

Instruction Manual

CNC TAPPING CENTER

TC-217

TC-227

INCH

brother®

CONTENTS

CHAPTER 1	GENERAL PRECAUTIONS	1
1-1	Precautions of First Importance	2
1-1-1	When feeding an axis	2
1-1-2	When indexing the magazine	2
1-1-3	When performing an automatic operation	2
1-1-4	When performing a maintenance work or setup	3
1-1-5	In case of machine trouble or danger	3
1-2	Precautions on Safety	4
1-2-1	Before turning on the machine	4
1-2-2	Before starting an operation	4
1-2-3	During an operation	4
1-2-4	If a machine trouble occurs during an operation	5
1-2-5	When turning off the machine	5
1-2-6	Other precautions	5
CHAPTER 2	GENERAL SYSTEM DESCRIPTION	7
2-1	Main Features	8
2-1-1	ATC (Automatic tool changer)	8
2-1-2	Tapping cycle	8
2-1-3	Spindle head	9
2-1-4	X-, Y- and Z-axis feeding mechanisms	9
2-1-5	CNC unit	9
2-2	Basic Configuration	10
2-2-1	Basic configuration	10
2-2-2	Machine rear	11
2-3	Overall View and Major Dimensions	12
2-4	Table Size and Machining Volume	16
2-4-1	Table top surface dimensions	16
2-4-2	Sub table top surface dimensions	18
2-4-3	Machining volume	20
2-5	Machine Specifications	22
2-6	Accessories	26
2-6-1	Standard accessories	26
2-6-2	Optional accessories	27
2-7	CNC Unit Specifications	28
2-8	Characteristics of Spindle Motor	30

2-9	Machining Capability -----	34
2-10	Safety Devices -----	36
2-10-1	Main safety devices -----	36
CHAPTER 3 INSTALLATION -----		37
3-1	Environmental Standards for Installation -----	38
3-1-1	Environmental conditions -----	38
3-1-2	Notes for installation -----	38
3-2	Installing the Machine -----	40
3-3	Relocating the Machine -----	42
3-3-1	Preparation for relocation -----	42
3-3-2	Unloading the fork lift from the fork lift -----	44
3-3-3	Levelling -----	45
3-4	Wiring between Primary Power and Machine Power -----	46
3-4-1	Opening and closing the door of the CNC unit -----	46
3-4-2	Grounding -----	47
3-4-3	Power specifications for wiring -----	47
3-4-4	Wiring for AC200V power supply -----	48
3-4-5	Wiring for (1) AC210-230V or (2) AC230-264V power supply -----	49
3-4-6	Arranging the power supply cables in the panel -----	50
CHAPTER 4 MAINTENANCE -----		51
4-1	Regular Inspections -----	52
4-2	Inspection of machine lubricants -----	54
4-2-1	Greasing interval -----	54
4-2-2	Recommended grease -----	54
4-2-3	Lubricating points -----	55
CHAPTER 5 OPERATION -----		59
5-1	Turning on the Power -----	60
5-1-1	Preliminary checks -----	60
5-1-2	Turning on the power -----	60
5-2	Turning off the Power -----	62
5-2-1	Checks before turning off the power -----	62
5-2-2	Turning off the power supply -----	62

5-3	Cautions on Workpiece and Tool Setting -----	64
5-3-1	Limitations on workpiece and jig height and tool length -----	64
5-3-2	Limitations on tool holder -----	65
5-4	Setting and Removing a Tool on and From the Magazine -----	66
5-4-1	Setting a tool on magazine -----	66
5-4-2	Removing a tool from the magazine -----	67
5-5	Operation Panel Overview -----	68
5-6	EL Screen -----	69
5-7	Switches -----	70
5-8	Keys -----	73

CHAPTER 6 MANUAL OPERATION ----- 81

6-1	Manual Operation -----	82
6-2	Zero Point Return -----	83
6-3	Working Zero Point Return -----	84
6-4	Axis Feed -----	86
6-4-1	Rapid traverse -----	86
6-4-2	Jog feedrate -----	87
6-4-3	Step Feed -----	88
6-5	Starting and stopping Spindle -----	90
6-6	Tool Change -----	91
6-7	Magazine Rotation -----	92

CHAPTER 7 DATA BANK ----- 93

7-1	Overview of Data Bank -----	94
7-2	Data Input, Modification and Reference -----	95
7-3	Tool Registration -----	96
7-4	Tool Registration with Auxiliary Code -----	100
7-5	Setting Tool Length -----	102
7-6	Setting Tool Pattern -----	106
7-7	Setting Primary Hole Drilling Diameter for Tapping -----	110
7-8	Setting Cutting and Tool Conditions -----	114

7-9	Setting Parameters -----	120
7-10	Data Bank -----	122
CHAPTER 8 MDI OPERATION -----		199
8-1	Setting Data -----	200
8-2	Operation by Data Entered -----	202
8-2-1	Setting a coordinate system -----	202
8-2-2	Providing an output of external signal -----	203
8-2-3	Setting a tool in the spindle -----	203
8-2-4	Turning on and off coolant supply -----	204
8-2-5	Running and stopping the spindle -----	204
8-2-6	Feeding an axis -----	205
8-3	Setting Tools to Be Mounted on The Magazine (1) -----	206
8-4	Drilling -----	208
8-5	Tapping -----	210
CHAPTER 9 MEMORY OPERATION -----		213
9-1	Outline of Memory Operation and Its Procedure -----	214
9-1-1	Types of memory operation -----	214
9-1-2	Memory operation procedure -----	215
9-2	Setting Tools to Be Mounted on The Magazine (2) -----	216
9-2-1	Assigning the main tool -----	216
9-2-2	Setting the spare tool -----	217
9-3	Test Operation -----	220
9-3-1	Dry run -----	220
9-3-2	Single operation -----	222
9-4	Cycle Operation -----	224
9-5	Memory Operation -----	226
9-6	Setting the Starting Point -----	230
9-6-1	Display of start point setting -----	231
9-6-2	Start point setting procedure -----	232
9-6-3	Cautions on starting point setting -----	234
9-7	Running a Schedule Program -----	238
9-8	Setting a Schedule Program Number -----	239
9-9	Feed Hold and Emergency -----	240

9-9-1	Feed hold -----	240
9-9-2	Emergency Stop -----	240
9-10	Reset -----	242
CHAPTER 10 ALARM MESSAGE -----		243
10-1	Alarm Message Screen -----	244
10-2	Error Code List -----	246
10-2-1	How to use the error code list -----	246
10-2-2	Spindle, X-, Y- and Z-axis positioning check in case of servo error -----	247
10-3	Battery Fault Alarm -----	274
10-4	I/O Status Display -----	276
PRODUCTION COUNTER (STANDARD SPECIFICATIONS) -----		289
1	Setting on the production counter screen -----	290
2	Setting items -----	292
3	Production counter activating comand in a program -----	295
EXTERNAL INPUT/OUTPUT SIGNALS -----		297

CONTENTS OF OPTION

CHAPTER 1	COOLANT UNIT	329
1-1	External view	331
1-2	Specifications	332
1-3	Installation	332
1-4	Piping	333
1-5	Wiring	334
1-5-1	Setting the optional panel switch	336
1-6	Confirming the installation of the coolant unit	337
CHAPTER 2	SPINDLE TAPER AIR BLAST UNIT	339
2-1	External view	340
2-2	Cautions on handling	341
2-3	Installing position	341
2-4	Piping	342
2-5	Wiring	343
2-6	Motion check	343
CHAPTER 3	MANUAL PULSE GENERATOR	345
3-1	External view	346
3-2	Operating procedure	347
3-3	Installation	348
3-4	Motion check	350
CHAPTER 4	INDICATION LAMP	353
4-1	External View	355
CHAPTER 5	MACHINE LIGHT	359
5-1	External View	360
5-2	Mounting Method	361
5-3	Motion Check	363
CHAPTER 6	EXTERNAL COMMUNICATION UNIT	365
6-1	External View	366
6-2	Mounting Method	367
6-3	System Configuration	369
6-4	communication Protocol	369
6-4-1	Specifications of serial interface	369
6-4-2	Printer interface	371

6-4-3	Reader/puncher mode	372
6-4-4	Computer (master station: T/C) mode	375
6-4-5	Computer (slave:T/C) mode	379
6-4-6	Printer mode	383
6-5	Communication Parameters	383
6-6	Alarm List	386
6-7	Data Compatibility with the Models TC-211, 215 and 225	388
6-8	Data Compatibility with the Models TC321 and 205	388
6-9	Character Code Table	389
CHAPTER 7 BUBBLE CASSETTE		391
7-1	External View	392
7-2	Part Name	393
7-3	Standards	393
7-4	Adapter	394
7-4-1	Adapter	394
7-4-2	Cassette	395
7-5	Method of Use	396
7-5-1	Cassette insertion procedure	396
7-5-2	Cassette ejection procedure	396
7-5-3	Write-protection of data	396
7-5-4	Label for note	396
7-5-5	Cassette storage case	397
7-6	Mounting Method	398
CHAPTER 8 AUTOMATIC ALIGNEMENT UNIT		399
8-1	Measuring Shape	400
8-2	Mounting and Dismounting the SONY TS 1	401
8-2-1	Mounting an automatic centering box	401
8-2-2	Mounting an automatic centering tool	403
8-2-3	Operation check	404
8-2-4	Dismounting an automatic centering tool	404
8-3	Setting Various types of Data Banks for Automatic Centering	405
8-3-1	Tool list	405
8-3-2	Magazine tool	406
8-3-3	Parameter	407
8-4	Cautions to be taken before Starting	409
8-5	Operating Procedure	410
8-5-1	Calling the automatic centering screen	410
8-5-2	1. Angle: measurement of X and Y coordinates of an angle	411
8-5-3	2. Parallel: measurement of X and Y coordinates of the axis of a parallel groove or boss	415
8-5-4	3. Center of circle (groove): measurement of X and Y coordinates of the center of a circle (groove)	419

8-5-5	4. Center of circle (boss): measurement of X and Y coordinates of the center of a circle (boss) -----	423
8-5-6	5. Z-axis height: measurement of Z-axis ordinate on the workpiece top -----	430
8-5-7	Automatic coordinate setting with [F4] key -----	434
8-6	Motion Display and Mode Switching during Automatic Centering -----	435
8-6-1	Mode switching -----	435
8-6-2	Motion display -----	435