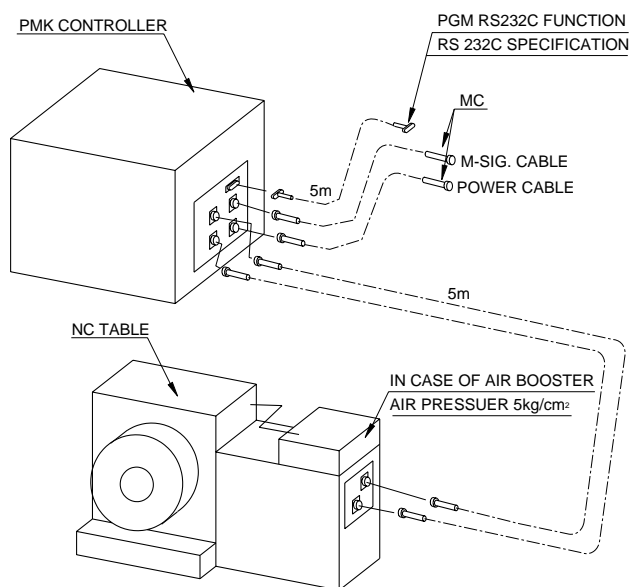


# 1 or 2 AXIS CONTROLLER



## CABLE CONNECTION



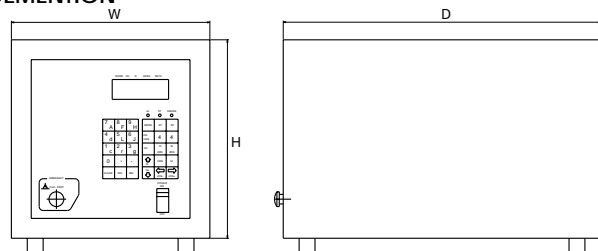
## PMK CONTROLLER SPECIFICATION

ITEMS	CONTENTS
NUMBER OF AXIS	1AXIS or 2AXIS
MIN INDEXING UNIT	0.001degree
MAX INSTRUCTION FIGURE	± 999.999degree
PROGRAM CAPACITY	100 steps × 16 channels
PROGRAM CONTROL FUNCTION	Repeat function, jump, sub-program, in-gear, continuous start
RS232C SPECIFICATION	When it adopts the running way as connecting with NC machine(machining center) and revolving the table as receiving the revolving angle command value in ON LINE.(In this case,it is unnecessary to make up the program of controller)
EXTERNAL PROGRAM SELECTION	16 PROGRAM
ROTARY SCALE FEED BACK	OPTIONS
INPUT INTERFACE	RS232C

## MODE

	CONTENTS
PROGRAM MODE	Editing and display of program
PRESENT POSITION DISPLAY MODE	Display of program execution, executing channel, step number, and present position.
DIAGNOSIS MODE	In spite of program execute or stop, display inside state.
PARAMETER CHANGE MODE	Editing and display of parameter.
ON LINE MODE	The ON LINE automatic running by the data correspondence.

## DEMENTION



## PMK CONTROLLER SPECIFICATION

MODEL	AXIS	ELECTRIC SOURCE	DEMENTION			APPLICABLE MODEL
			W	H	D	
PMK-800-1	1	2.5KVA	250	250	300	KDH203,KDH302,MDH232,MDB232,MDAT232(TILTING AXIS),MT200
PMK-1000-1	1	2.5KVA	335	335	400	MDH233,MDH322,MD322,MDAT322(TILTING AXIS)
PMK-2600-1	1	5.3KVA	355	335	400	MD323,MD400,MD500,MDAT400(TILTING AXIS)
PMK-3300-1	1	6.7KVA	355	335	400	MD403,MD630,MDAT630(TILTING AXIS)
PMK-5000-1	1	13KVA	385	415	400	MD1000,MD1200
PMK-800-2	2	5KVA	385	415	400	MDAT232
PMK-1000-2	2	5KVA	385	415	400	MDAT233,MDAT322
PMK-2600-2	2	10.3KVA	385	415	400	MDAT323,MDAT400
PMK-3300-2	2	13.4KVA	385	415	400	MDAT403,MDAT630

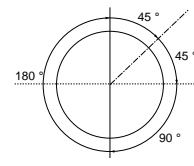
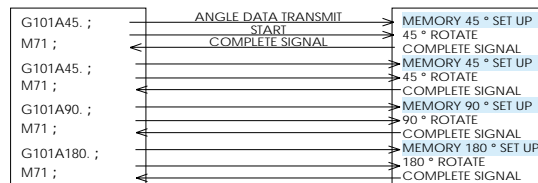
# EXAMPLES OF PROGRAM DRAWING

EXAMPLES OF PROGRAM	COTENTS OF MOTION	FIGURE OF MOTION
<pre> N 0 0 d 5 N 0 1 J 0 N 0 0 A 7 2 . 0 0 0 N 0 1 J 0                     </pre>	Dividing 3 6 0° in 5 Jump to N 0 0 . Rotate 7 2° Jump to N 0 0 . Each , rotates 7 2° in sends a message of complete signal. Repeated it in 5 times.	
<pre> N 0 0 A 6 0 . 0 0 0 N 0 1 A 9 0 . 0 0 0 N 0 2 A 4 5 . 0 0 0 N 0 3 A 5 5 . 0 0 0 N 0 4 A 1 1 0 . 0 0 0 N 0 5 J 0 N 0 0 A - 6 0 . 0 0 0 N 0 1 A 9 0 . 0 0 0 N 0 2 A 4 5 . 0 0 0 N 0 3 A 5 5 . 0 0 0 N 0 4 g 1 2 4 N 0 5 J 0                     </pre>	6 0° normal rev. 9 0° normal rev. 4 5° normal rev. 5 5° normal rev. 1 1 0° normal rev. Jump to N 0 0 . - 6 0° (reverse) revolution 9 0° normal revolution 4 5° normal revolution 5 5° normal revolution Working in normal revolution & work home position return. Jump to N 0 0 .	
<pre> N 0 0 F 7 5 N 0 1 A 6 0 . 0 0 0 N 0 2 F 3 3 0 N 0 3 g 1 2 4 N 0 4 J 0                     </pre>	7 5° / min. feed command. 6 0° normal revolution 3 3 0° / min. feed command. Work machining home position return. Jump to N 0 0 .	
<pre> N 0 0 A - 9 0 . 0 0 0 N 0 1 g 4 0 N 0 2 J 0 N 0 0 H 3 6 0 . 0 0 0 N 0 1 d 4 N 0 2 g 4 1 N 0 6 J 0 N 0 0 A 6 0 . 0 0 0 N 0 1 g 8 N 0 2 A 2 0 . 0 0 0 N 0 3 F 2 0 0 N 0 4 A 5 . 0 0 0 N 0 5 A 1 0 . 0 0 0 N 0 6 g 9 N 0 7 A 9 0 . 0 0 0 N 0 8 J 0                     </pre>	- 9 0° (reverse) revolution The complete signal doesn't output. Dividing 3 6 0° in 4 Output complete signal 6 0° normal revolution Continuous execute 2 0° normal revolution Feed speed 2 0 0° / min 5° normal revolution 1 0° normal revolution Cancel continuous execute. 9 0° normal revolution Jump to N 0 0 .	
<pre> N 0 0 F 7 0 N 0 1 A 1 0 . 0 0 0 N 0 2 g 1 0 0 4 N 0 3 A 5 0 . 0 0 0 N 0 4 J 0                     </pre>	Feed speed 7 0° / min 1 0° normal revolution 1.0 second dwell 5 0° normal revolution Jump to N 0 0 .	
<pre> N 0 0 A 5 0 . 0 0 0 N 0 1 g 1 0 N 0 2 A 3 0 . 0 0 0 N 0 3 A 4 5 . 0 0 0 N 0 4 A 6 0 . 0 0 0 N 0 5 g 1 1 N 0 6 A 7 5 . 0 0 0 N 0 7 J 0                     </pre>	Clamp after 5 0° revolved. Output complete signal Clamp cancel. Unclamp after 3 0° revolved. Output complete signal UnClamp after 4 5° revolved. Output complete signal Clamp after 6 0° revolved. Output complete signal Clamp is effective. Clamp after 7 5° revolved. Output complete signal Jump to N 0 0 .	
<pre> N 0 0 g 1 0 N 0 1 F 3 3 N 0 2 g 1 2 2 N 0 3 J 0                     </pre>	Clamp cancel. Revolve 3 3° / min Continuous start. Jump to N 0 0 .	
<pre> N 0 0 A 6 0 . 0 0 0 N 0 1 L 0 0 2 0 3 N 0 2 H 4 0 . 0 0 0 N 0 3 d 2 N 0 4 A 9 0 . 0 0 0 N 0 5 g 1 2 4 N 0 6 J 0                     </pre>	6 0° normal rotation Till N 0 3 repeat 2 times. Loop Opening angle 4 0° Dividing number in 2 . 9 0° normal rotation In normal rotation work machining home position return. Jump to N 0 0 .	

## RC232C SPECIFICATION EXAMPLE OF PROGRAM

MC WORKING PROGRAM

PMK CONTROLLER



IN THIS CASE IT USES THE MACRO COMMAND.

# CONNECTION DRAWING

