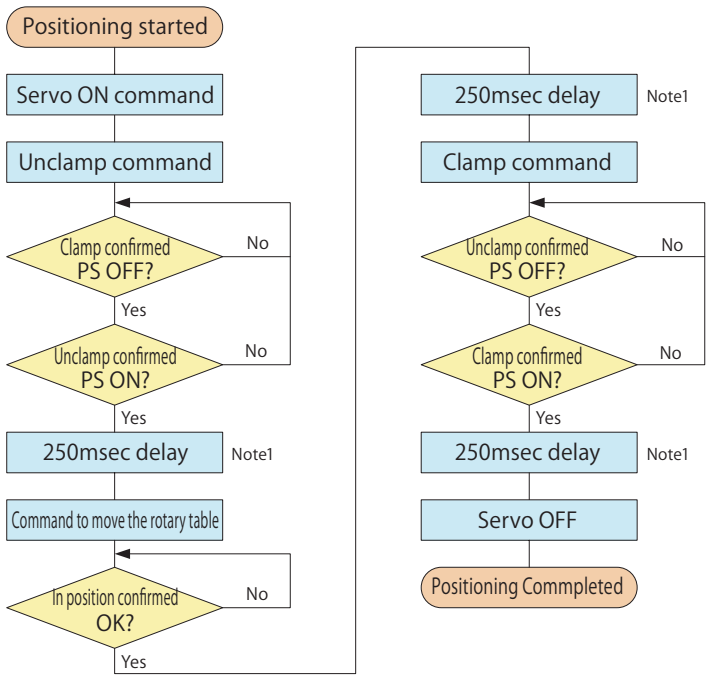
DATA Control Detail

■ Control Flow-Chart

It is in principle recommended for Kitagawa's NC rotary table control to turn the servo OFF while clamping.

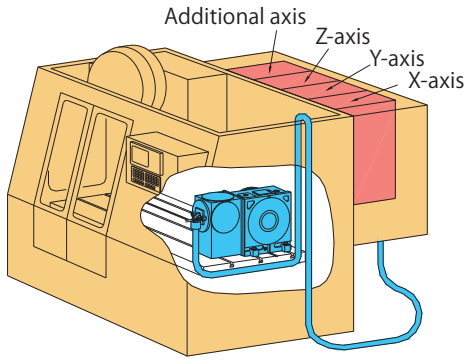
Semi-／Full-Closed Loop



Note1) The delay timing here is a recommended value. It may differ with different parameters or specifications.

■ Methods for Controlling NC Rotary Table

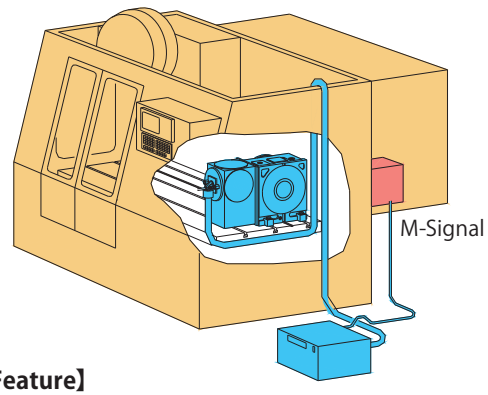
Additional-Axis Method



【Feature】

- ◆NC Rotary Table is controlled as the NC Axis of the machine.
- ◆Interpolation machining is possible with X- , Y- and Z-axis of the machine.
- ◆Program can be controlled on the machine.

M-Signal Method



【Feature】

- ◆NC Rotary Table is controlled by a separate controller, and not as the NC Axis of the machine.
- ◆NC Rotary Table can be fitted with machine with no compatibility for an additional axis, as long as M-signal is available.
- ◆NC Rotary Table can easily be transferred to another machine.