



# SERIES 8 CNC

## MULTI-SPINDLE LATHE

**FEATURING**

### SPECIALIZED SOFTWARE PACKAGE TARGETED TO MEET THE NEEDS OF THE MULTI-SPINDLE INDUSTRY

**Question: Why put CNC on your multi-spindle?**

**FASTER SETUP TIMES**

**SINGLE POINT THREADING**

**IMPROVED ACCURACY**

**ELIMINATE SECOND OPERATION**

**EASE OF PART ADJUSTMENTS**

**ELIMINATE SPECIAL TOOLING**

**Answer: Maintain high production while adding flexibility**

- Up to four part program streams supported for 2-axis slides including 2-axis contouring and single point threading
- Thermal compensation eliminates scrap during machine warm-up
- Tracking of the main feed cam; coordination of CNC cycle with machine cycle
- Synchronized pickoff capabilities with 2-axis backworking
- Up to six additional program streams for 1 axis slides

Easy to set up and program  
Touchscreen, menu-driven interface



# PENDANTS & PC



## OPERATOR PENDANT

### TOUCH SCREEN

DISPLAY: MACHINE POSITION, PROGRAM, MACHINE STATUS, TOOL OFFSETS, CARRIER OFFSETS, MACHINE FUNCTIONS, ETC.

### CUSTOM 4x4 PANEL

MANUALLY CONTROL CHIP CONVEYOR, SKIMMER, LUBE, COOLANT, HYDRAULICS, ETC.

## INDUSTRIAL PC



PC front end provides a user friendly interface and ease of importing program files



## REMOTE PENDANT

An extension of the main operator's pendant, with the same 4 x 4 panel buttons and hand wheel for accurate control, without the size requirements for the display. Valuable and time saving when working on the side of the multi-spindle lathe without the main operator's pendant.

## HANDHELD PENDANT

Our durable handheld pendant allows the operator to walk around the machine to each position and work closely to setup each position accurately in as little time as possible.





## MULTIPLE PROGRAM STREAMS

1-AXIS                      2-AXIS

**X2 cycle definition**

Initial dwell	2
Rapid approach endpt	2.25
Feedrate for 1st cut	.012
# chip breaks, 1st cut	2
Chip brk dist, 1st cut	1.75
Endpoint for 1st cut	.005
Feedrate for 2nd cut	2
# chip breaks, 2nd cut	.002
Chip brk dist, 2nd cut	1.527
Endpoint for 2nd cut	3
Final dwell	.03
Retract feedrate	2
Retract endpoint	2.5
End/start position	

Dwell time before rapid approach, in spindle revolutions

Dwell time before rapid approach, in spindle revolutions

Dwell time before rapid approach, in spindle revolutions

Dwell time before rapid approach, in spindle revolutions

Dwell time before rapid approach, in spindle revolutions

Dwell time before rapid approach, in spindle revolutions

**POSITION 8**

**POSITION 5**

**POSITION 4**

**POSITION 1**

```

T01
G05
G00 X2.5Z.25
G01 Z0F.012
G02 X2.25Z-.125
G01 Z-.5
G01 X2Z-.78
G00 X.25
G00 Z.25
M30

```

Program up to 10 program streams simultaneously, 4 2-axis slides or 6 1-axis slides, including 2-axis contouring and single point threading

## SPINDLE OFFSET

System    Configure    Offsets    Files    Program    Maintenance

CNC DISABLE    CYCLE START    CONTROL RESET    JOG MODE

HOME MODE    HAND WHEEL    JOG TO START

SERVO ON

Spindle Offsets: Position 2

Spindle	X	Z
1	0.0000	0.0000
2	0.0000	0.0000
3	0.0000	0.0000
4	0.0000	0.0000
5	0.0000	0.0000
6	0.0000	0.0000
7	0.0000	0.0000
8	0.0000	0.0000

7 8 9 + -

4 5 6 ↑ ↓ Exit

1 2 3 ← → Back Space

0 - - - - - Enter

F1 Help    F2 Change Window 1    F3 Change Window 2    F4 Change Window 3    F5 Extended Op. Panel    F6    F7    F8    F9    F10    F11 Tool Wear    F12 Keyboard

IN POSITION

Spindle offsets allow for some mechanical 'slop' in the spindles to be corrected by the software. Allowing more accurate parts to be cut with fewer reworking needed.

## MAIN SCREEN

②

③

X 0.0000

Z 0.0000

④

X 0.0000

Z 0.0000

X 0.0000

Z 0.0000

X 0.0000

Z 0.0000

Set Position    Enter Offset

F1 Help    F2 Change Window 1    F3 Change Window 2    F4 Change Window 3    F5 Extended Op. Panel    F6    F7    F8    F9    F10    F11 Tool Wear    F12 Keyboard

IN POSITION

### ① Machine Status Screen

Display screen for current machine position coordinates and status

### ② Cam Angle

Visually displays the cam angle, with green being the work degrees, yellow is high speed, and red is when the carrier is indexing

### ③ Slide Coordinates

The positions controlled by the CNC will have their slide coordinates of the cutting tool displayed, with the percentage complete bar across the bottom on the cell

### ④ Spindle Locations

Visual representation of the carrier and spindles displaying their real time locations

The SERIES 8 CNC for multi-spindle lathes is designed with the operator in mind. Multiple operator pendant options (main, remote and handheld) allow the operator to setup the machine from both sides of the machine. The large, bright touch-screen makes controlling the machine and navigating the software easy. With our customized 16 button (4x4) panel on the front of the operator pendants, machine options are not buried in control menus. Transferring part programs is easy with an industrial PC as the front end for the user interface. Use one of the multiple USB ports to plug a flash drive into or use the networking capabilities of Microsoft's Windows XP Professional to transfer part programs from your office PC to the SERIES 8 CNC.

# HIGH PRODUCTION

# HIGH FLEXIBILITY

## AXIS CONTROL

- » up to four 2-axis slides, M & G code program format
- » up to six 1-axis slides, 'fill-in-the-blank' programming
- » feed motor and spindle speed control
- » synchronized pickoff and 2-axis backworking

## OFFSETS

- » tool offsets
- » tool wear offsets
- » spindle carrier offsets
- » thermal compensation offsets

## CYCLE CONTROL

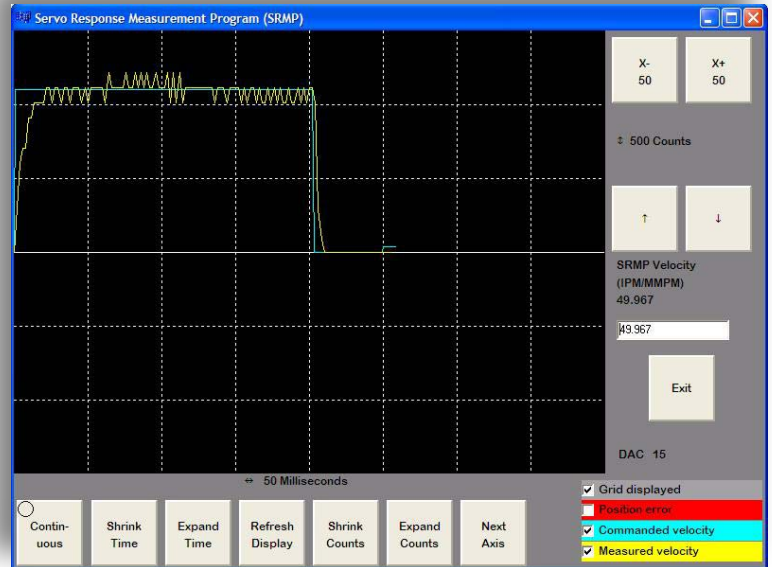
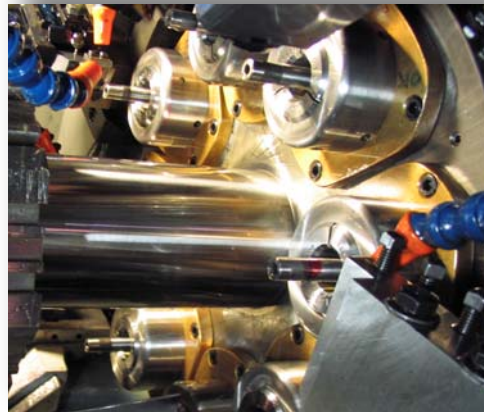
- » cycle control based on feed cam angle
- » programmable cycle start and stop angles for each slide position
- » control of auxiliary functions based on cam angle
- » programmable cycle stop position
- » tool life counter
- » part and batch counters

## OPERATOR FRIENDLY

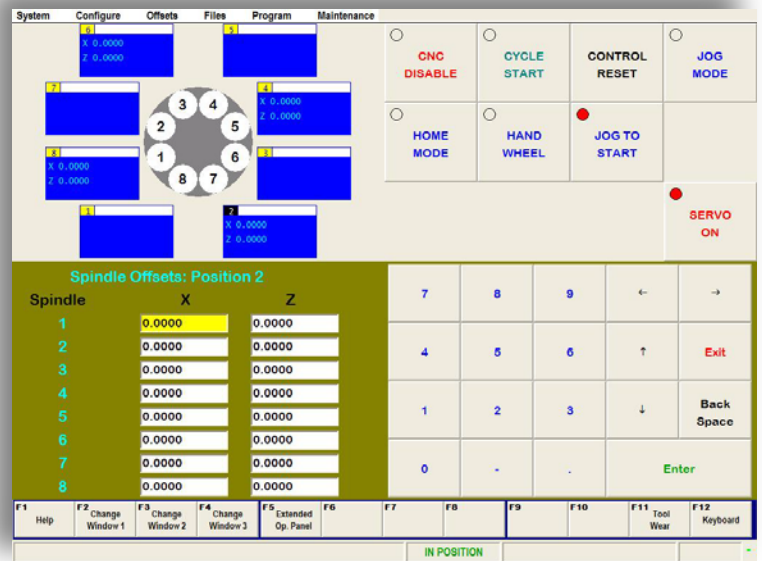
- » touch screen, menu driven
- » program editor
- » graphic program preview

## SERVICE

- » complete integration support available



On screen servo tuning with graphic display



Spindle offsets correct for spindle carrier variations

## CONTACT INFORMATION

SIEB & MEYER USA, LLC  
 3975 Port Union Road  
 Fairfield, OH 45014  
 PHONE: (513) 563-0860  
 FAX: (513) 563-7576  
[www.sieb-meyersusa.com](http://www.sieb-meyersusa.com)  
[info@sieb-meyersusa.com](mailto:info@sieb-meyersusa.com)

**SIEB & MEYER USA CAN DESIGN AND BUILD THE ENTIRE ELECTRICAL INTERFACE**

**SIEB & MEYER**

