
SUPER KIATURN 15/21 CNC HIGH SPEED LATHE

OPERATION MANUAL

(FANUC Oi-TB)

VERSION No. : 1.0



KIA HEAVY INDUSTRIES

Contents



I . INTRODUCTION

II . SAFETY .

III . SPECIFICATION

IV . OPERATION





INTRODUCTION

I . INTRODUCTION

1. Outline of The MANUAL	I -5
1-1. Symbol and Description	I -6
2. Characteristics	I -7
3. Standard Accessory	I -7
4. Special Accessory	I -8



SAFETY

II . SAFETY

1. General	II -5
2. General Safety Precautions	II -6
3. Notice When Operating the Machine	II -10
4. Notice When Repairing and Checking	II -14
5. Notice on the Electric And NC Devices	II -17
6. Safety Device	II -19
6-1. Name Plates	II -19
6-2. Safety Device	II -20
6-2-1. Door Lock System(Applicable only to the C.E.)	II -20
6-2-2. Pressure Switch(Applicable only to the C.E.)	II -21



Specification

Ⅲ . Specification

1. Introduction	Ⅲ -5
1-1. Head Stock	Ⅲ -5
1-2. Tool Post	Ⅲ -5
1-3. Tail Stock	Ⅲ -5
2. Specification	Ⅲ -6
2-1. Spindle Output and Torque Diagram	Ⅲ -7
3. NC Device Specification(FAUNC Oi-TB)	Ⅲ -8
3-1. G Function	Ⅲ -11
3-2. M Function (Auxiliary)	Ⅲ -13
4. Machine Part and Name	Ⅲ -16
5. Machine Outline Diagram	Ⅲ -17
6. Head Stock	Ⅲ -18
6-1. SUPER KIATURN 15	Ⅲ -18
6-2. SUPER KIATURN 21	Ⅲ -19
6-3. Major dimension of Head Stock	Ⅲ -20

7. Chuck and Rotary Cylinder	III -21
7-1. Hollow Chuck Major Dimension	III -21
7-2. SUPER KIATURN 15 Hollow Chuck	III -22
7-2-1. Connecting Parts for Rotary Cylinder	III -22
7-2-2. Major Dimensions	III -23
7-3. SUPER KIATURN 21 Hollow Chuck(8", ϕ 210)	III -23
7-3-1. Connecting Parts for Rotary Cylinder.	III -23
7-3-2. Major Dimensions	III -24
8. Tool Post	III -25
8-1. Turret	III -25
8-2. SUPER KIATURN 15	III -26
8-3. SUPER KIATURN 21	III -27



OPERATION



IV . OPERATION

1. Main Operating Panel	IV -7
1-1. Switch and Description	IV -8
2. NC Operating Panel	IV -15
3. Machine Operation	IV -19
3-1. Work Preparation	IV -19
3-2. Reference Point Return	IV -21
3-2-1. Reference Point Return 1	IV -21
3-2-2. Reference Point Return 2	IV -22
3-3 Completion of Work	IV -23
4. Manual Operation	IV -24
4-1. Feed of each Axis	IV -24
4-1-1. Handle Feed	IV -24
4-1-2. Jog Feed	IV -24
4-2. Tool Offset Amount Measurement	IV -25
4-2-1. Q-Setter Operation Method	IV -25
4-2-2. Q-Setter Operation of Thread Cutting Bite Tool	IV -29
4-2-3. Tool unable to measure using Q-Setter	IV -30
4-2-3-1. Tool Compensation in the Z direction.....	IV -30
4-2-3-2. Tool Compensation in the X direction	IV -33
4-3. Soft Jaw Cutting	IV -35

5. MDI (Manual Data Input) Operation	IV-38
5-1. MDI Program Input	IV-38
5-2. MDI Program Edit	IV-39
5-3. MDI Program Operation	IV-40
6. Program Registration	IV-41
6-1. From External Input Device	IV-41
6-2. Manually Using Address/Numeric Key	IV-43
7. Program Search	IV-44
7-1. Program No. Search	IV-44
7-2. Sequence No. Search	IV-45
8. Program Edit	IV-45
8-1. Preparation Prior to Program Edit	IV-45
8-2. Search of Word	IV-45
8-3. Program Edit	IV-47
9. Program Punch Out	IV-53
10. The Marking and Setting of Tool Offset Amount	IV-54
11. Setting of Work Coordinates System Shift Amount	IV-57
12. Automatic Operation	IV-60
12-1. Newly Made Program Operation	IV-60
12-1-1. Program Check	IV-60

12-1-2. Test Cutting	IV-61
12-2. Start in the Middle of Program	IV-62
12-3. Program Memory Operation	IV-63
12-4. Manual Operation During Automatic Operation	IV-64
12-5. MDI Operation During Automatic Operation	IV-66
13. Stroke Check	IV-67
14. Parameter Setting	IV-71