

CNCmakers Limited

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GSK928TEII TURNING MACHINE CNC SYSTEM

GSK928TEII Turning Machine CNC System has stable performances and many functions, matched with our AC servo drive unit to compose the high performance CNC system. The system can match other drive units according to the user's requirements.



Brief

- CPLD hardware interpolation, μm precision, and max. rapid traverse speed 15m/min;
- Acceleration/deceleration characteristics, auxiliary function logic are set by the user;
- Inch/metric single/multi thread machining, rigid tapping function;
- 480×234TFT color display, tool path imitation;
- Chinese/English operation panel, standard ISO code edit in full screen;
- Match with AC servo drive unit and servo motor to get the high cost-performance, match with the medium CNC turning machine;

Specification

Motion control	Controlled axes: X, Z	Least command increment: 0.001mm
	Interpolation: X, Z linear, arc interpolation	
	Maximum programmable dimensions: $\pm 8000.000\text{mm}$	Max. rapid traverse speed: 15000mm/min
	Max. cutting feedrate: linear 6000mm/min, circular 3000mm/min	
	Feedrate override: 16 steps 0~150%	
	Rapid override: 25%, 50%, 75%, 100% (valid in Manual/Auto mode)	
	Acceleration/deceleration: automatic acceleration/deceleration, its time can be adjusted	
	MPG: $\times 1\text{mm}$, $\times 10\text{mm}$, $\times 100\text{mm}$	
Display window	Display: 480×234TFT color display	
	Display mode: Chinese/ English	Graph display: tool path imitation
G command	26 G commands including fixed/compound cycle machining, Z drilling tapping and so on.	
Thread function	Metric/inch single and multiple straight, taper thread, high-speed retraction with setting the retraction distance	
	Pitch: 0.250~100.00mm(metric)	100.000~0.250 tooth/inch(inch)
	Rigid tapping function	

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	Spindle encoder: 1024p/r or 1200p/r incremental encoder (transmission ratio is 1:1)		
Compensation	backlash: (X, Z) 0~10.00mm		
	Tool compensation: 32 groups tool length compensation		
Tool function	Tool setting mode: fixed point and trial cutting	Optional tool post: 4~8 tool selection tool post	
	Tool selection signal input mode: No. 1~ No. 4 tool selection signal direct input, No. 5~8 tool selection encode input		
	Tool change: T command absolute or manual relative tool change, CCW tool selection, in-position clamp		
	Tool compensation mode: traverse tool/modify coordinates		
Spindle function	Control mode: gear or analog control		
	Gear control: S1, S2, S3, S4 direct output or BCD encode output S0~S15, manually gear shifting		
	Analog control: three gears, output 0~10V spindle speed		
	Constant surface cutting function: have(valid in spindle analog control model)		
Auxiliary function	Spindle CCW, CW, stop, brake; cooling ON/OFF; lubricating ON/OFF; chuck release/clamp; tailstock forward/backward; chuck clamp: outer/inner(set by a parameter) ; 2 user input signals, 2 user output signals		
Program edit	Program capacity: 62 KB, 100 programs	Format: ISO command, incremental/compound programming	
	Subprogram: editable	Program, parameter power-down hold	
Communication	RS232 communication interface is standard configuration; optional to the communication function which provides the communication software and communication cable, two-way transmitting programs between PC and CNC or CNC and CNC.		
Optional drive unit	Switch power: GSK PC (installed and connected)		
	Drive unit: DA98 AC servo Drive unit		
	Tool post controller: GSK TC (optional to 4~8 tool selection tool post for user to change)		
Panel dimension	Aluminum alloy panel 420mm×260 mm	Weight	Net weight: 5Kg Gross weight: 7.35Kg

G command List

Command	Function	Command	Function
G00	Rapid traverse (positioning)	G22	Partial cycle start
G01	Linear interpolation	G80	End of partial cycle
G02	CW arc interpolation	G50	Workpiece absolute coordinate system setting
G03	CCW arc interpolation	G31	jump
G33	Thread cutting	G26	X, Z reference point return
G32	Tapping cycle	G27	X reference point return
G90	Outer, inner cylinder surface cycle	G29	Z reference point return
G92	Thread cutting cycle	G04	Dwell
G94	Outer, inner taper cycle	G96	Constant surface speed control
G74	End face drilling cycle	G97	Constant surface speed control cancel
G75	Outer, inner grooving cycle	G93	System offset
G71	Outer roughing cycle	G98	Feed per minute
G72	End face roughing cycle	G99	Feed per rev

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Ordering Type and Configuration

Ordering Type

Type	Explanation
GSK928TE II	Aluminum panel (420mm×260mm)

Configuration

Type	GSK928TEII
Standard Configuration Function	Relational function in “Technical specification”
Optional Configuration Function	Communication: The bidirectional transformation of program and parameter data between system and PC are realized.
Function Standard Configuration Attachment	One piece for GSK-PC2 switch power (installed on CNC) DB socket: two pieces of DB9 female, one piece of DB9 male, one piece of DB15 female, one piece of DB25 female and one piece of DB25 female DB head rubber box: three sets of 9B rubber box, two sets of 15P rubber box and two set of 25P rubber box Cables: 8 cores shield wire 18m (input interface 3m×2, output interface 3m×2, tool-post interface 3m and encoder interface 3m) 10 cores shield wire (X and Z axis interface 3m×2) Anti-interference elements: six of 104/630V capability, eight of IN4007 diode A copy of 928TE II User Manual
Optional Configuration Attachment	Communication elements: five meters of communication cable, one piece of communication soft disk (with communication function) Additional panel: AP01 (Aluminum alloy 420×71mm), consolidated under the CNC Electrical MPG: ① Mini MPG: Changchun Yiguang ZGB-3-001-100 or Wuxi Ruipu RGT600-B01-100B/051-2 ② Big MPG: Changchun Yiguang LGF-001-100 or Wuxi Ruipu RGT800-B01-100B/051-2. Switch: ① ESP switch LAY3-02ZS/1 ② Auto-lock switch KH-516-B21 (Red or green) Non auto-lock switch KH-516-B11 (Red or green)

Explanation:

1. When the cables with such as drive unit, tool-post controller etc products are offered in whole set in terms of the non welding form, the welded cables are then provided.
2. When the products are provided in whole set with drive unit, tool-post controller, the DB socket of corresponding interface offers with the welded signal.