

Hotline-Support KOSY/MCS

Category 1: Machining of workpiece Error: Measures are not correct – too big - too small

Basics

After starting the machining program or during its operation you remark that the parts are too big or too small. In most cases the measures differ by factor 2 or even 10. A simple check can be helpful:

1. Make a reference run (key HOME)
2. Set the display to zero by Ctrl + End
3. Enter the CNC-command G00 X100
4. Watch the travel and measure it – is it really 100mm?

Remark:

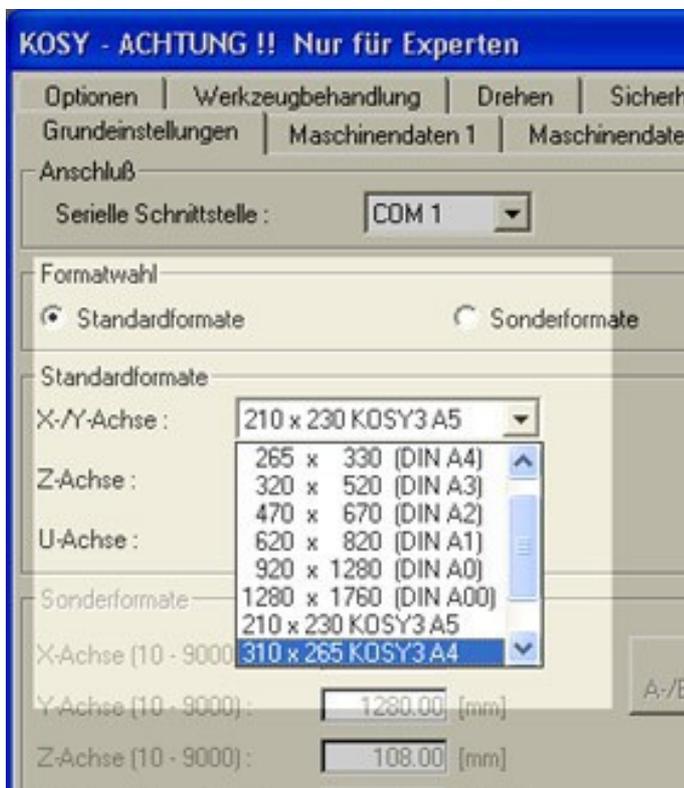
It is possible that the motors spin, you hear a howling noise. Then you needn't measure...

Possible causes of error and their correction

1. Wrong machine or wrong parameters were set

The different generations of our products have got changes in their mechanics as well as in their electronics, therefore the settings in the software must match them. Check the settings:

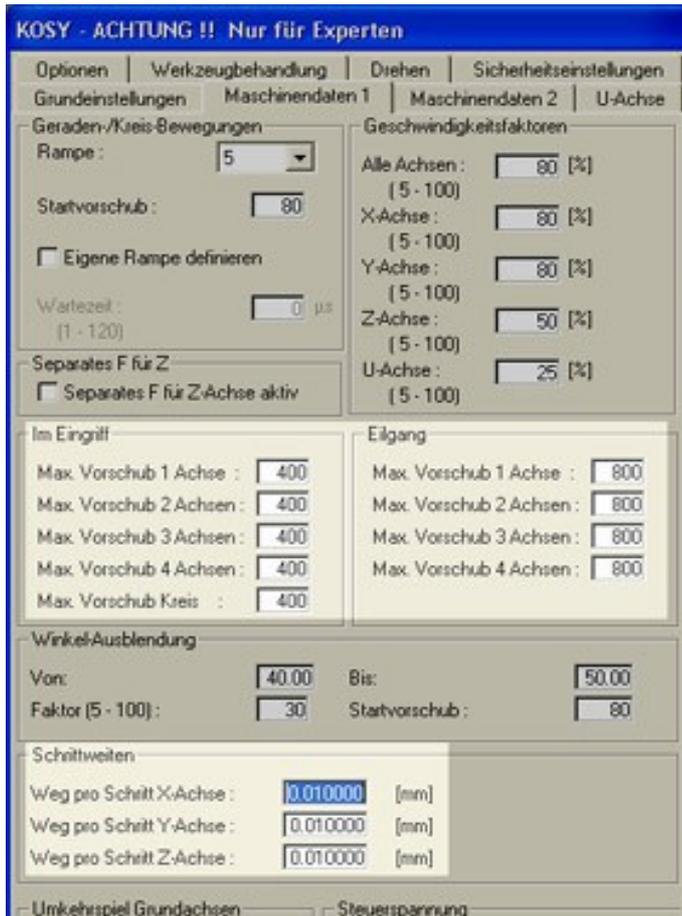
1. Select menu Parameters
2. Select machine or else, depending on version
3. Edit parameters
4. Confirm the caution message, it tells you to be careful with the settings.
5. The following window for basic settings appears:



Pay attention to KOSY3 or KOSY 4. Machines of older generations haven't got that addition. Select the right machine. When you are not sure, have a look to the type label or the delivery slip.

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Check other settings. There may be differences between the generations KOSY1 and KOSY2 , but also inside the generation KOSY3 with MCS and **nccad7.5**. The differences refer mainly to settings of speed and step width, see the following picture:



In the tab Machine data 1 the settings for step width and speed must correspond to your machine:

KOSY1 (till construction 1994)	Width of step: 0.005 mm	in attack: 200	in fast mode: 250
KOSY2 (till construction 2007)	Width of step: 0.01 mm	in attack: 250	in fast mode: 450
KOSY3 with MCS/IF5 (till Sept.2008)	Width of step: 0.0025 mm	in attack: 300	in fast mode: 500
KOSY3 with MCS/IF6 (since Sept. 2008)	Width of step: 0.00125 mm	in attack: 400	in fast mode: 800

After you have changed the settings, please check again the measures, s.above.