GSA+

# G-MATE AC Servo Controller

◎ Easy operation, saving space of machine shop.
◎ Connecting with-CNC Rotary Table to M-Code of CNC M/C for equal division indexing machining.
◎ The best solution for conventional M/C which could not retrofitted 4th axis.
◎ Program capacity = 9 sets, minimum increment 0.001°

**Suitable Rotary Table :**

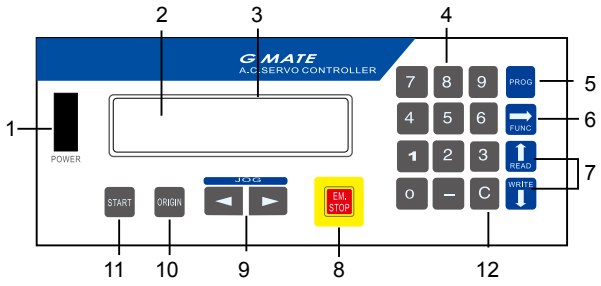
| | | | |
|---|---|---|---|
| CNC-120R | CNC-200RB | CNC-400R | CNCMT-200 |
| CNC-170RB | CNC-250R | CNC-500R | CNCMT-320 |
| CNC-170R | CNC-250RB | CNC-630R | NCF-250 |
| CNC-200R | CNC-320R | CNC-800R | |

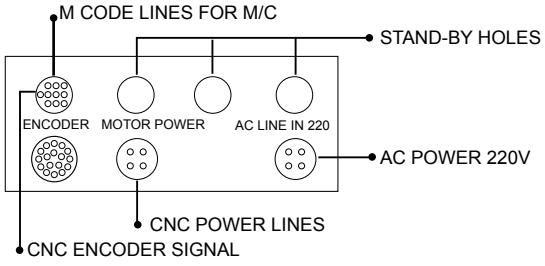
| ITEM | SPECIFICATION | ITEM | SPECIFICATION |
|---|---|---|---|
| Min. Increment | 0.001° | Key-Lock Function | Set Parameter # 7 to (1) |
| Programmable Angle | 1-999° | Mode Selection After Power On | Program mode / Run mode |
| Max. Equal Dividing | 2-999 equal dividing | Backlash Adjustment | Parameter # 17 |
| Emergency Stop | Whole system stop | Previous Step Display Function | Pushing “WRITE” key |
| Input System | key board | Next Step Display | Pushing “READ” key |
| Zero Return | Can be compensated by software / hardware | Standard Parameter Function | Parameter # 1-17 can be set easily |
| Feed rate | F1~F2000 (degree/sec.) | Motor | Meldas HC motor with feed back unit |
| Program Capacity | Nine programs, 99 steps for each program | Connection Cable | For input power/pulse coder, motor power cycle start / finish signal / brake signal |
| Jump Function | Jump to sub-program (code. 95) | Input Power | AC 240V/50Hz / three phase |
| Loop Count | Up to 999 times per step | Voltage | Below 48V/DC |

## Example

| | |
|---|---|
| Step 1 | Turn (Power) switch on. |
| Step 2 | Push and hold PROG and release display becomes blinking |
| Step 3 | Push and hold CLR for 5 sec. or "00" display |
| Step 4 | Key in "9000" |

| | |
|---|---|
| Step 5 | Push PROG to feed-rate (F), input "30" |
| Step 6 | Push FUNC to loops (L), input "4" |
| Step 7 | Push PROG display become no blinking |
| Step 8 | Push START table start rotating 4 times |




| | | | |
|---|---|---|---|
| ON POWER | 1. POWER SWITCH | EM STOP | 8. EMERGENCY STOP BUTTON<br>● The rotating table shows down and stop.<br>● When(11) CYCLE START BUTTON is depressed again, the table rotates the remaining angle of the program. |
| | 2. PROGRAM STEP DISPLAY SCAN<br>Present the step number you are on. | | |
| | 3. DATA DISPLAY SCAN<br>To show either position, step angle feedrate or loop count. | JOG ◀ ▶ | 9. JOG BUTTON<br>To jog the movement at single step, holding for rapid movement after 150 pulse. |
| 1 ~ 9 | 4. DATA ENTER KEYS<br>Enter in data of program | | |
| PROG | 5. MODE BUTTON<br>To select in the PROGRAM or RUN mode<br>● If the display is steady, you are in RUN mode.<br>● If it is flahing on and off, you are in PROGRAM mode. | ORIGIN | 10. ZERO RETURN BUTTON<br>In the RUN mode, push the button will return the table to Zero Point. |
| FUNC | 6. FUNCTION BUTTON<br>To view the piece of data in the display scan of the controller. | START | 11. CYCLE START BUTTON<br>The table rotates as programmed. |
| READ<br>WRITE | 7. STEP READ or WRITE BUTTON<br>● Scans step number from 1-99.<br>● To read or write prevenient or next step. | C | 12. CLEAR BUTTON<br>● In the RUN mode, it resets the "P" display to zero.<br>● In the PROGRAM mode, it is used to clear the current line or collect the error |