

Automation for a Changing World

Delta CNC Lathe Solution

Lathe Controller NC200 Series



www.deltaww.com

 **DELTA**
Smarter. Greener. Together.

Delta CNC Lathe Solution - Lathe Controller NC200 Series

Delta's CNC Lathe Solution adopts the CNC Controller NC200 Series to control servo systems, a spindle servo drive, and a PM spindle motor. With Delta's DMCNET protocol that provides high-speed data exchange, the solution is able to perform precise turning control and meet the machining requirements for high speed and high precision.

Features

- Embedded system design: high energy savings, high efficiency and high stability
- 8-inch high resolution color LCD: three kinds of operation interfaces, English / Traditional Chinese / Simplified Chinese
- User-friendly operation: provides interfaces with simple steps to meet users' requirements
- Delta's global service network: professional technical support and excellent service

Product Design and Main Specifications

Non Manual Pulse Generator (MPG) (NC200A-LI-A) With Manual Pulse Generator (MPG) (NC200P-LI-A)



Separate Type (NC200A-LS-A)



- Maximum control: 5 axes
Simultaneous control: 3 axes
- Single spindle and single turret applications
- Cost-efficient all-in-one type CNC controller
- Delta's DMCNET protocol
- Compatible with ISO standard G codes
- C-axis function

CNC Lathe Solution

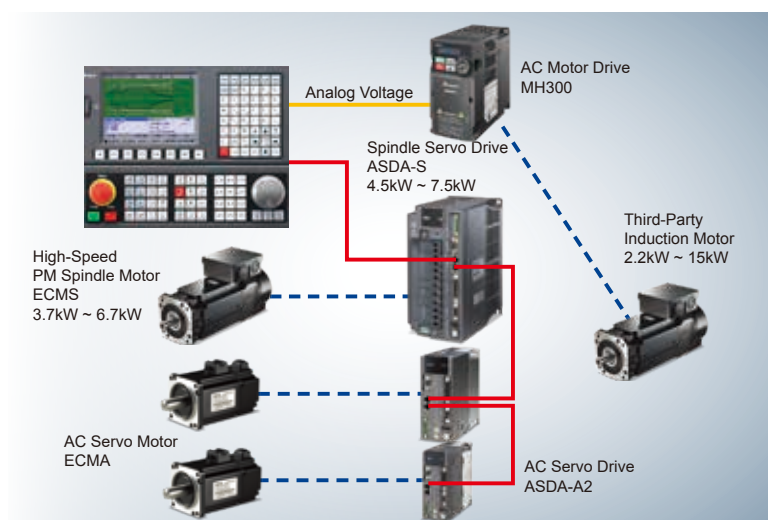
System Application Flexibility

Application 1

- DMCNET Communication with Spindle Servo Drive

Application 2

- Analog Signal with AC Motor Drive

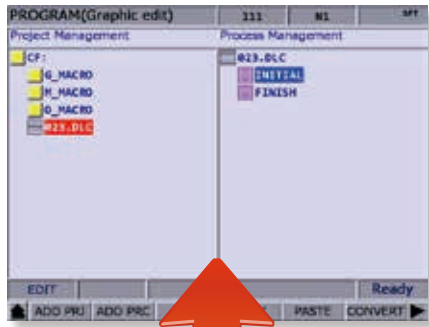


Lathe Functions

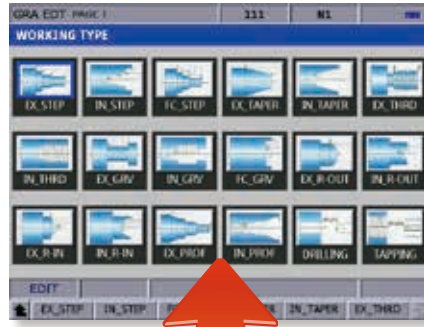
CNC Lathe Programming

- Simple interface design and steps for quick programming and processing management

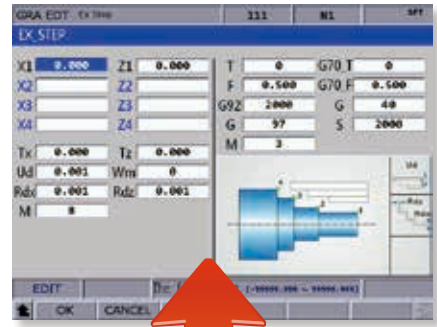
Graphical programming steps:



Step 1:
Click the Process Management function



Step 2:
Select the Working Type function



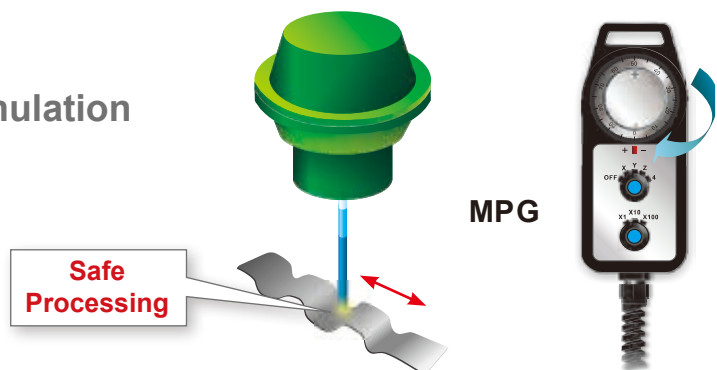
Step 3:
Fill in working steps

Step 4: Complete NC code programming

The same workpiece can be employed with different processing combinations

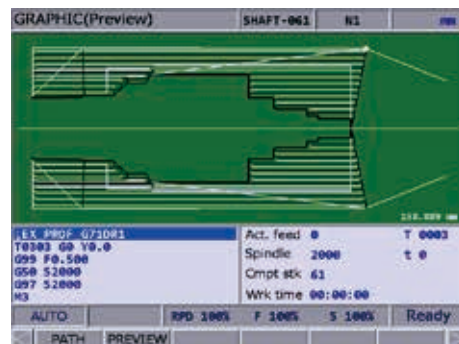
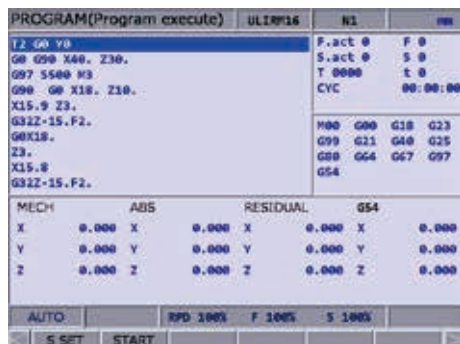
Manual Pulse Generator (MPG) Simulation

- Controls processing speed and guarantees cutter stability to prevent execution error or tool damage from inaccurate operation for safer and more precise CNC processing



Graphical Preview of Tool Path (Look-Ahead Simulation)

- Provides graphical preview of tool paths to simulate, check and observe the movement of the tools for verifying and optimizing the NC machining programs before processing, which reduces defect rates



NC 200 Series Lathe Functions

Lathe Cutter / Tool Chart

OFFSET (Tool Offset)					111	N1	mm
Num	X OFFSET	Z OFFSET	RADIUS	POINT			
1	0.000	0.000	0.000	0	MECH		
2	0.000	0.000	0.000	0	X	90.000	
3	0.000	0.000	0.000	0	Z	190.000	
4	0.000	0.000	0.000	0			
5	0.000	0.000	0.000	0			
6	0.000	0.000	0.000	0			
7	0.000	0.000	0.000	0	REL		
8	0.000	0.000	0.000	0	X	90.000	
9	0.000	0.000	0.000	0	Z	190.000	
10	0.000	0.000	0.000	0			
11	0.000	0.000	0.000	0			
12	0.000	0.000	0.000	0			
13	0.000	0.000	0.000	0			
14	0.000	0.000	0.000	0			
15	0.000	0.000	0.000	0			

OFFSET (Tool Wear)					111	N1	mm
Num	XWTEAR	ZWTEAR	RAD WTEAR				
1	0.000	0.000	0.000		MECH		
2	0.000	0.000	0.000		X	90.000	
3	0.000	0.000	0.000		Z	190.000	
4	0.000	0.000	0.000				
5	0.000	0.000	0.000				
6	0.000	0.000	0.000				
7	0.000	0.000	0.000		REL		
8	0.000	0.000	0.000		X	90.000	
9	0.000	0.000	0.000		Z	190.000	
10	0.000	0.000	0.000				
11	0.000	0.000	0.000				
12	0.000	0.000	0.000				
13	0.000	0.000	0.000				
14	0.000	0.000	0.000				
15	0.000	0.000	0.000				

Recording Processing Data

- Records processing details to verify processing time and the amount of completed stocks

DIAGNOSE (PROCESS)				111	N1	SFT
Total time				133:	06:	25
Single time				00:	03:	38
Target stocks				10		
Completed stocks				10		
Date	2017/02/21			Time	14:55:46	

Integration with Servo System

- Provides auto-gain tuning and compensation function for calculating parameters and controlling servo drives, and integrates with the CNC system, Delta's AC servo system and the HMI for outstanding motion control

DIAGNOSE (Servo Monitor)							111	N1	SFT
Ch	Axis	Cont.	Rdy	Load	Peak	MECH	Home	Abs. Rat	
0	X	OK	OK	1 %	7 %	90.000	OK		
0	Z	OK	OK	0 %	9 %	190.000	OK		
0	SP1	OK	OK	0 %	7 %	0.000	OK		

Servo Parameter Name and Values

DIAGNOSE (Servo Tuning)				111	N1	SFT
Ch	Axis	Current	Calculate	In Drive		
P1-37	Load Inertia Ratio	1.0	1.0			
P2-00	Position Loop P gain	35	35			
P2-02	Position Feedforward	50	50			
P2-04	Speed Loop P gain	500	500			
P2-05	Speed Loop I gain	100	100			
P2-25	OSC Reject Filter	2	2			
P2-26	External Noise Reject	0	0			
P2-49	Speed D Filter and I Suppression	0.01	1000	0.01	1000	
P2-47	Auto Resonance Suppression Sel	1	1			
P2-23	Notch filter Freq(1)	1000	1000			
P2-24	Notch filter Freq(2)	0	0			
P2-43	Notch filter Gain(1)	1000	1000			
P2-44	Notch filter Gain(2)	0	0			
P2-45	Notch filter Freq(3)	1000	1000			
P2-46	Notch filter Gain(3)	0	0			

Positioning Points Setup

Tuning Criteria

Auto-gain Tuning Result

Current Servo Parameter Values

Other Functions

Remote Monitoring & Data Synchronous Management

- Connects the NC 200 Series with a personal computer via an Ethernet communication network for remote monitoring synchronously managing the programs and data of the controllers

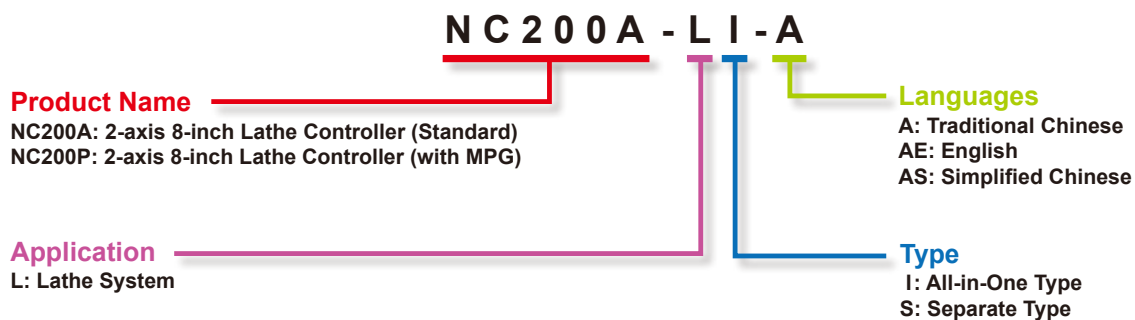
Barcode Application

- Connects barcode readers to the NC200 Series via USB to rapidly scan and input files with barcode names for filing and processing, which saves data searching time

User Authority

- Allows users to assign authority levels and register passwords to set permissions for different users' security control
- Authority management includes system, machine and user (operator) to enhance operation safety

Ordering Information



Electrical Specifications

Models	NC200A-LI-A □	NC200P-LI-A □	NC200A-LS-A □
Operation Environment	10% ~ 95% RH [0 ~ +55 °C]		
Storage Environment	10% ~ 95% RH [-20 ~ +60 °C]		
Cooling Method	Natural Cooling		
Operation Voltage	DC +24V (-10% ~ +15%) (has built-in isolated power circuit)		
Voltage Endurance	AC500V for 1 minute (between charging DC24V terminal and FG terminals)		
Power Consumption	24V 0.6A 15W		
Backup Battery	3V lithium manganese battery CR2032 x 1		
Backup Battery Life	Depends on temperature and usage condition: around 3 years or more under 25° C		
Dimensions (W) x (H) x (D) mm	400 x 320 x 91	400 x 320 x 130	400 x 200 x 93
Weight (kg)	4.5	4.7	3.4

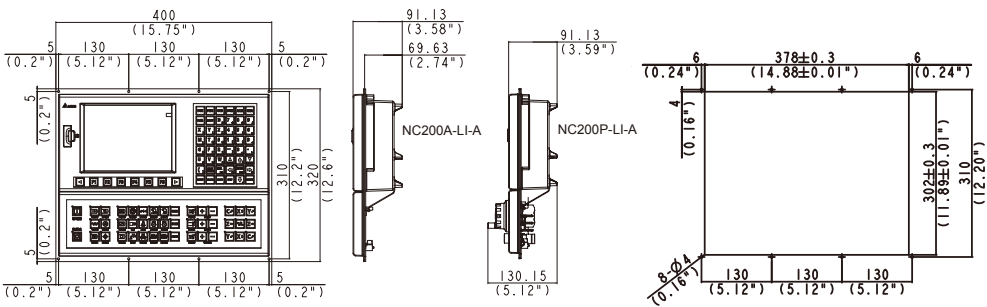
Standard Specifications

Model Name		DELTA NC200A/P
Product Specifications	Max. number of main systems	1
	Max. number of PLC control axes	Max. 5 axes
	Max. number of NC controlled axes (standard)	5 axes
	Max. number of spindle axes	1
	Max. number of simultaneous controlled axes	3 axes
	Least control unit (mm)	0.0001
	Max. number of workpiece coordinate sets	70 (6+64)
	Max. number of tool offset sets	64
	Preview control (single block)	500
	Single block processing time (single block/second)	1000
Hardware Specifications	Standard I/O	8 inputs / 5 outputs
	Optional I/O	Max. 32 inputs / 32 outputs for one remote I/O port; Max. 8 sets of 256 inputs / 256 outputs for extension
	DA	1 set
	Display	8-inch LCD color display
	RJ-45	2 sets
	RS-485	1 set
	CF Card	1 set
Compensation	Backlash compensation	O
	Pitch error compensation	O
	Acute-angle compensation	O
Operation	MPG simulation	O
	Dry run	O
	Optional stop	O
	Single block execution	O
	Pause point start	O
	Breakpoint start	O (breakpoint)
	External offset setting	O
Program Input	Optional skip	O
	Subroutine call	O (M98)
	Acceleration / Deceleration constant of S-curve	O
	Automatic corner deceleration	O
	Circular radius speed limit	O
	Multiple groups of high-speed and high-precision parameters	O
Auxiliary Functions	Machine lock	O
	Software stroke limit	O
	Serial tuning function	O (gain tuning function)
	Rapid spindle positioning	O (M29)
	Data backup restore	O (parameters import and export)
	Startup screen customization	O
	Authority management	O
Program Editing	Background editing	---
	Editing protection	O
Data Transfer	Ethernet (between PC and CNC side)	O
	DNC via Network	O
	DNC via USB	O
Data Display	Graphic simulation	O
G-code	G90 Outer diameter / inner diameter turning cycle	O
	G92 Thread turning cycle	O
	G94 Endface turning cycle	O
	G31 Skip function	O
	G32 Thread cutting	O
	G34 Variable pitch thread cutting	O
	G54 ~ G59 Workpiece coordinate system setting	O
	G70 ~ G76 Multiple cutting cycle	O
	G92 Absolute zero coordinate system setting	O
	G96 Constant surface cutting speed	O

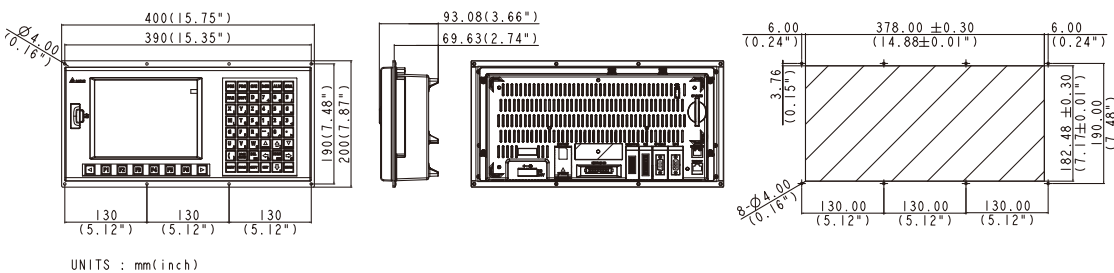
Dimensions

NC200A-LI-A ☐

NC200P-LI-A ☐



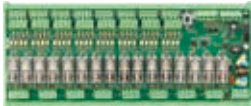
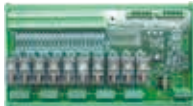






NC200A-LS-A ☐



Units: mm (inch)

Optional Accessories

High Speed Serial I/O			
I/O Cable	Photocoupler Type	Relay Type	Relay Type
 <ul style="list-style-type: none"> 1.5 / 3.0 / 5.0 / 10 m Part No.: <ul style="list-style-type: none"> 1.5m NC-CAB-EIO015 3.0m NC-CAB-EIO030 5.0m NC-CAB-EIO050 10m NC-CAB-EIO100X 	 <ul style="list-style-type: none"> 32 Inputs / 32 Outputs Part No.: NC-EIO-T3232 Size: <ul style="list-style-type: none"> 286 mm x 121.78 mm x 51.01 mm (Length x Width x Total Height) 	 <ul style="list-style-type: none"> 32 Inputs / 16 Outputs Part No.: NC-EIO-R3216 Size: <ul style="list-style-type: none"> 286 mm x 121.7 mm x 54.73 mm (Length x Width x Total Height) 	 <ul style="list-style-type: none"> 20 Inputs / 10 Outputs Part No.: NC-EIO-R2010 Size: <ul style="list-style-type: none"> 217 mm x 121.79 mm x 60.56 mm (Length x Width x Total Height)

Converter			Other
6-Axis Pulse Converter	AD Converter	DA Converter	MPG
 <ul style="list-style-type: none"> 6 Axes of Pulse Output Part No.: NC-EIO-PMC06 Size: <ul style="list-style-type: none"> 217 mm x 121.78 mm x 41.9 mm (Length x Width x Total Height) 	 <ul style="list-style-type: none"> Analog Input Type (4 channel ADC) Part No.: NC-EIO-ADC04 Size: <ul style="list-style-type: none"> 146.25 mm x 86.78 mm x 51.05 mm (Length x Width x Total Height) 	 <ul style="list-style-type: none"> Analog Output Type (4 channel DAC) Part No.: NC-EIO-DAC04 Size: <ul style="list-style-type: none"> 146.25 mm x 86.78 mm x 51.05 mm (Length x Width x Total Height) 	 <ul style="list-style-type: none"> Manual Pulse Generator Part No.: NC-MPG-105HS-FL Size: <ul style="list-style-type: none"> 184 mm x 73 mm x 71 mm (Length x Width x Height)



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Industrial Automation Headquarters

Delta Electronics, Inc.

Taoyuan Technology Center
No.18, Xinglong Rd., Taoyuan District,
Taoyuan City 33068, Taiwan
TEL: 886-3-362-6301 / FAX: 886-3-371-6301

Asia

Delta Electronics (Shanghai) Co., Ltd.

No.182 Minyu Rd., Pudong Shanghai, P.R.C.
Post code : 201209
TEL: 86-21-6872-3988 / FAX: 86-21-6872-3996
Customer Service: 400-820-9595

Delta Electronics (Japan), Inc.

Tokyo Office
Industrial Automation Sales Department
2-1-14 Shibadaimon, Minato-ku
Tokyo, Japan 105-0012
TEL: 81-3-5733-1155 / FAX: 81-3-5733-1255

Delta Electronics (Korea), Inc.

Seoul Office
1511, 219, Gasan Digital 1-Ro., Geumcheon-gu,
Seoul, 08501 South Korea
TEL: 82-2-515-5305 / FAX: 82-2-515-5302

Delta Energy Systems (Singapore) Pte Ltd.

4 Kaki Bukit Avenue 1, #05-04, Singapore 417939
TEL: 65-6747-5155 / FAX: 65-6744-9228

Delta Electronics (India) Pvt. Ltd.

Plot No.43, Sector 35, HSIIDC Gurgaon,
PIN 122001, Haryana, India
TEL: 91-124-4874900 / FAX : 91-124-4874945

Delta Electronics (Thailand) PCL.

909 Soi 9, Moo 4, Bangpoo Industrial Estate (E.P.Z),
Pattana 1 Rd., T.Phraksa, A.Muang,
Samutprakarn 10280, Thailand
TEL: 66-2709-2800 / FAX : 662-709-2827

Delta Electronics (Australia) Pty Ltd.

Unit 20-21/45 Normanby Rd., Notting Hill Vic 3168, Australia
TEL: 61-3-9543-3720

Americas

Delta Electronics (Americas) Ltd.

Raleigh Office
P.O. Box 12173, 5101 Davis Drive,
Research Triangle Park, NC 27709, U.S.A.
TEL: 1-919-767-3813 / FAX: 1-919-767-3969

Delta Electronics Brazil

São Paulo Sales Office
Rua Itapeva, 26 - 3º, andar Edifício Itapeva,
One - Bela Vista 01332-000 - São Paulo - SP - Brazil
TEL: 55-12-3932-2300 / FAX: 55-12-3932-237

Delta Electronics International Mexico S.A. de C.V.

Mexico Office
Gustavo Baz No. 309 Edificio E PB 103
Colonia La Loma, CP 54060
Tlalnepantla, Estado de México
TEL: 52-55-3603-9200

EMEA

Headquarters: Delta Electronics (Netherlands) B.V.

Sales: Sales.IA.EMEA@deltaww.com
Marketing: Marketing.IA.EMEA@deltaww.com
Technical Support: iatechnicalsupport@deltaww.com
Customer Support: Customer-Support@deltaww.com
Service: Service.IA.emea@deltaww.com
TEL: +31(0)40 800 3900

BENELUX: Delta Electronics (Netherlands) B.V.

De Witbogt 20, 5652 AG Eindhoven, The Netherlands
Mail: Sales.IA.Benelux@deltaww.com
TEL: +31(0)40 800 3900

DACH: Delta Electronics (Netherlands) B.V.

Coesterweg 45, D-59494 Soest, Germany
Mail: Sales.IA.DACH@deltaww.com
TEL: +49(0)2921 987 0

France: Delta Electronics (France) S.A.

ZI du bois Challand 2, 15 rue des Pyrénées,
Lisses, 91090 Evry Cedex, France
Mail: Sales.IA.FR@deltaww.com
TEL: +33(0)1 69 77 82 60

Iberia: Delta Electronics Solutions (Spain) S.L.U

Ctra. De Villaverde a Vallecas, 265 1º Dcha Ed.
Hormigueras – P.I. de Vallecas 28031 Madrid
TEL: +34(0)91 223 74 20

Carrer Llacuna 166, 08018 Barcelona, Spain

Mail: Sales.IA.Iberia@deltaww.com

Italy: Delta Electronics (Italy) S.r.l.

Via Meda 2-22060 Novedrate(CO)
Piazza Grazioli 18 00186 Roma Italy
Mail: Sales.IA.Italy@deltaww.com
TEL: +39 039 8900365

Russia: Delta Energy System LLC

Vereyskaya Plaza II, office 112 Vereyskaya str.
17 121357 Moscow Russia
Mail: Sales.IA.RU@deltaww.com
TEL: +7 495 644 3240

Turkey: Delta Greentech Elektronik San. Ltd. Sti. (Turkey)

Şerifali Mah. Hendem Cad. Kule Sok. No:16-A
34775 Ümraniye – İstanbul
Mail: Sales.IA.Turkey@deltaww.com
TEL: + 90 216 499 9910

GCC: Delta Energy Systems AG (Dubai BR)

P.O. Box 185668, Gate 7, 3rd Floor, Hamarain Centre
Dubai, United Arab Emirates
Mail: Sales.IA.MEA@deltaww.com
TEL: +971(0)4 2690148

Egypt + North Africa: Delta Electronics

Unit 318, 3rd Floor, Trivium Business Complex, North 90 street,
New Cairo, Cairo, Egypt
Mail: Sales.IA.MEA@deltaww.com