

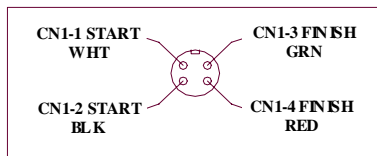
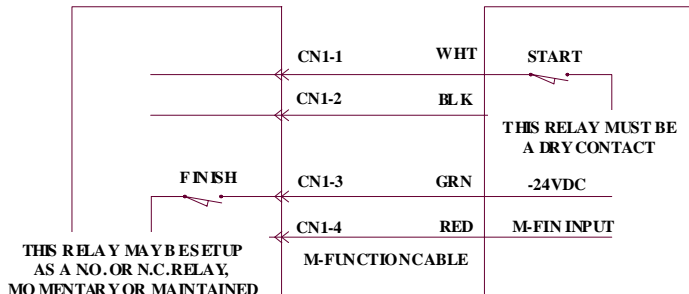
FCN SERIES CONTROL

- ◆ **MODEL FCN-35 CONTROL** (6.5" THRU 9" TABLES)
- ◆ **MODEL FCN-50 CONTROL** (10" THRU 20" TABLES)

M-CODE WIRING DIAGRAM

*FCN-35 OR FCN-50
CONTROL*

CUSTOMER CNC CONTROL



VIEW OF CONNECTOR ON BACK OF FCN-



FCN CONTROL

STANDARD FEATURES:

- SIMPLE MENU DRIVEN COMMANDS AND SOFT KEYS
- 4 LINE BLUE LCD DISPLAY (POSITION, PROGRAM, PARAMETERS)
- STANDARD G-CODE AND M-CODE PROGRAMMING
- LINE REPEAT, LINE JUMP AND SUB-PROGRAM CALL COMMANDS
- (G90) ABSOLUTE AND (G91) INCREMENTAL PROGRAM MODES
- (G00) RAPID TRAVERSE AND (G01) FEED RATE MODES
- MDI MODE CAPABILITY (MANUAL DATA INPUT)
- TWO KEYPADS FOR PROGRAM AND PARAMETER ENTRY AND EDITING
- 0-150% FEEDRATE OVERRIDE RUN / JOG POTENTIOMETER
- EMERGENCY STOP AND CYCLE START PUSHBUTTONS
- RS-232 COMMUNICATIONS PORT (UPLOAD, DOWNLOAD & DNC)
- M-FUNCTION INTERFACE CAPABILITY (CABLE INCLUDED) SEE PRINT
- BACKLASH COMPENSATION (PARAMETER SETTING)
- 115VAC 20 AMP INPUT (POWER CABLE AND CABLE TO ROTARY TABLE INCLUDED)

SAMPLE PROGRAM:

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0 998      (PROGRAM NUMBER)
G90       (ABSOLUTE POSITIONING)
A360 M60 (A-AXIS MOVE 360 DEG; BRAKE ON)
P999 L12 (SUBPROGRAM CALL; REPEAT 12 TIMES)
A-360 M60 (A-AXIS MOVE -360 DEG; BRAKE ON)
M30      (END PROGRAM)

0 999      (SUBPROGRAM NUMBER)
G91       (INCREMENTAL POSITIONING)
A30 M60 (A-AXIS MOVE 30 DEG; BRAKE ON)
M99      (END SUBPROGRAM & LINE JUMP)
    
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