Machine Tool Products

Siemens SINUMERIK 828 Analog Retrofit

for

Milling Machines

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For more information or to request a quote please contact:

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Analog Retrofit Photos
Put a NEW Siemens control on your machine for a fraction of the cost, reusing your motors and drives

Requirements for Analog Control Only Upgrade:

- Current Drive command is analog
- Drives operational
- Enclosure depth from back-plate at least 12”
- Feedback Encoders AqBq TTL
- Ratios/Pitches required between motors and load
Siemens 828 Control System Overview

Standard Siemens 828 Control Features

- 10.4” Color Display
- Ethernet/USB Data Transfer
- Siemens ProgramGUIDE & ISO Programming (Fanuc Dialect)
- 4th Axis Capable (interpolating)
- Tool Wear Monitoring
- Speeds/Feeds Calculator
- Tool Table
- Full Alphanumeric Keyboard
- in to mm toggle
- Backlash & Temperature Compensation
- 3MB of User Memory (Additional Memory - CF card)
- 128 Tools / 256 Cutting Edges
- On Screen Help Manual

Included in Package:

- Siemens 828 PPU with MCP (Operator Station Optional)
- Back Plate (27” x 17”) with the following components mounted:
  - (2) Analog HLA Modules
  - (4) Encoder Feedback Breakouts
  - (2) IO Breakouts wired to relays
  - 24V and 120V Relays
  - 50 Terminal Blocks
  - SMC30 Module for Spindle Feedback
- Bi-Directional Compensation Software Option
- Measuring Cycles Software Option (Probing)
- MTP Source Code (tool changer optional)
- 72in/48out IO Board

Available Options

- NEW Siemens Analog Drives and Motors (V90 Drives + IFL6 Motors)
- ShopMill Conversational Programming
- Advanced Technology Functions
- DXF Reader
- 3D Simulation
- FREE Offline Software (Not full feature)
- Turnkey Installation & Commissioning
Control Screenshots

- Main Start Up Screen
- G-Code Editor
- Tool Management
- Move Position Command
- Measure Tool
- Measure Workpiece
Probing Cycles (AUTOMATIC)

- Edge
- Slot
- Rectangular Corner
- Rectangular Pocket
- Hole
- Inside Circular Segment
- Ball
- Align Plane
Machine Tool
products.com

Align Edge

Any Corner

Circular Spigot

Rectangular Spigot

Outside Circular Spigot

Web

3 Balls
ShopMill Conversational Features (Optional)

*non-standard features included in options*

- Ability to Write and Edit G-Code
- Repeat, Rotate, Mirror, Offset, and Scaling
- Solid Model Graphics (Centered Block, Pipe, Cylinder, N Corner, and Regular Block)
- 2D or 3D Multiview Operation Graphics
- Estimated Machining Time
- *Advanced Technology Functions (Option)*
- *DXF Import (Option)*
- *3D Simulation (Option)*

**Drilling Cycles**

- Centering
- Drilling
- Reaming
- Deep Hole Drilling
- Boring
- *Tapping (rigid tapping requires high performance spindle option)*
- Positions (bolt hole circle, rectangle, array, position, repetition)

**Milling Cycles**

- Face Milling
- Pocket Milling (*expansion pack for pocket milling cycles included*)
  - Rectangular Pocket
  - Circular Pocket
- Slot Milling (*expansion pack for slot milling cycles included*)
  - Circumference Slot
  - Open Slot
  - Longitudinal Slot
- Helix Milling
- *Multi-Edge Spigot (rectangular, circular, multi)*
- *Thread Milling (requires high performance spindle option)*
- *Engraving*

**Contouring Cycles**

- Path Milling (rough, finishing, chamfer)
- Rough Drill
- Pocket & Spigot
- Chamfering

**ShopMill Screenshots**

**Solid Model Graphics (Blank)**

![Block Centered](image1)

- **Block**
- **N Corner**
- **Cylinder**
- **Pipe**
ShopMill Machining Cycles

Drilling

Pocket Milling
*This is not a complete list of the included machining cycles*
3D Simulation

Want to Try Sinumerik CNC Before you Buy?

Download the FREE PC Software HERE.
FREE Training Webinars covering the following:

- Workpiece/Tool Setup
- G-Code Standard/Advanced Cycles (programGUIDE)
- Program Simulation
- Create & Manage Tools/Offsets
- Conversational Standard/Advanced Cycles (ShopMill/ShopTurn)
- Working with CAD/CAM Programs
- DXF Programming
- Automatic Calculations (trig, contours, etc.)
- Probing Cycles (Manual/Automatic)
- And Many more!

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