE CYCLE
G 11 ADDITIONAL FUNCTIONS F, S, T	G 79 FREE CYCLE
G 12 ADDITIONAL M-FUNCTIONS	G 80 CYCLE OFF
G 13 ADDITIONAL M-FUNCTIONS	G 81 FREE MODAL CYCLE
G 17 PLANE XY	G 82 DEEP DRILLING (MODAL)
G 18 PLANE XZ	G 83 FREE CYCLE
G 19 PLANE YZ	G 84 FREE CYCLE
G 20 JUMP TO PROGRAM	G 85 POCKET CYCLE
G 22 CALL PROGRAMM	G 86 CIRCLE SEGMENTATION
G 23 CALL/ JUMP WITH CONDITION	G 87 CIRCLE POCKET
G 33 TAPPING	G 88 LINEAR SEGMENTATION
G 36 TOOL CHANGE	G 89 FREE CYCLE
G 40 RADIUS CORRECTION OFF	G 90 ABSOLUT INPUT
G 41 RADIUS CORRECTION LEFT	G 91 INCREMENTAL INPUT
G 42 RADIUS CORRECTION RIGHT	G 92 SET ACTUAL VALUE
	G 94 FEEDRATE IN MM/MIN

PARAMETRICAL FUNCTIONS

↓ 00 ASSIGN VALUE	↓ 17 CALCULATE COSINE (VALUE X1000)
↓ 01 *ADDITION	↓ 18 *LOGICAL AND FUNCTION
↓ 02 *SUBSTRACTION	↓ 19 DIVISION BY 2
↓ 03 *MULTIPLICATION	↓ 20 *LOGICAL OR FUNCTION
↓ 04 *Division	↓ 50 JUMP IF RESULT ZERO
↓ 10 COPY CONTENTS	↓ 51 JUMP IF RESULT POSITIVE
↓ 11 ARCUSTANGENS OF (#02)/(#03)	↓ 52 JUMP IF RESULT NEGATIVE
↓ 12 #002 = SQRT ((#02) ² + (#03) ²)	↓ 53 JUMP WITHOUT CONDITION
↓ 13 CALCULATE COMPLEMENT	↓ 54 JUMP IF RESULT NOT ZERO
↓ 14 CALCULATE ABSOLUTE VALUE	↓ 55 DECREMENT REGISTER #099 AND JUMP IF #099 NOT EQUAL TO 0
↓ 15 CALCULATE THE ROOT	
↓ 16 CALCULATE SINE (GIVES SINE X1000)	STARTING FROM ↓ 80 SPECIAL FUNCTIONS