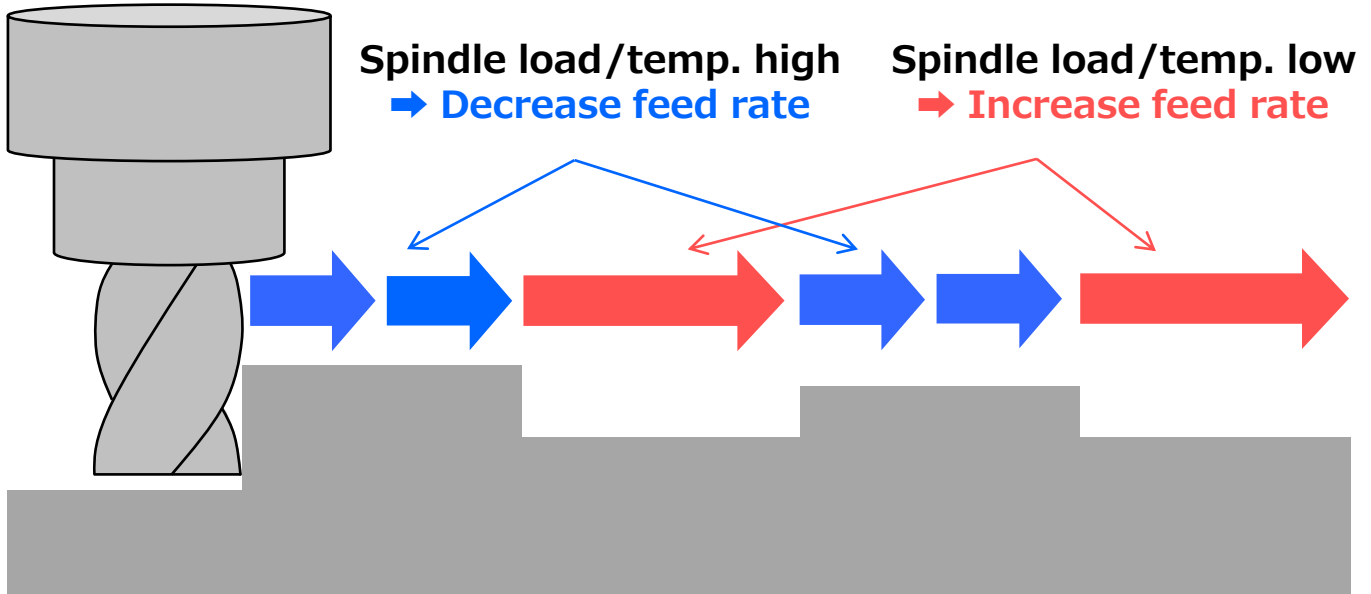


Smart Spindle-load Control



Real-time feed control according to spindle load/temp.

No.	工具名称	自動設定	主軸負荷 レベル	目標主軸負荷	制 主
デフォルト		<input type="checkbox"/>	0		
1	MILLING	<input checked="" type="checkbox"/>	9	254	
2	ENDMILL	<input checked="" type="checkbox"/>	9	78	
3	MILLING	<input checked="" type="checkbox"/>	9	293	
4		<input type="checkbox"/>	0	0	
5		<input type="checkbox"/>	0	0	
6		<input type="checkbox"/>	0	0	

Auto setting
by one-time machining

Adjustment with
referring to waveform
of spindle load

Demonstration

Cycle time reduction

- Dynamic feed rate control reduces cycle time

Heavy cutting with large tools

- Φ 63mm milling (depth 4 mm)
- Φ 25mm grooving (depth 4 mm)

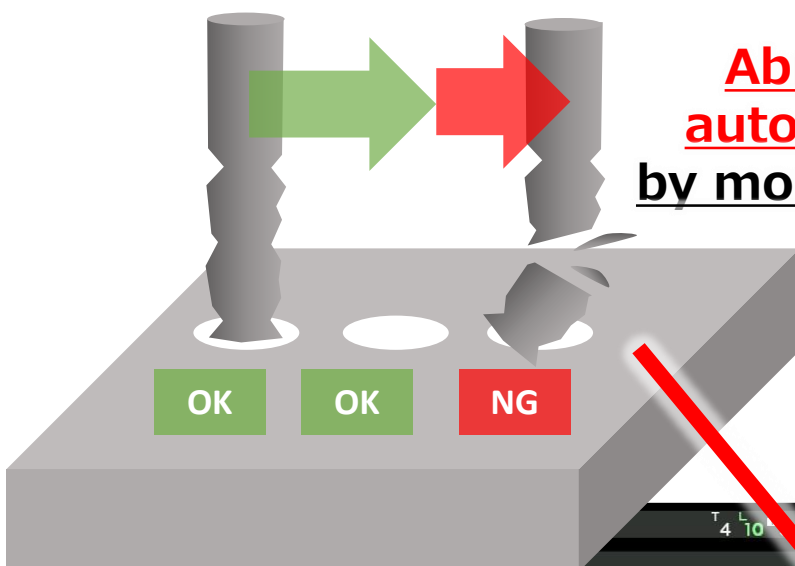


Latest information of ROBODRILL is available on our website.

<https://www.fanuc.co.jp/en/product/robodrill/index.html>



Cutting Load Monitor



Abnormal cutting is automatically detected by monitoring cutting load

使用	G1	工具	比較	下限	標準	現在	上限	有効	開始	終了
<input checked="" type="checkbox"/>	1	1 ドリル	最大	8.25	16.50	3.08	33.00	<input type="checkbox"/>	17.0170	0.0000
<input checked="" type="checkbox"/>	2	2 ドリル	最大	8.33	16.64	11.02	33.29	<input type="checkbox"/>	16.9934	0.0000
<input checked="" type="checkbox"/>	3	3 ドリル	最大	8.47	16.94	16.00	33.8	<input type="checkbox"/>	16.9935	0.0000



Merit

- No need for sensor installation
- Automatic generation of judgment conditions
- Alarm display and machine stop

Demonstration

Generate judgment conditions

- One-time reference machining generates judgment conditions

Abnormal cutting detection of Drilling and Tapping

- $\Phi 3.3$ mm drilling (pilot hole)
- M4 tapping

