

**Release**

**1**

**HH Roberts**

**TW-CGL**  
**Operation**  
**Manual**

**Anilam 3300 MK**



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## **CAUTION**

**IMPROPER OPERATION AND OR IMPROPER MAINTENANCE OF THIS MACHINE MAY CAUSE SERIOUS BODILY INJURY.**

**DO NOT OPERATE THIS MACHINE UNTIL YOU HAVE RECEIVED OPERATING AND SAFETY INSTRUCTIONS FROM YOUR EMPLOYER.**

**FOLLOW ALL SAFETY PRACTICES PRESCRIBED BY YOUR EMPLOYER AND OUTLINED IN THE OPERATION MANUAL.**

**ALWAYS AVOID UNSAFE CONDITIONS OF OPERATION SUCH AS EXCESSIVE FEEDS AND SPEEDS.**

**ALWAYS BE SURE ALL SAFETY DEVICES ARE IN GOOD OPERATING CONDITION.**

**ALWAYS BE CERTAIN THAT ONLY QUALIFIED PERSONNEL PERFORM SERVICE ON THIS MACHINE.**

# Machine Safety

Every effort has been made in the design and production of this piece of equipment to comply with statutory requirements and to provide a fundamentally safe machine tool. In the further interest of safety, attention should be given to the following notes:

## Machine Use

Responsibility for the following points with respect to machining a part must ultimately rest with the machine operator.

1. Ensure that the operator has had suitable training and possesses the required degree of skill and experience to undertake the work.
2. Provide suitable work holding and/or supporting equipment: chucks, steadies, revolving centers, vises etc.
3. Ensure that suitable tooling is provided and correctly mounted.
4. Ensure that suitable feeds and speeds are selected.
5. Use the guards that are provided with the machine.
6. Wear suitable protective devices: safety glasses, shields.

## Safety Rules

1. KNOW HOW TO STOP THE MACHINE BEFORE STARTING IT.
2. Read and understand all manuals for your machine.
3. Keep your machine and work area clean.
4. Before operating spinning tools, note and observe the maximum operating speed of the selected device as marked on the nameplate by the manufacturer.
5. Remove chuck keys IMMEDIATELY after use.
6. Check the load capacity of revolving centers and drivers.
7. Ensure guards are in position before operating the machine.
8. DO NOT use cracked or chipped tools.
9. STOP THE MACHINE IMMEDIATELY IF ANYTHING UNEXPECTED HAPPENS.
10. DO NOT touch revolving chucks or tools.



11. DO NOT remove tools or work from a machine without retracting the tool to a safe position and stopping the spindle.
12. ALWAYS use the E-STOP button when working in the machine envelope or when leaving the machine unattended.

## **Personal Safety Rules**

1. Report any accident as soon as it happens.
2. Wear safety glasses or shields.
3. Wear safety shoes.
4. Use barrier creams if provided.
5. Wear your overalls buttoned up.
6. Roll sleeves up or button the cuffs.
7. Keep hair short or use a suitable cap.
8. Use the correct size wrench at all times.
9. Be careful of, and remove burrs and sharp edges.
10. When lifting heavy a work-piece or fixture, use the correct type of sling, ensure that it is not worn or damaged and that its safe workload is not exceeded.
11. Stand clear when lifting a work-piece or equipment by crane.
12. Obtain assistance when lifting heavy or awkward work-pieces or fixtures.
13. DO NOT wear rings, watches, ties, etc. when operating a machine.
14. DO NOT keep sharp tools in pockets.
15. DO NOT manually lift heavy equipment.
16. DO NOT wash hands in coolant.
17. DO NOT remove chips or cuttings with bare hands; use a rake or chip hook.
18. DO NOT use rakes or chip hooks with enclosed handles.
19. DO NOT use files, scrapers, etc., on machines.
20. DO NOT lean on the machine.
21. DO NOT tamper with electrical equipment.

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**SECTION****2**

## Machine Lifting

### Lifting The Machine

The machine should be lifted using a forklift truck or crane as illustrated in Figure 2-1. Ensure that the forklift truck has sufficient capacity. Approximate machine weight as follows.

Model	Axis Travel	Approx. Weight
TW-3 CGL 2 AXIS	32" X 15" X 5"	3,100 lbs
TW-3 CGL 3 AXIS	32" X 15" X 4.5"	3,110 lbs
TW-3 CGL-40 2 AXIS	32" X 15" X 5"	3,100 lbs
TW-3 CGL-40 3 AXIS	32" X 15" X 4.5"	3,110 lbs
TW-4 CGL 2 AXIS	32" X 15" X 5"	3,100 lbs
TW-4 CGL 3 AXIS	32" X 15" X 4.5"	3,110 lbs
TW-4 CGL-40 2 AXIS	32" X 15" X 5"	3,100 lbs
TW-4 CGL-40 3 AXIS	32" X 15" X 4.5"	3,110 lbs
TW-5 CGL 2 AXIS	32" X 15" X 5.5"	3,800 lbs
TW-5 CGL 3 AXIS	32 X 15" X 4.5"	3,810 lbs

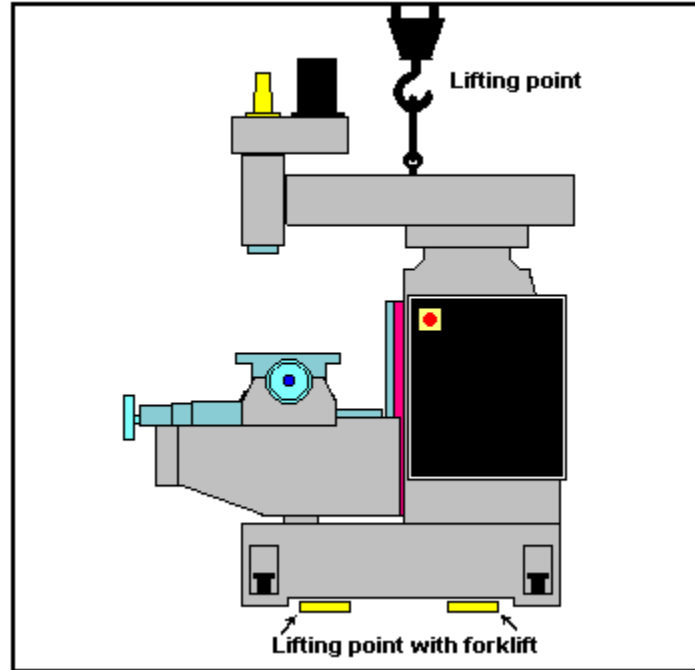


Figure 2-1

Above is the correct way to lift the machine frame with overhead crane or with a forklift from the side.

## Inspection

Check your delivery slip against the accessories that were ordered with the machine. If there is a shortage or error, report it to your dealer immediately, giving the serial number, which is stamped on the nameplate on the rear of the machine.

## Cleaning

All unpainted parts of the machine have been coated with an anti-rust compound. This should be thoroughly removed after the machine is installed and before moving any axis. Remove anti-rust compound with varsol and a clean cloth. Do not use paint thinners. All unpainted surfaces should be coated immediately with a light coat of way-lube.

**SECTION****3**

## Machine Installation

### Leveling

For proper operation the machine should be set on a substantial floor capable of supporting a uniform pressure of 50 PSI. After the machine is in position, it must be leveled by adjustment of the leveling bolts. Use a precision level placed on the table, with the X and Y-axis in approximately the center of travel. Adjust the outside 4 leveling bolts to obtain optimum level. After the bed has been leveled, use a dial indicator to sweep the table and adjust the head to bring the spindle perpendicular to the table.

### Power Supply

A fused branch circuit disconnect must be provided in front of the machine. All machines have a nameplate on the electrical cabinet with the rated horsepower and current. AC power wiring must be consistent with any local codes, national electric codes and be able to withstand the voltage and current ratings applied. It is suggested that the cable entrance to the electrical cabinet on the machine is at the side or bottom of the cabinet in order to prevent coolant and oils from contaminating the electrical enclosure.

### Grounding:

The 3-phase AC supply **MUST** be bonded to EARTH GROUND. Figure 3-1 shows the most common transformer secondary winding configurations, but not all possibilities, as there are too many transformers to depict all combinations.

Note 1: Failure to reference the secondary winding to EARTH GROUND could void warranty.

Note 2: Some types of delta wound transformers may cause problems with inverter drives.

Check incoming voltage on the three-phase supply before turning on the machine. See Powering Up The Control later in this section.

The machine must be securely bonded to earth ground. Conduit ground is not acceptable. The ground conductor must be equivalent in cross sectional area to the supply conductors minimum #8 AWG and have a green / yellow jacket or bare wire. The ground resistance must not exceed 4 ohms

Grounds are provided for two reasons:

1. Establish a low impedance path between the equipment enclosure and other material parts of the system for the protection of personnel against electrical shock in the event of an electrical failure in the machine electrics.
2. Establish a neutral reference common to all voltage sources in the system for the protection of electronic equipment against interference generated both in the machine itself and in electrical equipment in the vicinity of the machine. This interference may cause damage and / or defective operation of the equipment.

In as much as safety requirements may vary with geographic location, be sure to consult the local governing Codes, which take precedence over the following guidelines that are, in general, considered practical. These guidelines are based on the following references:

National Electrical Code 1975

California "Electrical Safety Orders" 1967

Pennsylvania "Electrical Safety Regulations" 1965

## Typical Earth Ground Effectiveness:

- |                                  |   |
|----------------------------------|---|
| 1. Continuous copper water pipe. | Properly buried length, depending on condition of soil. Installed below permanent moisture level. (Impedance typically 3 ohms)                    |
| 2. Man-made buried electrodes    | properly installed length depending on condition of electrodes Soil. Installed below permanent moisture level. (Impedance typically below 5 ohms) |
| 3. Other available electrodes    | such as metal frames of buildings must be well chosen and tested that they do not exceed 5 ohms.  |

Ground connections, wire and electrodes should not exceed 5 ohms, as measured from the equipment ground stud through the primary electrode, through earth, to another independent electrode separated by 20 feet of earth. Additional ground should be installed when necessary to insure that the impedance does not exceed 5 ohms. The ohmic measurement should be made in terms of a voltage-current relation, such as the current of a 120-volt, 100watt light bulb. When longer lengths of ground conductor are required, use a larger size cable, so that the total resistance of the cable is less than 0.075 ohms.

### Multi tap isolation transformers

An isolation transformer is completely different than an autotransformer. The difference is that in isolation transformers there are six sets of windings whereas an autotransformer only has three sets of windings. Because of this there is no means of surge protection or power balancing. In isolation transformer the first three sets of windings are only used by the primary side (incoming power) and the second set of windings are used on the secondary side (outgoing power) this is done in order to generate clean balanced power. As the two sets of windings are not connected by any means. With using the two sets of windings in this manner you get a buffering effect between the in / coming power and outgoing power. Spikes generated in the power lines will be absorbed in the windings by a fare amount.

The following will explain the basics of reading the nameplate and connecting an isolation transformer. See figure 3-1.

REX MANUFACTURING		
<b>CAT. NO.</b> DC20HISI/K4	<b>KVA</b> 20	<b>ENCL</b> OPEN
<b>SERIAL</b> B 27449	<b>HZ</b> 60	<b>TYPE</b> ANN
<b>TRANSFORMER</b> 3 PH ISO	<b>% IMP</b> 5.5	<b>AT</b> 170 C
<b>INSULATION CLASS</b> 220 C	<b>TEMPERATURE RISE</b> 150 C	
<b>PRI. VOLTAGE</b> 460 DELTA H1-H2-H3	<b>BIL.</b> 10KV	
<b>SEC. VOLTAGE</b> 230Y/133 X0-X1-X2-X3	<b>WT.</b> 275 LB	
<b>PRI. VOLTAGE</b>	<b>CONNECTION</b>	
105.0%	1-1-1	
102.5%	2-2-2	
100.0%	3-3-3	
97.5%	4-4-4	
95.0%	5-5-5	

FIGURE 3-1

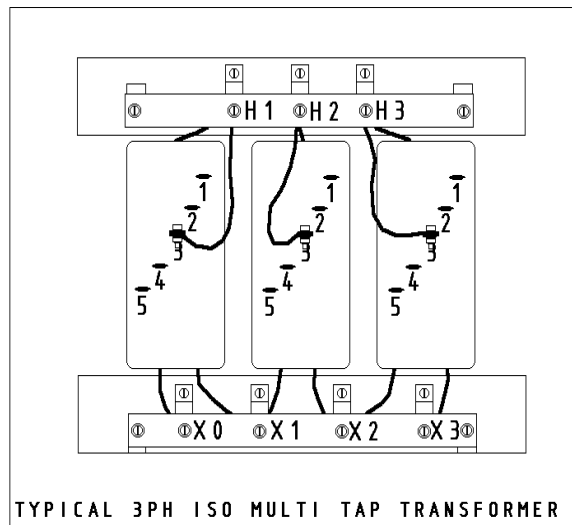


FIGURE 3-2

Please note the following on the nameplate you will find **PRI. VOLTAGE** this is the incoming power from the building on this e.g., it is **460 V DELTA H1-H2-H3**, the H1, H2 and H3 represent that the incoming 3PH gets connected to the terminal blocks with these labels. See figure 3-2.

Below this you will find **SEC. VOLTAGE** this is the outgoing power to the machine tool **230Y/133 X0-X1-X2-X3**, the X1, X2 and X3 represent that the outgoing 3PH gets connected to the terminal blocks with these labels. See figure 3-2. The X0 terminal block gets connected to ground this is called referencing the transformer to ground, which balances the three phases by making each line the same voltage. This is a very important part of any CNC machine tool installation. With out grounding the X0 you will be asking for all types of problems. If a your machine is acting funny but you can't find any problem you will most likely find the X0 is not connected to ground.

Below this you will find the Multi tap specifications. In this example the Primary. Voltage has 5 different input adjustments. They are 105.0%, 102.5%, 100.0%, 97.5% and 95% this means if your incoming power is not exactly 460 Volts you can adjust the output of the transformer by changing the taps, below is a table for this example.

Input Voltage	Percentage	Connection Taps
483V	105.0%	1-1-1
471V	102.5%	2-2-2
460V	100.0%	3-3-3
448V	97.5%	4-4-4
437V	95.0%	5-5-5

In order to make this adjustment if you refer to figure 3-2 you can see the multi taps located on the main body of each winding. There are three different wires going to the rings that are mounted on each winding. Each ring is labeled with numbers and you must move these wires to the corresponding number. For this example you have 480V incoming to the transformer, so you must move the wires to the rings labeled 1 on each winding. Now the incoming power is 480V and by using the multi taps we can adjust the transformer to output 230V. If you input 480V to this transformer and didn't adjust the multi taps then the transformer would output 241V to the machine, which is too high and may cause problems.

The last part of checking the power going to the machine is to check the line voltage to the machine by comparing the line voltage of each leg of power. This is done by using your meter and checking each phase to ground. If the transformer is grounded correctly then each phase to ground should be with in 5 Volts.

## Air Supply

The machine requires a ½" supply line direct from the compressor or from a main header supply capable of supplying a steady 90 PSI. at 3 CFM. For maximum operation of the automatic tool change unit.



## Powering up control

When you are ready to power up the control for the first time you must make the following checks.

1. Incoming power: check that the incoming power is within the following tolerance:  
For 230V machines the incoming voltage must be between 220V- 240V  
For 460V machines the incoming voltage must be between 440V- 480V
2. Control Transformer: check that the control voltage is between 110V- 120V. You can adjust the output voltage by changing the input taps on the transformer.
3. 5V DC power: check the 5V DC supply to the control. This can be done by removing the cover on the console and measuring the 5V DC plug on the hard drive mounted to the side of the monitor. The tolerance of this voltage is 5.0V-5.2V. If you need to adjust the voltage you will find the power supply mounted inside the electrical cabinet on the right side wall. Note: There are three supplies; the supply for the 5V DC to the control is mounted on the top and it supplies 5V DC, +15V DC and -15V DC to the computer. Make the required adjustment using the adjustment pot.
4. Check the axis drive setup and tuning. See section 4 Maintenance under Axis Drive Setup and Tuning.

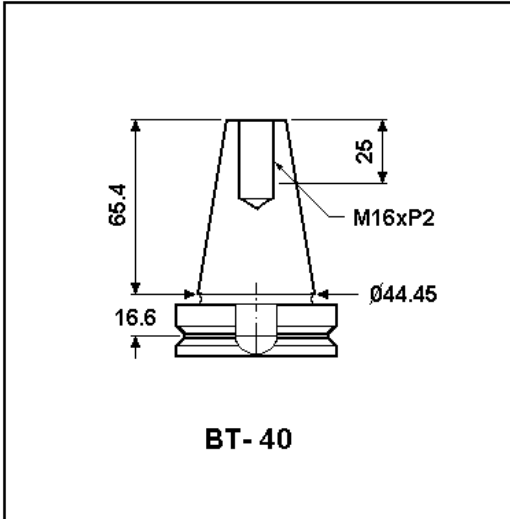
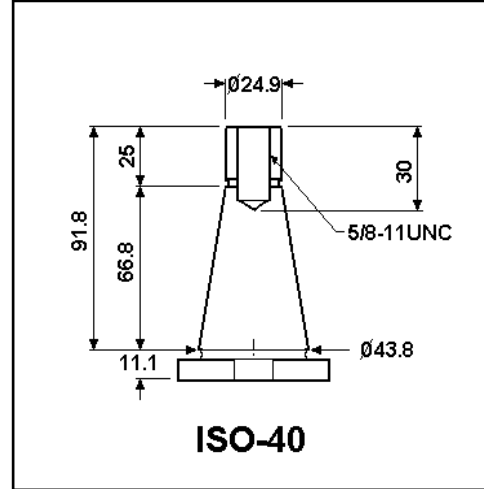
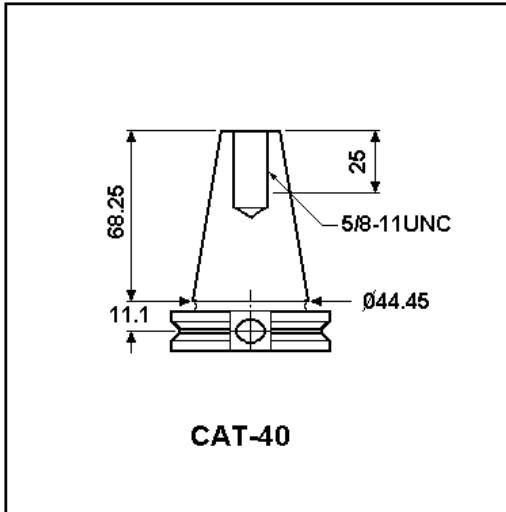
## Additional Devices

If additional devices are to be mounted and driven off the machine supply, make sure they are suppressed in accordance with Anilam's requirements as described in their installation manual.

**We only recommend these modifications be done by trained service engineers familiar with the Anilam controls.**

## Tool Holders

The GL series machines can be ordered with three different types of tooling. Either CAT-40 , BT-40 or ISO-40 tooling. This must be specified when ordering the machine or you will have to change the draw bar. Below are dimensional drawings of each type of tool holder.



**SECTION**  
**4**

## **Maintenance**

### **Daily Maintenance:**

1. Check and fill way lube.
2. Check and fill airline oil, be sure to use air tool oil.
3. Drain water from catcher.
4. Clean off limit and over-travel switches.
5. Clean and inspect the spindle taper.

### **Weekly Maintenance:**

1. Check and fill way lube.
2. Check and fill airline oil, be sure to use air tool oil.
3. Drain water from catcher.
4. Clean off limit and over-travel switches.
5. Clean and inspect the spindle taper.
6. Clean the cabinet filters.
7. Check all cabinet fans.
8. Check the coolant system and clean out sludge.

## Monthly Maintenance:

1. Check and fill way lube.
2. Check and fill airline oil, be sure to use air tool oil.
3. Check and fill tool unclamp reservoir oil.
4. Drain water from catcher.
5. Clean off limit and over-travel switches.
6. Clean and inspect the spindle taper.
7. Clean the cabinet filters.
8. Check all cabinet fans.
9. Check the coolant system and clean out sludge.
10. Check way lube delivery to axis slides, if necessary remove way wipers and clean, do not allow contaminants to get under slides.

## Twice Yearly Maintenance:

1. Check and fill way lube.
2. Check and fill airline oil, Be sure to use air tool oil
3. Check and fill tool unclamp reservoir oil.
4. Drain water from catcher
5. Clean off limit and over-travel switches.
6. Clean and inspect the spindle taper
7. Clean the cabinet filters.
8. Check all cabinet fans.
9. Check the coolant system and clean out sludge.
10. Check way lube delivery to axis slides, if necessary remove way wipers and clean, do not allow contaminants to get under slides.
11. Clean machine top to bottom.
12. Check cable carriers for signs of chafing or pulling of cables and hoses.
13. Adjust gibs where necessary.
14. Check machine level and tighten hold down bolts where necessary.
15. Check electrical connections and plugs.

## Adjusting Air Regulator Oiler

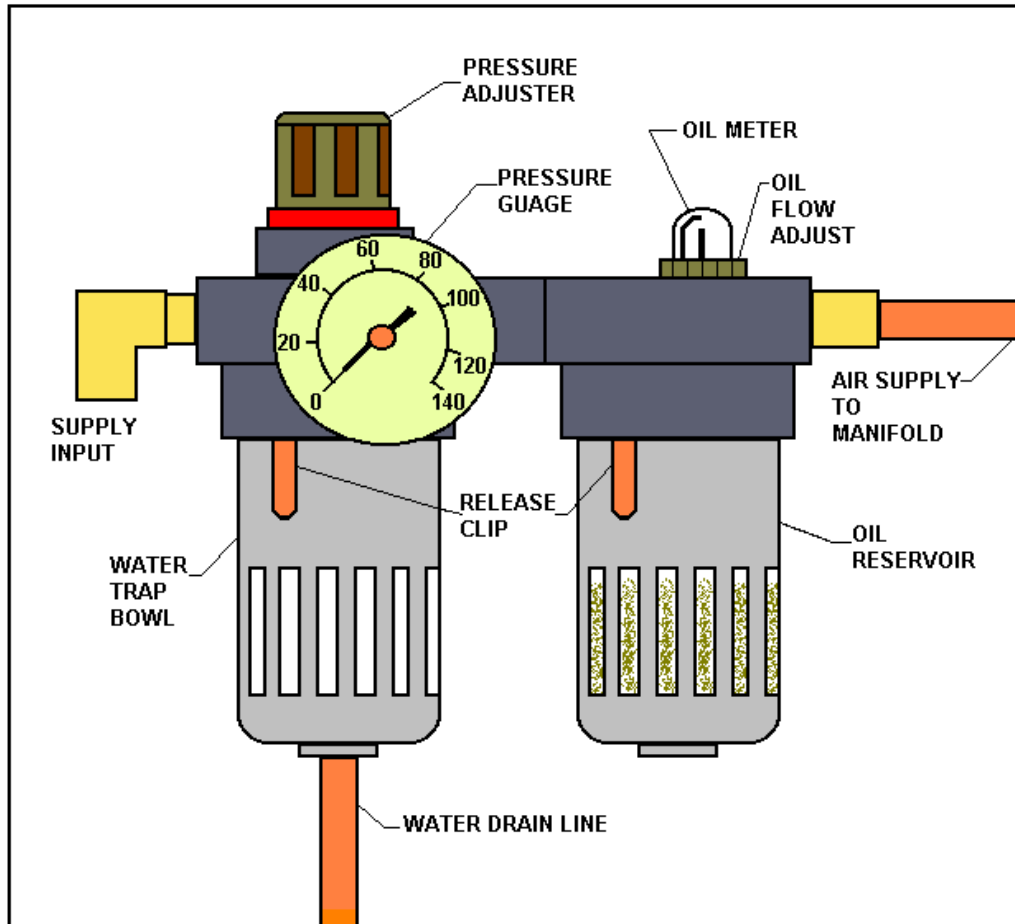


Figure 4-1

The air regulator oiler that comes on the CGL series machines is equipped with an automatic water separator, the water trap bowl will drain the water collected automatically when the air supply is disconnected or turned off. The recommended operating air pressure for the CGL machine is 95 – 100 PSI or 6.5 – 7 Kg/cm<sup>2</sup>. To adjust the air pressure pull up on the Pressure Adjuster knob (See figure 4-1) until it is free of the lock then turn the knob clock wise to increase the pressure or counter clock wise to decrease the pressure, When the required pressure is set, lock the knob in place by pushing down on the knob.

To fill the reservoir, remove the air pressure and then remove the cap on top of the lubricator. Fill reservoir about 2/3 full using Air Tool Oil. Replace cap.

To adjust the oiler open (C.C.W.) the oil flow adjustment screw (2) turns. Lower the quill Approx. 2" and lock the quill in place. Press IN and OUT button on the control head in short (1 second) bursts until oil is seen dripping from the oil tube site bowl located on top of the lubricator. After about (7) drops of oil stop. Close (C.W.) the oil flow adjustment screw. (DON'T OVER TIGHTEN). Then open (C.C.W.) the oil flow adjustment screw  $\frac{1}{2}$  to  $\frac{3}{4}$  of a turn. Fine Adjustment may be needed later. Below is the recommended adjustment.

2 to 4 drops per day – light usage.

3 to 5 drops per day – medium usage.

4 to 6 drops per day – heavy usage.

## **Power Draw Bar Operation**

Turn off the spindle and wait until it has stopped. Retract the quill back to the UP position. Lock the quill. Take the tool holder and insert it in to the spindle until you feel contact with the drawbar. Then push the IN button on the control box, the tool will be pulled in to the spindle. The longer you hold the IN button the tighter the tool will become. (Under normal conditions  $\frac{1}{2}$  to 1 1/2 seconds is all that is required). To remove the tool, turn off the spindle and wait until it has stopped. Hold the tool well pushing the OUT button on the control panel until the tool becomes free.

## Power Draw Bar Trouble Shooting

Tips to prevent sticky tool holders.

1. Do not leave tool holder in the spindle over night.
2. Clean all nicks, dirt, oil and heavy tarnish off tool holders
3. Inspect and clean inside of the spindle taper for nicks, dirt, oil and heavy tarnish
4. Do not over tighten the tool holder.

PROBLEM	SOLUTION
Power head goes up and down and air motor is running but the drawbar doesn't tighten or loosen	Make sure the quill is all the way up and locked in position
Power head runs sluggish / Power head blowing heavy oil mist out of exhaust during operation.	Too much oil. Correct by adjusting lubricator to minimum oil flow. Drop quill down approx. 2" so power head will run freely and run power head until heavy oil mist stops.
Drawbar rattles when spindle is running and quill is in the up position	Loosen power head base from bearing cap and move slightly to center power head to drawbar.  Check top of spindle for damage.
Drawbar stripping threads	Tool holder sticking in spindle taper. Quill is being pushed down instead of tool holder coming out of spindle.  Inserting double ended mills to far into tool holder and cutting the end of the draw bar.  Check tool holder for bad threads or chips in threads.

## Automatic Way Lubricator

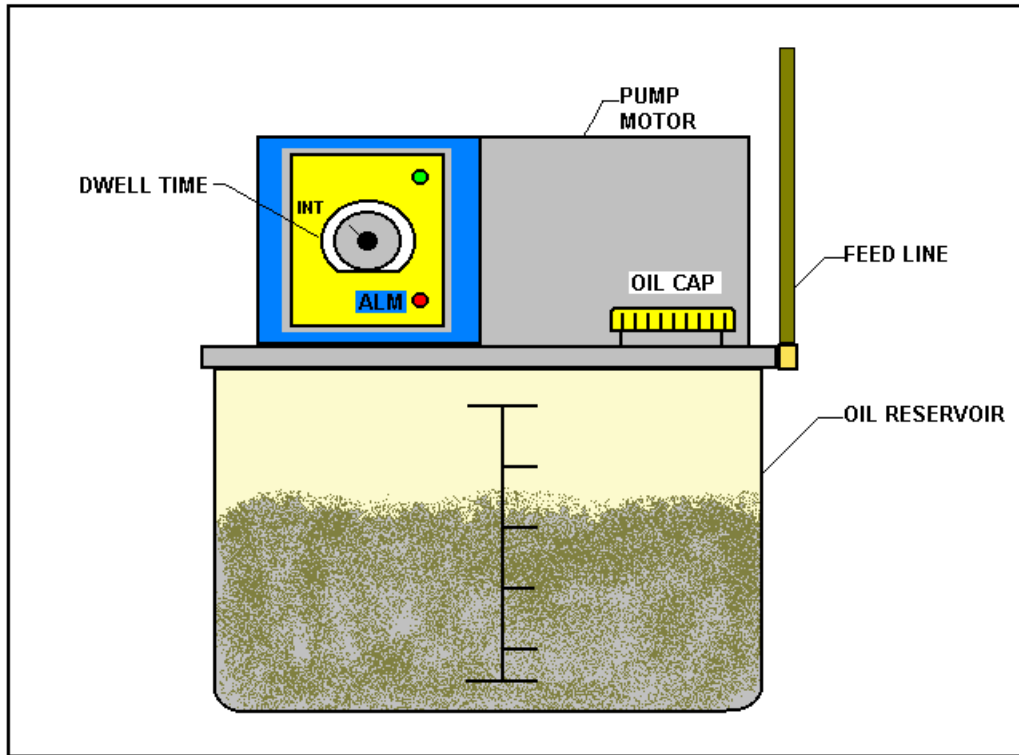


Figure 4-3

A lubricator located at the rear of the machine automatically lubricates ball screw nuts and way surfaces at timed intervals. (Figure 4-3) The following are the recommended factory settings. Pump dwell time set to 30 minutes.

Regularly inspect the ways to insure that the slide-ways always have a film of oil. If the lubricant in the reservoir is not replenished, a level switch will automatically disable the automatic mode of the machine and display an alarm message. It is recommended that the lubrication be topped up every eight hours. A lubricant with a viscosity of 300 - 350 SUS at 100°F is recommended. (See oil chart) Ball-screw bearings are pre lubricated with grease and sealed, so require no additional lubrication.

### Oil Chart

Company	Way lube	Power Draw Bar	Coolant
Oil type	S.A.E. No. 68	S.U.S. No. 32	Semi-Synthetic
Sunoco	WAY LUBE 68	SUNVIS 832	N/A
Shell	TONNA T68	TELLUS 32	DROMAS B
Esso	FEBIS K68	NUTO H32	EXXCOOL 2000
Mobil	VECTRA # 2	DTE 24	N/A



## CAN I/O Test facility

The CAN I/O Test facility provided in the CNC makes the trouble-shooting of the Can Nodes very easy and efficient. This test utility helps to trouble-shoot problems with all Can Nodes on the machine tool.

From the boot up menu select **MOTION SETUP/TESTING** then select the **CAN TEST** soft key. Below are the conditions you should see when all operations are normal.

### POWER ON STATUS WITH EMERGENCY STOP PUSHED IN

<b>Estop</b>	Will not be highlighted.
<b>SvOn</b>	Will be highlighted.
<b>+24</b>	Will be highlighted.
<b>SvoEn</b>	Will not be highlighted.

### POWER ON STATUS WITH EMERGENCY STOP PULLED OUT AND SERVO'S OFF

<b>Estop</b>	Will be highlighted if the Emg. Stop switch is working.
<b>SvOn</b>	Will be highlighted.
<b>+24</b>	Will be highlighted.
<b>SvoEn</b>	Will be highlighted if all elements of the Emg. Stop loop is closed.

### POWER ON STATUS WITH EMERGENCY STOP PULLED OUT AND SERVO'S ON

<b>Estop</b>	Will be highlighted if the Emg. Stop switch is working.
<b>SvOn</b>	Will not be highlighted if the reset is seen by the CNC.
<b>+24</b>	Will be highlighted.
<b>SvoEn</b>	Will be highlighted if all elements of the Emg. Stop loop is closed.

## Input and Output List

See the tables below for the assigned inputs and output labels.

Can Node 0			
Input	Label	Output	Label
IN 0	Unused	OUT0	Unused
IN 1	X Axis Home Switch	OUT1	Unused
IN 2	Y Axis Home Switch	OUT2	Unused
IN 3	Spindle Drive Fault	OUT3	Spindle Drive Enable
IN 4	Z Axis Home Switch	OUT4	Unused
IN 5	Way Lube Low Switch	OUT5	Coolant Pump Motor
IN 6	Spindle Lock		
IN 7	Unused		
IN 8	Unused		
IN 9	Unused		

Can Node 1			
Input	Label	Output	Label
IN 0	X Axis Select	OUT0	Unused
IN 1	Y Axis Select	OUT1	Unused
IN 2	Z Axis Select	OUT2	Unused
IN 3	Unused	OUT3	Unused
IN 4	Unused	OUT4	Unused
IN 5	Unused	OUT5	Unused
IN 6	Rate x1		
IN 7	Rate x10		
IN 8	Rate x100		
IN 9	Unused		

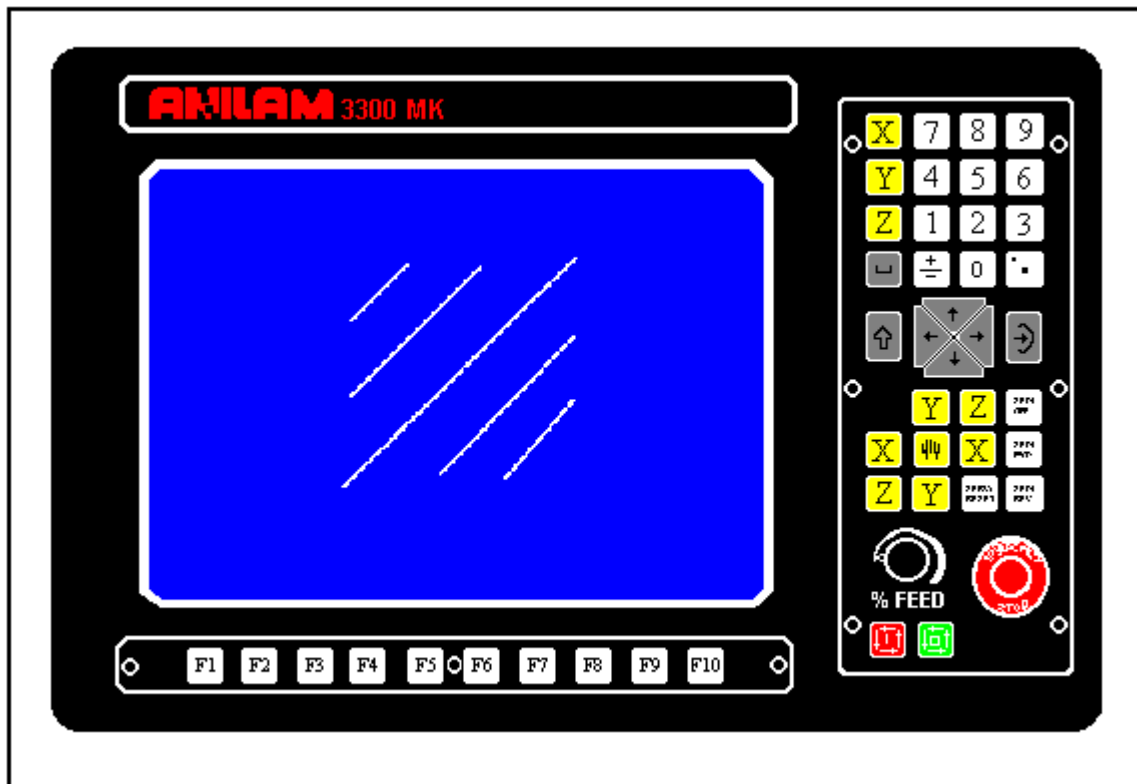
## Axis Drive Setup and Tuning

When you first installing a machine the axis drives should be set up and tuned you will find a complete procedure laid out in the Anilam manual supplied with the machine.

# SECTION 5

## Machine Operation

### Powering Up The Control



## Powering On The Machine

Turn on the main disconnect on the side cabinet of the machine and then turn on the power switch on the rear of the side cabinet. After the computer has booted up the software version screen will appear. Push F10 (Soft-key 10) to continue. Then a selection menu is displayed on the screen, with the cursor keys, highlight **CNC Control** and push **ENTER**, this will start CNC software.

Release the E-STOP push button and push the Servo Reset button.

## Powering Off The Machine

Push in the E-Stop button. Wait for all functions on the machine to stop and then turn off the main disconnect on the rear of the machine.

## Manual Operation

### Homing The Machine

When at the main CNC screen use the following keystrokes.

1. Push the M.D.I. key (F7).
2. Push the MILL key (F5).
3. Push the MORE key (F5).
4. Select "HOME" push enter.
5. Select the axis you want to home.
6. Push the SAVE key (F10).
7. Push the PREV key (F9).
8. Push the EXIT key (F10).
9. Push the CYCLE START.

All selected axes will be homed with the Z-axis homing first.

### Jogging The Axis in Feed Mode

Select the jog mode by pushing the hand on the keypad and then push the corresponding axis button to be jogged. The % Feed override selector switch will modify the feed rate

### Jogging The Axis in Rapid Mode

Select the jog mode by pushing the hand on the keypad and then push the corresponding axis button to be jogged. The % Feed override selector switch will modify the feed rate

## Jogging The Axis Using Incremental Jog Mode

Select the jog mode by pushing the hand on the keypad and then push the corresponding axis button to be jogged. The % Feed override selector switch will modify the feed rate

Note the increment values are as set out below

100X = 0.0100" or 0.100 mm

10X = 0.0010" or 0.010 mm

1X = 0.0001" or 0.001 mm

The units are either inch or metric depending on the mode the control is in at the time of operation.

## MDI Operations

When at the main CNC screen Push the M.D.I. key (F7). The M.D.I. screen programs the same as a main program.


## Running The Spindle

Enter a spindle speed by pushing the "." Key, enter a RPM and push the SAVE key (F10) then push the CYCLE START key. By pushing the SPDL FWD or SPDL REV key you can start the spindle. To stop the spindle push the SPDL STOP key.

Or

By using M.D.I. use the following keystrokes.

10. Push the M.D.I. key (F7).

11. Push the  key.

12. Enter a RPM.

13. Push enter.

14. Push the  key.

15. Under the MACHINE CODE enter 3 for (CW.) or 4 for (CCW.)

16. Push the SAVE key (F10).

17. Push the PREV key (F9).

18. Push the EXIT key (F10).

19. Push the CYCLE START.

For all other operations of the machine and programming refer the Anilam 3300MK-programming manual supplied with your machine.

<b>M-Code List</b>		
M00	Infinite dwell	Control waits for cycle start or manual key. Similar to pressing Hold key.
M02	End of Program	Signals end of program to control. Spindle, coolant pump and work air blast turn off.
M03	Spindle on forward	Signals the interface to run the spindle drive in the CW. direction
M04	Spindle on reverse	Signals the interface to run the spindle drive in the CCW'S. direction
M05	Spindle off	Signals the interface to stop the spindle drive.
M08	Coolant on	Signals the interface to start the coolant pump
M09	Coolant off	Signals the interface to stop the coolant pump.
M12 (Option)	Stand alone 4 <sup>th</sup> Axis controller start	Signals the interface to run a 4 <sup>th</sup> axis stand alone controller EG. HAAS or SMW
M30	End of program	Signals end of program to control. Spindle, coolant pump and work air blast turn off.
M98	Subprogram Call	Call subprogram Pp. EG. M98 PP [L] P=subprogram number L=loop count
M99	End of Subprogram	End of current subprogram. Error if not in subprogram. CNC continuous execution in the block after subprogram call.