
HIGH-SPEED HIGH-PRECISION CONTROLLER

TAIWAN

Taiwan (Hsinchu)

SYNTEC Technology Co., Ltd
ADD : No.25, Yanfa 2nd Rd., East Dist.,
Hsinchu City 300, Taiwan (R.O.C.)
TEL : +886-3-6663553
TEL : +886-3-6663505
EMAIL : sales@syntecclub.com.tw

Taichung

SUN-CNC Co., Ltd
ADD : No. 22, Lane 428, Section 1, Fengyuan
Boulevard, Fengyuan District
TEL : +886-4-25337731
TEL : +886-4-25349224
TAX : +886-4-25349224

TANLU-CNC Co., Ltd

ADD : No. 42, Jingming Road, Xitun District,
Taichung City, Taiwan (R.O.C.)
TEL : +886-4-23102626
TEL : +886-4-23102636

Tainan

ADD : No. 218, Denan Road, Rende District,
Tainan City, Taiwan (R.O.C.)
TEL : +886-6-2796707
TEL : +886-6-2796705

AROUND THE WORLD

Malaysia

ADD : 43, Ground Floor, Jalan Tpp1/1, Taman
Perindustrian Puchong, 47100, Selangor Darul Ehsan.
TEL : +603-61577632
TEL : +603-61577632
EMAIL : otis.siah@syntecclub.com.tw;
yenearn.teoh@syntecclub.com.tw

Thailand

ADD : 78/38 Kheha Romklao Rd., Khlong Song Ton Nun,
Lat Krabang, Bangkok, 10520
TEL : +662-006-5738
TEL : +662-006-5738
EMAIL : thanawat@syntecclub.com.tw

Vietnam

ADD : 3F, No. 36, A4 Street, Ward 12, Tan Binh District,
Ho Chi Minh City, VietNam
TEL : +84938332829
TEL : +84938332829
FAX : +842822635566
EMAIL : andyngo@vnsyntec.com.vn

Turkey

ADD : Küçükbakkalköy Mah. Vedat Günyol Cd. Defne Sok.
No:1 D:1502 Flora Residence,34750 Atasehir/Istanbul, Türkiye
TEL : +90-216-2662475
TEL : +90-216-2662475
EMAIL : daisy.cheng@syntecclub.com.tw

USA (South California)

ADD : 766 Pinefalls Ave. Walnut, CA 91789
TEL : +1909-551-0187
TEL : +1909-551-0187
EMAIL : info@syntecamerica.com

Indonesia

PT. OTOMASI BERSAMA INDONESIA
ADD : Ruko Arcadia Mataram Blok B, No 15, Kelurahan
Cibatu, Kecamatan Cikarang selatan, 17530, Indonesia
TEL : +6221 2210 4832
TEL : +6221 2210 4832
EMAIL : yulius@otomasi.co

CHINA

Jiangsu

SYNTEC Equipment CO.,Ltd.
ADD : Building B, Kejiyuan, Xindai, No. 9, Chunhui Road,
Suzhou Industrial Park
TEL : 0512-69008860
TEL : 0512-69008860
FAX : 0512-65246029

Jiangsu-Suzhou

Suzhou Huaxin Numerical Control Technology
Development Co.,Ltd.
ADD : Building A, Kejiyuan, Xindai, No. 9, Chunhui Road,
Suzhou Industrial Park
TEL : 0512-69008890
TEL : 0512-69008890
FAX : 0512-69560818

Nantong

Suzhou New Generation CNC Equipment Co., Ltd.
Nantong Branch (NTST)
ADD : Building A, Kejiyuan, Xindai, No. 9, Chunhui Road,
Suzhou City Industrial Park
TEL : 0513-89077025

Jiangsu-Nanjing

The Suzhou new generation of CNC Equipment
Co., Ltd. Chongqing Branch
ADD : Room 104, Unit 2, Building 6, Jiulonghu Villa, No. 188,
Qingshuiling West Road, Jiangning District, Nanjing City
TEL : 025-52717710
TEL : 025-52717710
FAX : 025-52717702

Anhui Hefei

Suzhou new generation numerical control
equipment Co., Ltd. Hefei branch
ADD : Hefei Binhu Baohe District Century City
Fu Hui Yuan T4-2202map
TEL : 0551-63814183

Shaanxi

Shaanxi Xi'an
The Suzhou new generation of CNC Equipment
Co., Ltd. Xi'an Branch
ADD : Room 11328, Unit 1, Building 4, Duhui, 1, Yicuiyuan,
No. 10, Tangyan South Road, Gaoxin District, Xian City
TEL : 029-88287423
TEL : 029-88287423
FAX : 029-88287423

Guangdong

Suzhou SYNTEC Equipment Co.,Ltd. Guangdong
Branch
ADD : 2F, Building 6, Dongguan-Taiwan Biotechnology
Incubation Center, No.1, Taiwan High-Tech Park, Songshan
Lake
TEL : 0769-22249073
TEL : 0769-22210012
FAX : 0769-22210012

Guangdong Dongguan

Suzhou SYNTEC Equipment Co.,Ltd. Dongguan
Branch Co., Ltd. Chongqing Branch
ADD : Zone B, 3F, Building 1, No.522,
Chain-An East Rd., Changan Townmap
Lake
TEL : 0769-31660318
TEL : 0769-31660318
FAX : 0769-81660328

Guangdong Guangzhou

Suzhou SYNTEC Equipment Co.,Ltd. Guangzhou
Branch
ADD : 2T404, Zhiqi, No. 8, Luojia Village Section, Fuyi Road,
Dalong Street, Panyu District, Guangzhou City
TEL : 020-34583040
TEL : 020-34583040
FAX : 020-34583220

Chongqing

The Suzhou new generation of CNC Equipment
Co., Ltd. Chongqing Branch
ADD : Floor 5, Huilong Building, No. 8, Qianyi Road, Banshi
Village, Changping Town, Dongwan City
TEL : 0769-82826802
TEL : 0769-82826802
FAX : 0769-82826820

Shenzhen

Shenzhen branch
ADD : 5F, Building C, Sunshine Technology Park, Gin-Long
2nd Rd., Baolong Industrial Zone, Shenzhen Longgang District
TEL : 0755-84320380
TEL : 0755-84320380
FAX : 0755-84559490

Jiangmen

Suzhou New Generation CNC Equipment Co., Ltd.
Jiangmen Branch (JMST)
ADD : Room 02, Floor 7, Huojia Building, Gaoxin District, No.
288, Jinou Road, Jianghai District, Jiangmen City,Guangdong
Province
TEL : 0750-3771824
TEL : 0750-3771824
FAX : 0750-3771824

Xiamen

Suzhou SYNTEC Equipment Co.,Ltd. Xiamen
Branch
ADD : No.100,B Chuang Chang Fang 3F East Jin Fu Road,
Tong An District,Xiamen City, Fujian Province, China
TEL : +86-592-7191901
TEL : +86-592-7191901
FAX : +86-592-720536

Zhejiang

Zhejiang Hangzhou
Suzhou SYNTEC Equipment Co.,Ltd. Hangzhou
Branch
ADD : Room 1202 Unit2 Building 1, Edifice Dikai, Jincheng
Road, Baijia Street,Xiaoshan District , Hangzhou City,Zhejiang
Province, China
TEL : 0571-82751187
TEL : 0571-82751187
FAX : 0571-82751186

Zhejiang Ningbo

Suzhou SYNTEC Equipment Co.,Ltd. Ningbo
Branch
ADD : Room 12-07, No.262,416 Alley, Xiaohui Road,
Jiangdong District, Ningbo City.
TEL : 0574-87750305
TEL : 0574-87750305
FAX : 0574-87750306

Zhejiang Wenling

The Suzhou new generation of CNC Equipment
Co., Ltd. Wenling Branch
ADD : Room 1206, Department A, Zhenxing Plaza, Taiping
Subdistrict, Wenling Citymap
TEL : 0576- 86138372
TEL : 0576- 86138372
FAX : 0576-86119106

Luoyang

Henan Luoyang
The Suzhou new generation of CNC Equipment
Co., Ltd. Luoyang Company
ADD : 1-1-704, Runsheng Building, Cross of Sanshan Road
and-Heluo Road, Hi-and-New Tech Park of Luoyang
TEL : 0379-65110352
TEL : 0379-65110352
FAX : 0379-65110352

Chongqing

Suzhou New Generation CNC Equipment Co., Ltd.
Chongqing Branch (COST)
ADD : Block B, Dongli International, 11-6, Building 2, No. 62,
Taishan Boulevard East Section, Bu New District, Chongqing
City
TEL : 023-67913296
TEL : 023-67913296
FAX : 023-67634382

Tianjin

The Suzhou new generation of CNC Equipment
Co., Ltd. Tianjin Branch
ADD : No. 37, A District, Huayuan, Qiaofuqiang, No. 7,
Waihuai West Road, Xiqing District, Tianjin City
TEL : 022-23739192-801
TEL : 022-23739192-801
FAX : 022-23739192

Shandong

Shandong Jinan
Suzhou SYNTEC Equipment Co.,Ltd. Jinan
Branch
ADD : Flyover District of Jinan three Bridge Street No. 29
Luneng Cambridge 9 Building 3 unit 101 room
TEL : 0531-85907208
TEL : 0531-85907208
FAX : 0531-85905708

Hubei

Hubei Wuhan
Suzhou new generation of CNC Equipment Co.,
Ltd. Wuhan Branch
ADD : Room 2003-2006, A Guanggogocui, No.456,
Luoyu East Road, Hongshan District , Wuhan, China
TEL : 027-87638876
TEL : 027-87638876
FAX : 027-87204137

Liaoning

Shenyang
Suzhou new generation of CNC Equipment Co.,
Ltd. Wuhan Branch
ADD : 22-1, C61-, Diycheng, No. 1, 1Jia1, Qigong Street, Tiexi
District, Shenyang City, Liaoning Province
TEL : 18698806526
TEL : 18698806526



SYNTEC Technology Co., Ltd.

No.25, Yanfa 2nd Rd., East Dist., Hsinchu City 300,
Taiwan (R.O.C.)

☎ 886-3-6663553
☎ 886-3-6663505

Suzhou SYNTEC Equipment Co.,Ltd.

No. 9th, Chun Hui Road, Suzhou Industrial Park,
Jiangsu Province

☎ 86-512-69008860
☎ 86-512-65246029



<http://www.syntecclub.com.tw>

Catalog NO. 201811-v2



Developing powerful and efficient CNC systems has long been Syntec's mission. With fast innovating PC technology and our dedicated research in both hardware and software, we are able to provide the best total solution of control system in the machine tool industry. Performance-wise, our outstanding High-Speed High-Precision (HSHP) functions are perfect for mold or high speed milling purposes. Multi-axis & multi-program applications allow Mill-Turning Machines to easily execute complicated simultaneous multi-tool cutting interpolations. Abundant G/M codes and friendly user interface allows inexperienced operators to quickly catch on to the Syntec control. More over, our integration capability and flexibility are a great match for machine builder to develop unique application for specialized products at will. Syntec's professional and responsible engineer regiment provide solid and instant technical support; and our passionate service teams are able to help any customer globally. We leave you no worry to reach end users, and we are always standing by to deliver on-demand, unlimited backup.

Syntec will always be your best technical and service partner.

SIMPLICITY & CONVENIENCE

- Machining preparation, dry run function, clear and easy -to-use machining monitor.
- Complete operating support, and customized help screens.
- With graphic input interface, users can also edit programs easily even when they are not familiar with G code.
- Provide network and USB disk interface, the most complete PC interface for input and output.

HIGH EFFICIENCY

- High speed and high precision, with a maximum of 4000 blocks look-ahead.
- High speed drilling and tapping, high speed threading.
- Support up to control to meet demands of multi-program machining.
- Axis-coupling, axis-exchange, and virtual axis function to increase the flexibility of machine.
- Support functions of 5-Axis Simultaneous Machining and feature coordinate-function.



SYNTEC Turning Controller	01
SYNTEC Milling Controller	02
Turning Features	03
Milling Features	05
5-Axis Simultaneous Machining Features	06
High Speed, High Precision	07
Operation Interface	08
Open-architecture Tools Application	08
Pick and Place Integration Solutions	10
Vision System	11
CAD/CAM Features	12
Dual System Dipole Structure	12
Product Features Comparison Table	13

FEATURES

- Provide eHMI application for users to customize operation interface conveniently.
- Customized G/M code, dedicated machine can be used easily.
- Provide dipole architecture, users can integrate the customized software onPC.
- Provide optional vision system or pick-and-place equipments for highly automated integration solutions.

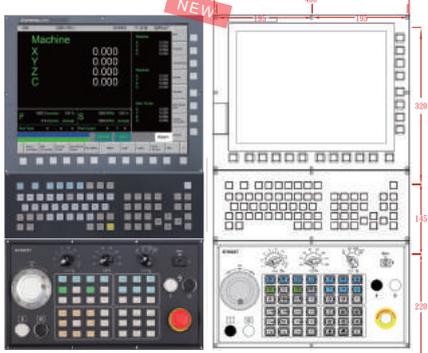
Application

- Standard Machine: Lathe, milling machining center, engraving and milling machine, mill-turn machine.
- Dedicated machine: Tapping center, glass cutting machine, cutter grinding machine, PCB molding machine, spring machine, laser processing machine, flame cutting machine, stone processing machine...ect.

SYNTEC Lathe Controller

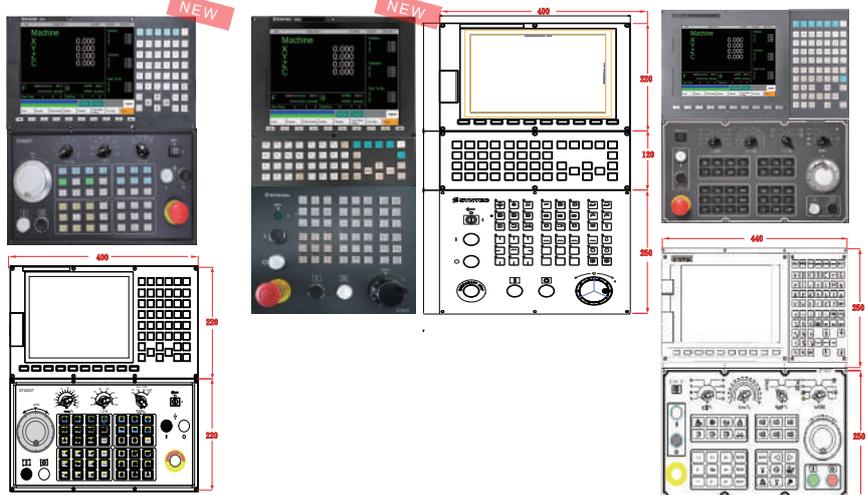
Mono block controller features high standardization, low wiring costs and low floor area. Significantly reduces wiring costs and space requirements, therefore improved CP value. Combined with the latest M2/M3 embedded technology of Ethernet-based serial communication methods, customers are provided with better servo control functionalities and more comprehensive integration of electric machinery.

15 inches



Keyboard: VK15
Panel: ST4022T

10 inches

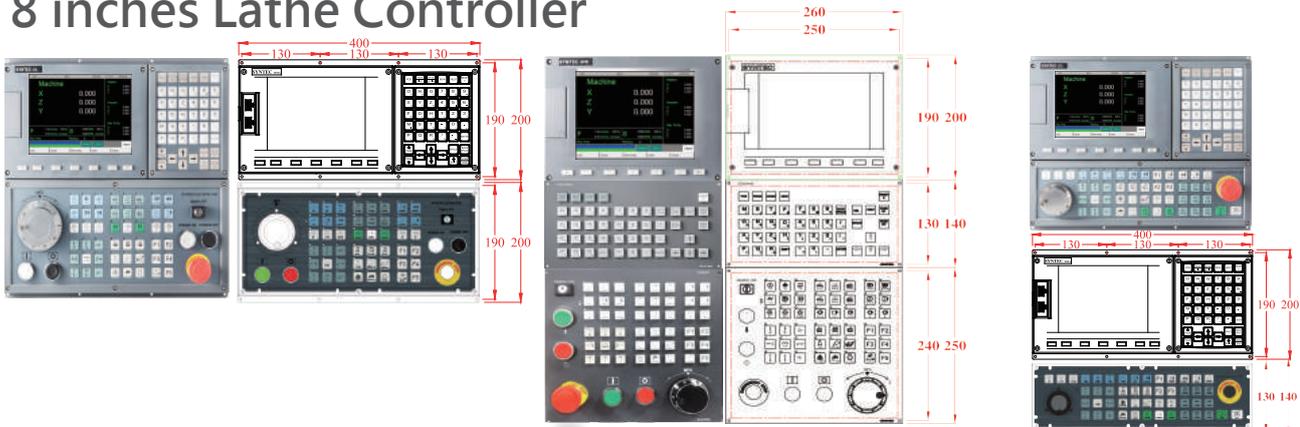


Panel: ST4022T

Keyboard: VK10
Panel: 3025T

Keyboard: HK
Panel: 4425T2

8 inches Lathe Controller



Panel: 4018T3

Keyboard: VK8
Panel: 2625T

Panel: 4012T2

Controller type	Standard			General Mill-Turn								Multi - Axis Group Mill-Turn						
	6TA	6TB	6TA-E	11TA**	21TA	21TA-E	21TB	21TB-E	22TA	22TB	11TB	200TB-5	210TB-H	210TB-HS	220TB	220TB-5		
Axis no.	3	4	3(4)	4				6(8)		4	6(8)	8	12(16)	12(16)		12(16)		
DA	2			2						-		2	1	2		-		
Max I/O	32/32			32/32	96/96				128/128		128/128	96/96	96/96		128/128			
Display	8"			10.4"	8"/10.4"				8"/10.4"/15"		10.4"	8"/10.4"	8"/10.4"/ rear half		10.4"/15"			
Servo	General Purpose		M3/ECAT/RTEX	General Purpose	M2	M3/ECAT/RTEX	M2	M3/ECAT/RTEX	M3/ECAT/RTEX		General impulse	M2	M2/M3/ECAT/RTEX		M3/ECAT/RTEX			
VGA	-			-								-		0	0*		-	
Connection	Ethernet RS485		Ethernet RS485 SRI	Ethernet RS485					Ethernet RS485 SRI		Ethernet RS485	Ethernet RS232 RS422 RS485	Ethernet RS485 SRI		Ethernet RS485 SRI			
Multi-Program No.	1		1	2				2		2	2	4	4	4	4	4		
Memory	256MB		512MB	512MB				4GB		512MB	256MB	4GB	4GB	4GB	4GB	4GB		
Inclined Plane process	-			-								-		△	-	△	-	△
HPCC	-			-								-		△	-	△	-	△

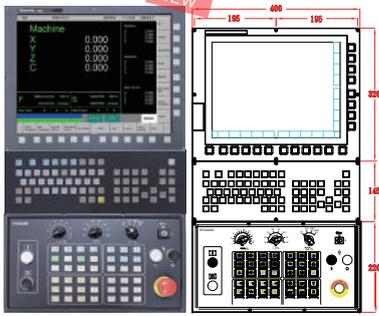
*VGA is only provided for the rear half

Marking: "o" denotes standard function; "△" denotes optional function; "-" denotes none.

SYNTEC Milling Controller

Controllers use the latest embedded technology to give high efficiency, stability and reliability. Communication supports M2, M3 Ethernet-based serial communication that reduces noise interference and further provides better control synchronization of multi-axis as well as scalability for integration with electric machinery.

15 inches

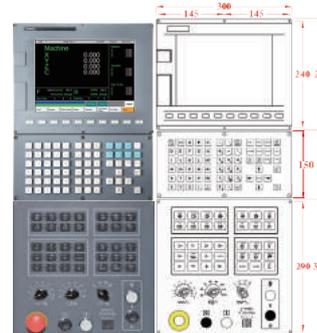


Keyboard: VK15
Panel: ST4022M

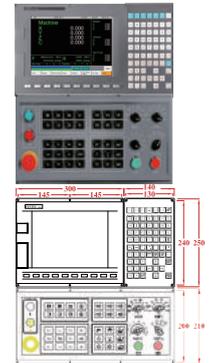
10 inches



Keyboard: VK10
Panel: 3030M5

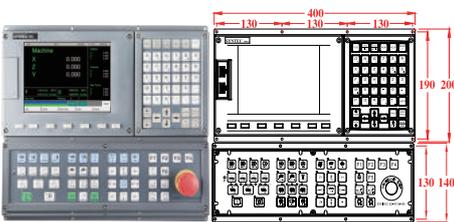


Keyboard: VK
Panel: 3030M3



Keyboard: HK
Panel: 4421M2

8 inches



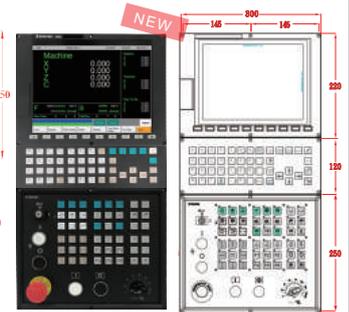
Panel: 4012M



Panel: ST4022M



Panel: SK6M



Keyboard: VK10
Panel: 3025M

Controller type	Standard				Multi-Function Milling				Composite Milling				Five-Axis							
	6MA	6MB	6MA-E	6MB-E	11MA	11MB	21MA	21MA-E	22MA	210MA-H	210MB-H	220MA	220MB	200MA-5	200MB-5	210MA-H5	210MB-H5	220MA-5	220MB-5	
Axis no.	3	4	3	4(5)	4	8	6	6	6	8(9)	12(16)	8(9)	12(16)	8(9)	12(16)	8(9)	12(16)	8(9)	12(16)	
DA	2				2				-	2		-		1		2		-		
Max I/O	32/32				32/32	128/128	96/96	96/96	128/128	96/96		128/128(RIO-M3 IO-SRI)		96/96		96/96		128/128(RIO M3 IO SRI)		
Display	8				10.4/rear half		8/10.4/12/15		8/10.4/15	8/10.4/15		10.4/15		10.4/15		10.4		10.4/15		
Servo	General Purpose		M3/ECAT/RTEX		General Purpose		M2	M3/ECAT/RTEX		M3/ECAT/RTEX		M2/M3/ECAT/RTEX		M3/ECAT/RTEX		M2		M2/M3/ECAT/RTEX		
VGA	-				-				-	O*		-		O		O*		-		
Connection	Ethernet RS485				Ethernet RS485				Ethernet RS485 SRI	Ethernet RS485 SRI	Ethernet RS485 SRI		Ethernet RS485 SRI		Ethernet RS232 RS422 RS485		Ethernet RS485 SRI		Ethernet RS485 SRI	
Mult-Program No.	2				2				2		4		4		4					
Memory	256MB		512MB		512MB				4GB		4GB		4GB		256MB					
RTCP	-				-				-	-	-	-	-	-	△		△		△	
Inclined Plane Process	-				-				△	△	-	-	-	-	△		△		△	
HPCC	-				-				O		O		O		O					

*VGA is only provided for the rear half

Marking: "o" denotes standard function; "△" denotes optional function; "-" denotes none.

Versatile panel layout

Dual USB



Ethernet, RS485



Variable control panel option



Product	6TA	6TB	6TA-E
Axis no.	3	4	3(4)
Spd no.	2	2	4
Multi-Program no.	2	2	1
DA no.	2	2	2
IO no.	32/32	32/32	32/32

- Lately developed hardware design for application of 2-4-axis lathes
- Enclosed design without CF card.
- Highly reliable motherboard.
- USB and network supported.
- Comprehensive lathe functionalities
- 6TA-E supports serial communication such as

Brand new hmi for agile operation and easy learning

Offers 6 series for versatile product selection and panel layout.

SYNTEC serial package solution

Controller servo integration screen

SYNTEC 22TA/B serial lathe controller



/ Drive auto fine-tune function/



/ Axial and spindle load ratio monitoring/



MECHATROLINK



Yaskawa Axis motor



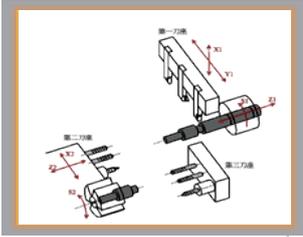
SYNTEC spindle package

Multi-Program Mill-Turn Solution



- 200, 210, 220 series
- Up to 4 axis groups controlled
- Simultaneous execution of 4 independent program paths

Dual-paths Mill-Turn Solution



- Dual-paths interface
- Dual-paths operation panel
- Support advanced functions for multi-program application, such as synchronized and non-synchronized axis-coupling, axis exchange, and ect.
- Synchronize motion in-between multi-program
- Synchronized spindles function

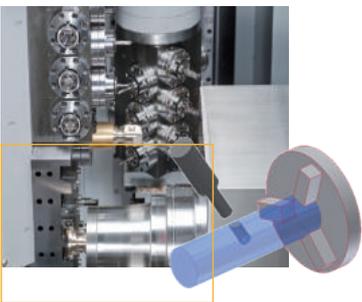
Turning function: Specific, Powerful, Practical



Extreme Speed Threading Mode

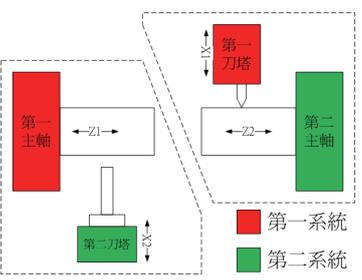
Overlapping technology improves tool retraction in threading cycle.

1000 Times Threading	General Threading
G21 Threading	36789(Sec)
G78 Threading	24685(Sec)



Tilted Plane Machining

Function of rotating coordinates simplifies the programming on the inclined surface. Milling, drilling, and tapping on the inclined plane can be implemented with NC program input manually, without complex CAD / CAM processing.



Axis-Exchange Feature

The turret of the first path can machining with the second spindle; and at the same time the first spindle occupies the second turret to machine. Reduces the number of machine tools, improves the flexibility and efficiency of machining.



Synchronized Tapping

Spindle has no need to decelerate or stop, the dynamic control of tapping-head allows spindle to remain rotating while tapping. This significantly reduces the tapping time.

SYNTEC milling machine serial controller



Powerful Controller with M3 Bus Protocol

SYNTEC serial controller supports yaskawa M2/M3 ethernet-base serial communication system, significantly increasing band width to 100mbps; max. Resolution up to 24bit, effectively improves smoothness of process.

High Speed, High Precision, High Quality

SYNTEC serial controller is capable of processing 2000 single segments and possesses versatile advanced high-speed high precision functions such as smooth precision advanced (SPA), high precision contour control (HPCC), process path smoothing, multi-group processing conditions (G120.0), quick parameter setting, quick threading tool retraction, multi-spindle synchronous threading, which is the optimal choice for high efficiency and high precision in the milling machine industry.

Flexible & Competitive Solution

SYNTEC serial controller is capable of controlling 4-16 CNC axes if required; supporting ROT servo elements; exclusion of tool magazine motor from total axes facilitates higher flexibility in axes combination. In addition to general interface and da interface, the spindle may also be combined with SYNTEC serial communication spindle package for higher definition and better processing performance. Capable of external connection with SYNTEC communication IO modules via SRI interface for free allocation of IO contacts based on actual needs.

Machining Serial Bus Solution

Machining Serial Bus Solution



High Performance & Better Configuration

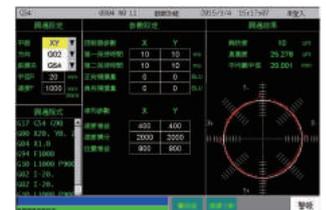
Syntec latest Milling machine serial bus solution

- 22MA milling machine controller
- High definition drive
- Axial optical ruler (option)
- SYNTEC HD spindle electric machinery package
- SYNTEC DD fourth axis, fifth axis
- Central water outlet spindle electric machinery (option)
- High-speed spindle positioning
- High-speed rigid threading
- High-speed high precision (HPCC) function

Highly integrated configuration and diagnostic



/ Axis and spindle setting /



/ Serial bus oscilloscope /

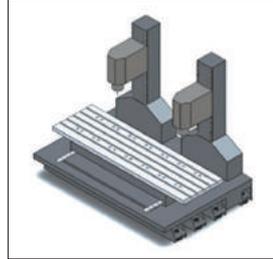
Mill Function

攻牙快速退刀

退刀百分比	100%	150%	200%	300%
百孔時間	310	273	255	240
節省百分比	-	11.94%	17.74%	22.58%

- 攻牙退刀速度可參數設定，最高可達300%
- 同時支援鐘型加減速，兼顧速度及機台平穩性

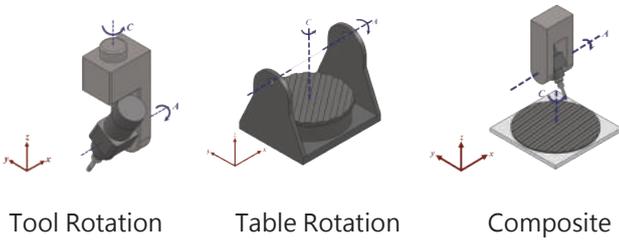
多主軸攻牙



- 提供單機多主軸方案，對應相同程式，達到單機多產的效果
- 可根據加工條件不同，彈性選擇加工主軸
- 支援多主軸攻牙，提高生產效率
- 最高可支援至6主軸

Five-Axis Control Function(Optional Feature for Special Controller)

Support Various Types of Five-Axis Compensation



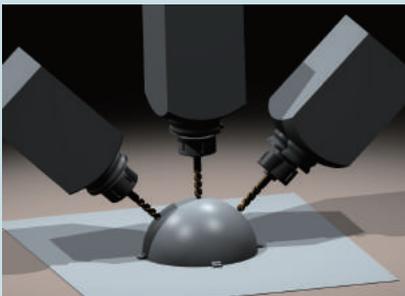
Tilt Working Plane Machining

For oblique cutting tool or rotating worktable provides correction function to define the tilt machining plane conveniently .



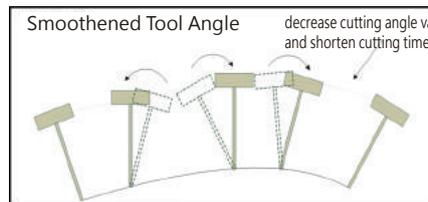
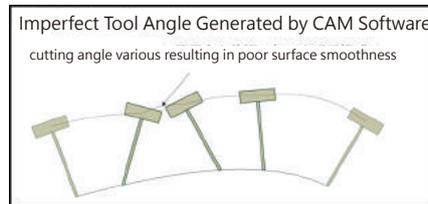
Rotation Tool Center Point Feature (RTCP)

Support 3D tool length compensation feature, user only needs to program product in CAM program, controller will automatically implement tool length and wear, and the tool tip will always on the perpendicular against product contour.



Smooth RTCP Feature (SMTCP)

特定機型可選配



5 Axis SMTCP will overcome the defects of path generated by CAM software, especially for side blade machining.

High Efficiency Machining

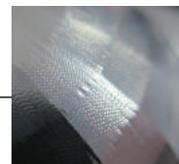
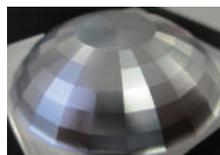
High-Speed, High-Precision Machining (HSHP)



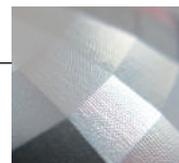
The WinCE system can process 1000 blocks and look-ahead 2000 blocks each second. These enable smooth motion and enhance surface quality. In order to advance the precision, HSHP function also controls the corner and arc feedrate

Smooth Precision Advanced (SPA)

High-Speed Machining



SPA OFF



SPA ON

Due to limitation of machine condition, servo mismatch can be found even the servo loop gain has been optimized. This error causes dimensional shrinkage especially in high-speed machining. SPA

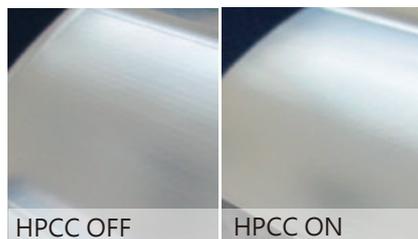
Path Smoothing Feature



Enhance the brightness of the surface and reflect obviously

By trimming the rough program path generated by CAD/CAM software with a tolerance, the desired smooth and fine path is estimated by Path Smoothing function. This improves the surface finish, machining efficiency and stability of machine tool.

High Precision Contour Control (HPCC)



HPCC OFF

HPCC ON

The tool path generated by CAD/CAM software is generally discontinuous, and it causes negative effects on machining operations. The problems will be more serious because of larger CAD/CAM tolerance. HPCC function fits the discontinuous blocks into a smooth-curve path, and this will enhance the machining precision and reduce the mechanical shock.

Simplified HSHP Parameter



User may choose [Precision level<---> Speed level], [Original path<--->Smoothing path level], and SPA features to control machining result

Direct Numerical Control Feature (DNC)

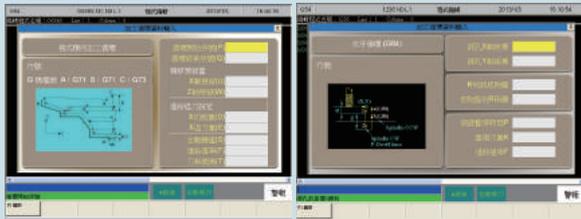


Loading and running the programs from external devices(USB disk, Ethernet) directly, which saves the disk space and the time for transferring huge programs.

User Friendly Operation Interface

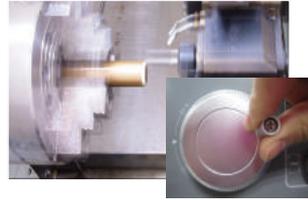
Users can get started easily and immediately operate it right for the first time.

Graphic Conversational Input

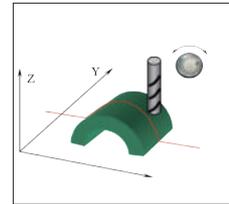


Provide various graphic conversational input in program editing menu. Customized graphic conversational input is also available.

MPG Simulation



Lathe



Mill

In the dry run process, users can decide the cutting speed and direction with moving MPG forward or backward.

Permission Management Feature



Provides machine maker or operation manager permission management feature, different permission allowed according to different level

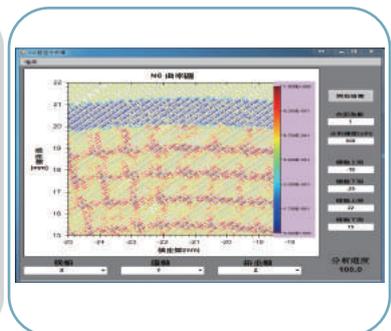
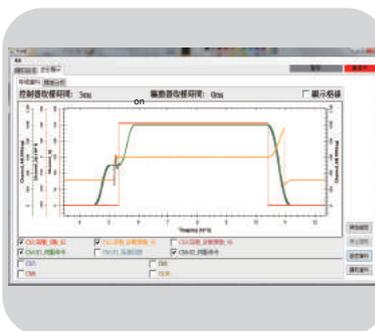
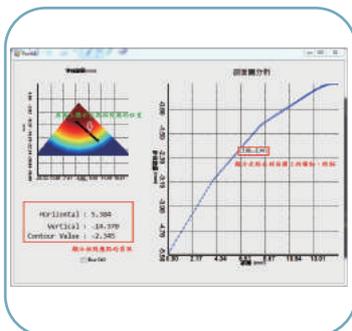
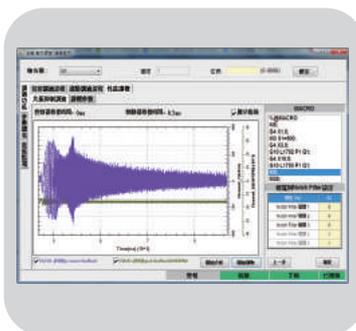
My Favorites



New F6/F7/F8 [My Favorites] function key allow user or machine maker to set their favorite interface shortcut and access designated interface faster.

M&E integration analysis platform

SYNTEC provides analysis software to assist electrical control personnel adjusting servo gain promptly; also provides analytic tools capable of graphitizing NC commands and feedbacks, enabling electrical control personnel quick identification of any root cause.



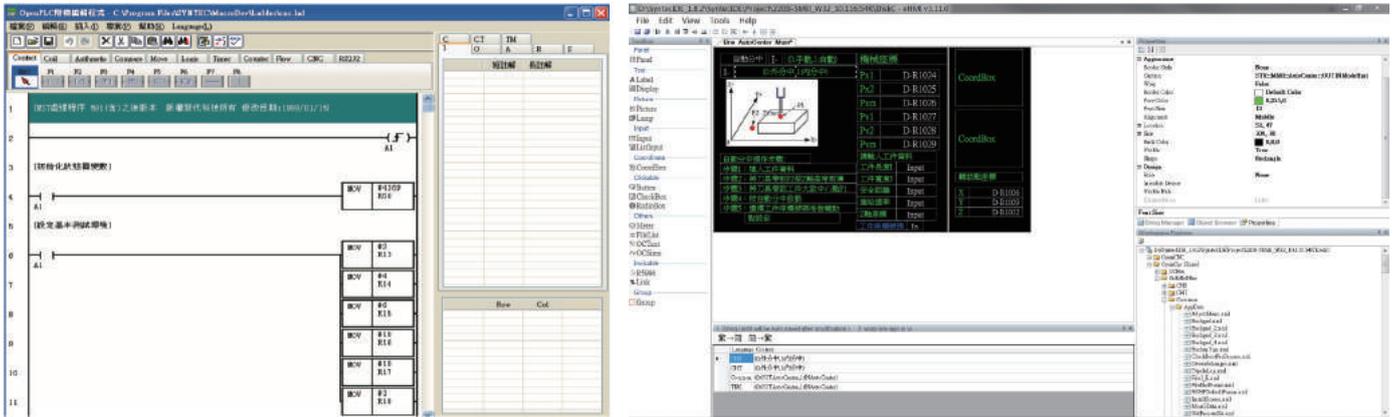
Comprehensive servo adaptation function

neighboring channel analysis

PLC interface sequential analysis

3D curvature analysis

Introduction - Open Platform, Easy to Learn and Easy to Use Environment



PLC edit tool supports open file, save, notes, long remark, cut, paste, copy and syntax check.

Easy to understand EHMI development tool, edits the screen just by dragging elements, effectively shortens time of project development.

Master controller integrated measuring function

Jointly developed with Renishaw, an on-line measuring HMI.



Measuring function portal



Inspection plus work



AXISET 5-axis error measurement



NC4 tool measuring

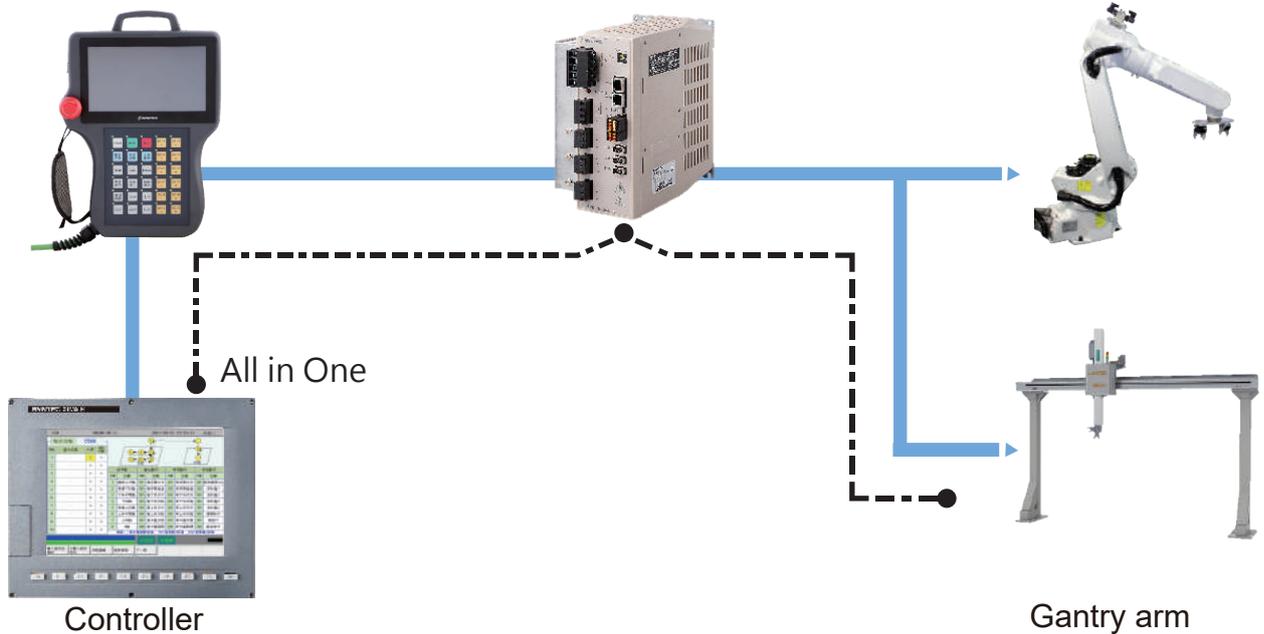
- Jointly developed with renishaw, including:
 - Probe work measuring (Inspection plus)
 - Contact tool measuring (RTS)
 - Non-contact tool measuring (NC4)
 - Five-axis mechanism error measurement solution (AXISSET)
- Calibration and measurements are accomplished via dialogic proprietary measuring HMI for easy operation and time and effort saving.

Syntec Robotics Pick and Place Solutions

81R Handheld controller

All-in-one drivers

Robot arm



- Highly integration between controller and robotic arm to minimize the automation barriers
- All in One: By using multi-axis structure to control truss arm and to meet the demands of pick and place
- Available for secondary development to modify for own specialties

Features of Robotic Arms

81R supports various types of arms



- Supports various types of arms (SCARA、six-axis arm、DELTA、4-axis robot...)
- Synchronize movement and end point linear motion control

81R & All in One teaching features



- Make it easier with conversational teaching
- Special material plate setup and module
- Reduce the teaching time by setting up reference point

Vision Alignment System

Combined with vision system, the offset and rotation information of work piece can be obtained and compensated by control. In this way, the machining accuracy can be significantly improved

Our vision system provides simple and intuitive manipulation and teaching interface, supports up to 4 CCDs, and is very convenient for users'setting.



Syntec WinCE Controller

Ethernet

Ethernet

RS-232

Rear platform: vision system computation
SYNTEC exclusive vision solution



- **Easy to Operate**
All operations can be reached on the controller, another monitor or control box is unnecessary.
- **Easy to Use**
Provide standard alignment macro for general application. For different size of work piece, users only need to modify parameters.
- **Easy to Set Up**
Provide waterproof box. All the vision accessories are calibrated and set up inside. Users only need to install the waterproof box.
- **Easy to Customize**
Through eHMI, users can easily modify the browser layout.
- **High Openness**
Modify macro to reach different needs.
- **High Compatibility**
Support Cognex, Keyence, and Omron visual system.

Syntec Vision Package

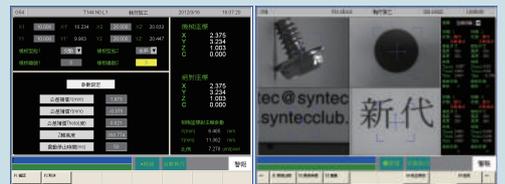
Feature	A type Economical,dedicated	B type All with fixed distance	C type All with different distance
Appliance	Glass Metal mark	Glass: rarely Other: OK	All
Camera	1.3 megapixel CCD  USB Interface DMK-72AUC02  GigE:DMK-23K445		
Lens	Telecentric Lens (coaxial) 	Telecentric Lens 	CCTV Lens 
Lighting	Spot Light 	Direct Ring Light 	Coaxial Light 
Dimmer LED-Power	1CH Analog Dimmer 	1CH Analog Dimmer 	1CH Analog Dimmer 
Resolution	≈ 5um/pixel	≈ 5um/pixel	≈ 5-50um/pixel
Field of View-FOV	≈ 4.8mm*6.4mm	≈ 4.8mm*6.4mm	≈ 5mm*7mm ~50mm*70mm
Working Distance	110mm	110mm	110mm-500mm

Identify Targets



- Cross mark
- Circular mark
- Arbitrary pattern
- Line
- L-mark
- Intersection

Standard Visual Pages



- Includes parameter setting
- Multiple camera display

2D DXF Import and CAD/CAM Solution

CAD/CAM Platform

Loading AutoCAD DXF File

SYNTEC provides the function of loading DXF files, the complex graphic can also be loaded.

Editing the Image File Loading from AutoCAD

Providing the editing function after loading DXF files, users can delete or add the line segment in DXF files.

CAM Path Optimization Function

Providing the capability to optimize the machining path in the DXF file, complex segments of DXF can be automatically determined and arranged to create the smooth machining path.

Function of Setting CAM Machining Program

Users can edit their own machining processes; do not need to follow these steps: the tool feeding → the machining path → the tool relieving... converting to NC files.

Function of Setting Relieving Point in CAM

Allowing users to choose feeding points accordingly

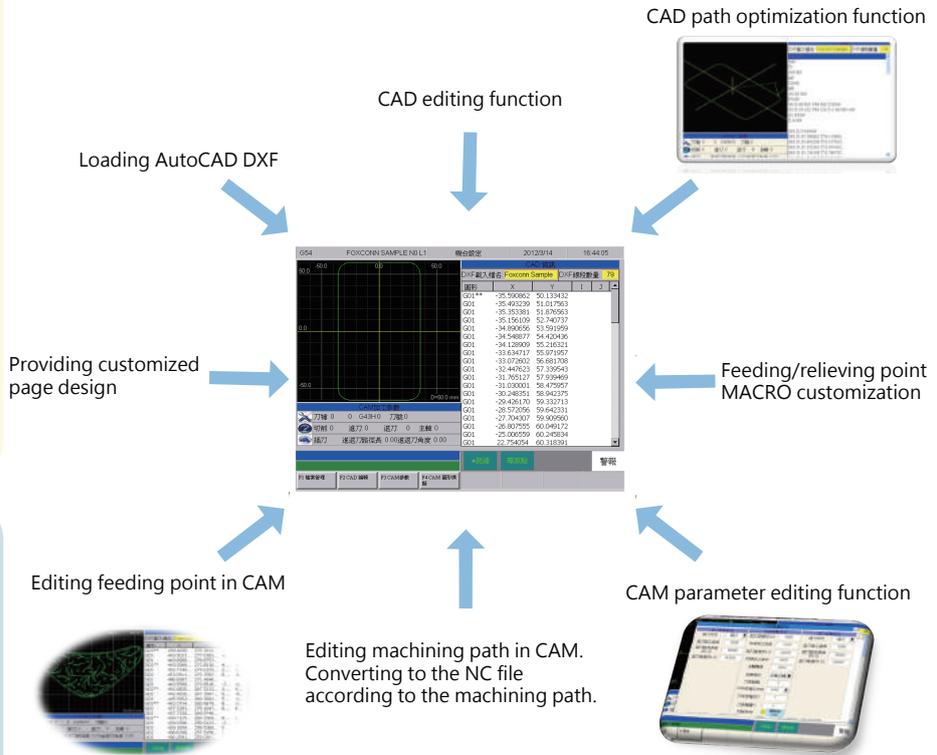
Open Development Platform

Function of Editing CAM Parameter

SYNTEC provides customers with CAM parameters page to self-define or self-customize dedicated customized surface.

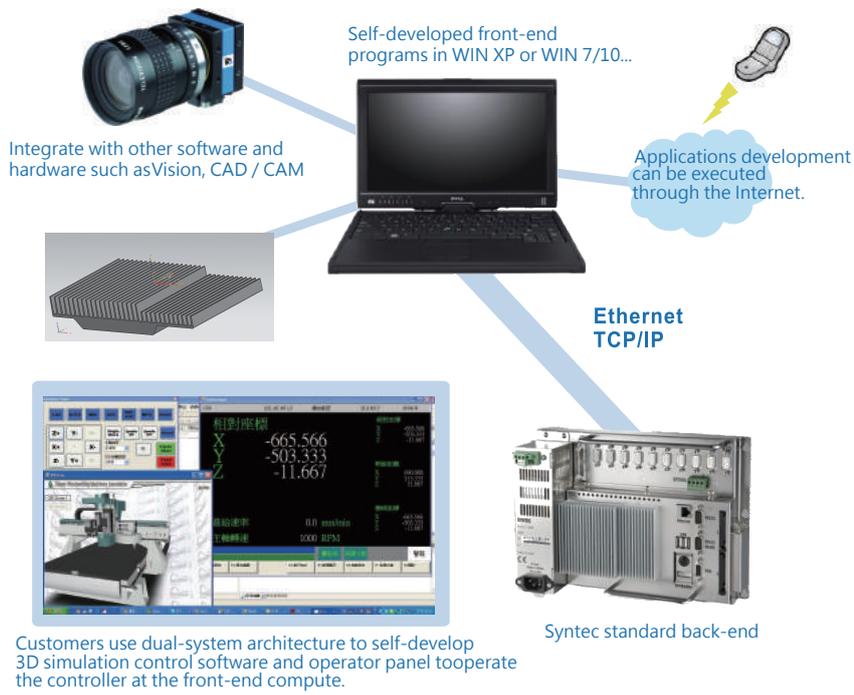
MACRO Program to Set Tool Feeding/Relieving In CAM

SYNTEC provides customers with CAM parameters page to self-define or self-customize dedicated customized surface.



Dual System Dipole Structure

SYNTEC provides dual-system architecture with expectation that users can benefit from PC-Based CNC. Dual-system architecture provides connection between front-end computer and back-end CNC by cable. Front-end computer can process various applications such as Vision, CAD/CAM and other high level software applications, allowing customers to integrate hardware and software resources.



SYNTEC provides standard API to facilitate customers to develop front-end application programs. Front-end computer can use Win xp or Win7 and other platforms, easy to integrate with other Front-end computer develops relatively fast in order to PC, and all human-machine interface is executed in the front-end computer, does not affect the back-end CNC's performance. SYNTEC provides standard platform ensuring real-time quality at the back-end.

Dedicated Lathe Functions

				General purpose				Serial												
				6 series		11 series		6 series	21 series				22 series	200 series	210 series		220 series			
Category	Item	Unit	Remark	TA	TB	TA**	TB	TA-E	TA	TA-E	TB	TB-E	TA	TB	TB-5	TB-H	TB-H5	TB	TB-5	
Product spec	Max. Axes group in system	Axes group		1	2	2		1	2				2		4	4		4		
	Max. PLC axes group	Axes group		—	1	1		—	1				1		3	3		3		
	Standard controlled axes (standard)	Axis		3	4	4	8	3	4	6				4	6	12	12	12	12	12
	Max. controlled axes (option)	Axis		3	4	4	8	4	4	8				4	8	16	16	16	16	16
	Max. Number of spindles	Axis		2		2		6	1	2				4	6	6		6		
	Max. Axes in synchronous control (single axes group)	Axis		3	4	4	4	3	4	4				4	4	5	4	5	4	5
	Min. Control unit-mm			0.0001		0.0001		0.0001	0.0001				0.0001	0.0001	0.0001		0.0001			
	Max. Number of work coordinates system	Set		32		100		100	100	100				100	100	100		100		
	Max. Groups of tool compensation	Set		96		96		32	96	96				96	96	96		96		
	Number of multi-channel function groups	Set		4		4		4	4	4				4	4	4		4		
	Number of pre-read segments			64		1000		1000	1000	1000				1000	2000	2000		2000		
Segment process time			300		1000		300	1000	1000				1000	4000	1000	4000	1000	4000		
Hardware spec	Storage DISKA	MB		256		512		512	512				4096	256	4096		4096			
	I/O standard	Point		32/32		32/32		64/64	32/32	32/32				32/32	32/32	32/32		32/32		
	I/O optional	Point		None		None		128/128	—	96/96				96/96	128/128	96/96		128/128		
	DA	Set		2		2		2	2				2	—	2		2			
	Display	Inch		8		10.4		8	8/10.4	8/10.4				8/10.4/15	8/10.4	8/10.4/rear half***		10.4/15		
	CF card	Set	Frontal port	—		—		—	—				—	—	—		—			
	USB	Set		2		2		2	2				2	1	2		2			
	RJ-45	Set		1		1		1	1				2	2	1		2			
	VGA output	Set	Rear port	—		—		—	—				—	1	1***		—			
	PS/2	Set		—		—		—	—				—	1	—		—			
	RS-232	Set		—		—		—	—				—	1	—		—			
	RS-422	Set		—		—		—	—				—	1	—		—			
	RS-485	Set		1		1		1	1				1	—	1		1			
USB	Set	—		—		—	—				2	2	—		2					
SRI	Set	—		—		1	—	1	—				1	—	1		1			
Servo control	General purpose (A/B phase)			0		0		—	—				—	—	—		—			
	General purpose (CW/CCW)			0		0		—	—				—	—	—		—			
	Mechatrolink II			—		—		—	0	—				0	0	0		0		
	Mechatrolink III			—		—		0	—	0	—				0	—	0		0	
	EtherCAT			—		—		0	—	0	—				0	—	0		0	
RTEX			—		—		0	—	0	—				0	—	0		0		
Compensation	Back gap compensation			0		0		0	0				0	0	0		0			
	Pitch error compensation			0		0		0	0				0	0	0		0			
	Spike compensation			0		0		0	0				0	0	0		0			
	Temp. Rise compensation			0		0		0	0				0	0	0		0			
	2D compensation			0		0		0	0				0	0	0		0			
	Operation	Handwheel simulation			0		0		0	0				0	0	0		0		
Program empty run				0		0		0	0				0	0	0		0			
Selective stop				0		0		0	0				0	0	0		0			
Segment execution				0		0		0	0				0	0	0		0			
Virtual handwheel				0		0		0	0				0	0	0		0			
Pause point start				0		0		0	0				0	0	0		0			
Tool interrupt point start				0		0		0	0				0	0	0		0			
Tool retract				—		—		—	—				—	—	—		—			
Offset setting				0		0		0	0				0	0	0		0			
Handwheel offset function			—		—		—	—				—	—	—		—				
Program input	Selective jump			0		0		0	0				0	0	0		0			
	B-STOP/ program end			0		0		0	0				0	0	0		0			
	Absolute zero coordinates system		G92/G92.1	0		0		0	0				0	0	0		0			
	Interrupt MACRO		M96/M97	0		0		0	0				0	0	0		0			
	M 198 call subroutine			0		0		0	0				0	0	0		0			
G-code extension			0		0		0	0				0	0	0		0				
High speed high precision	Constant Jerk control			0		0		0	0				0	0	0		0			
	Cross-segment S-curve acceleration/ deceleration			0		0		0	0				0	0	0		0			
	Auto deceleration at corner			0		0		0	0				0	0	0		0			
	Corner radius speed limit			0		0		0	0				0	0	0		0			
	Multiple high speed high precision parameter set			—		—		—	—				—	—	—		—			
	User quick parameter			—		—		—	—				—	—	—		—			
	SPA function			—		—		—	—				—	—	—		—			
	Virtual circle radius function			0		0		0	0				0	0	0		0			
	High speed high precision control mode i		G05.1Q1	—		—		—	—				—	—	—		—			
High speed high precision control mode ii		G05P1000 0	—		—		—	—				—	—	—		—				
NURBS interpolation function			—		—		—	—				—	—	—		—				

Tool management	Auto tool align screen		—	—	—	—	—	—	—	—	—
	Auto work measurement	Renishaw h/w required	0	0	0	0	0	0	0	0	0
	Tool lifespan management	Only the screen; function requires customization	0	0	0	0	0	0	0	0	0
Auxiliary function	Mechanical lock (R-Bit)		0	0	0	0	0	0	0	0	0
	Software travel limit		0	0	0	0	0	0	0	0	0
	Spindle speed detection		0	0	0	0	0	0	0	0	0
	Axial coupling function		0	0	0	0	0	0	0	0	0
	Axial dynamic coupling function		0	0	0	0	0	0	0	0	0
	Feedback coupling function		0	0	0	0	0	0	0	0	0
	Threading quick tool retract		0	0	0	0	0	0	0	0	0
	Virtual axis function		0	0	0	0	0	0	0	0	0
	Axle exchange function		0	0	0	0	0	0	0	0	0
	Axial torque control		—	—	0	0	0	0	0	0	0
	Serial adjustment function (CNC axis)		—	—	0	0	0	0	0	0	0
	Driver data display (CNC axis)		—	—	0	0	0	0	0	0	0
	Spindle adaptation function (CNC axis)		—	—	0	0	0	0	0	0	0
	Serial PLC axis		—	—	0	0	0	0	0	0	0
	High speed spindle positioning	SYNTEC spindle required	—	—	0	0	0	0	0	0	0
	ROT element		—	—	0	0	0	0	0	0	0
	Dipole foreground/ background configuration		—	0	—	0	0	0	0	0	0
	Data backup and recover	Maker backup	0	0	0	0	0	0	0	0	0
	Start-up screen customization		0	0	0	0	0	0	0	0	0
	My favorite	Only support ARM 8-key system	—	0	0	0	0	0	—	0	0
Project protection function		0	0	0	0	0	0	0	0	0	
Access management		0	0	0	0	0	0	0	0	0	
Remote AP monitoring		0	0	0	0	0	0	0	0	0	
Programming	Background edit		0	0	0	0	0	0	0	0	0
	Edit protection		0	0	0	0	0	0	0	0	0
	Real time syntax check of processing program		0	0	0	0	0	0	0	0	0
	PLC diagnosis function (FORCE I-point)		—	0	0	0	0	0	0	0	0
DATA TRANSFER FUNCTION	NETWORK		0	0	0	0	0	0	0	0	0
	FTP		0	0	0	0	0	0	0	0	0
	RS-485		0	0	0	0	0	0	0	0	0
	DNC(Network)		0	0	0	0	0	0	0	0	0
	DNC(USB)		0	0	0	0	0	0	0	0	0
Data display	Operation history display		0	0	0	0	0	0	0	0	0
	Graphic simulation		0	0	0	0	0	0	0	0	0
	Partial graphic simulation		0	0	0	0	0	0	0	0	0
	Dynamic multi-language switch-over		—	0	0	0	0	0	0	0	0
G-code	Oval cutting (clockwise)	G02.1	0	0	0	0	0	0	0	0	0
	Parabolic cutting (clockwise)	G02.2	0	0	0	0	0	0	0	0	0
	Cylinder interpolation	G07.1	0	0	0	0	0	0	0	0	0
	Start-up polar coordinates	G12.1	0	0	0	0	0	0	0	0	0
	OD/ID turning cycle	G20	0	0	0	0	0	0	0	0	0
	Threading cycle	G21	0	0	0	0	0	0	0	0	0
	Intermediate threading feed cycle	G21.2	0	0	0	0	0	0	0	0	0
	End face turning cycle	G24	0	0	0	0	0	0	0	0	0
	Jump function	G31	0	0	0	0	0	0	0	0	0
	Treading	G33	0	0	0	0	0	0	0	0	0
	Variable pitch threading	G34	0	0	0	0	0	0	0	0	0
	Polygon turning	G51.2	0	0	0	0	0	0	0	0	0
	Work coordinates system setting	G54~g59.9	0	0	0	0	0	0	0	0	0
	Mirror function (lathe)	G68	0	0	0	0	0	0	0	0	0
	Complex turning cycle	G72~g78	0	0	0	0	0	0	0	0	0
	Fixing cycle for drilling	G80 , g83-g89	0	0	0	0	0	0	0	0	0
	Absolute zero coordinates system preset	G92.1	0	0	0	0	0	0	0	0	0
	Inverse time feed	G93	—	—	—	—	—	—	—	—	—
	Constant surface cutting speed	G96	0	0	0	0	0	0	0	0	0
	Spindle synchronization function	G114.1	—	—	0	—	0	0	0	0	0
Spindle load function	G114.3	—	—	0	—	0	0	0	0	0	

Remark * Only sell in Mainland China
 ** Only sell in Taiwan
 *** VGA is only provided in the rear half
 **** 210TB-H5 is only 10.4" .
 O: standard function,
 △: optional function,
 -: Not available function

Dedicated Milling Functions

				Pulse Train						Serial BUS									
				6 Series		10 Series		11 Series		6 Series		21 Series		200 Series					
	Items	Units	Remark	MA	MB	MF	MA	MB	MD	MD-H*	MA	MA-H*	MA	MA-5	MB	MB-5			
Product Specification	Max. PLC Controlled Paths			2		4		2		2		2		4					
	Max. PLC Controlled Paths			1		3		1		1		1		3					
	Standard Axis	Axis		3	4	8	4	8	4	6	8		12						
	Max. Axis (Optional)	Axis		3	4	8	4	8	5	6	9		16						
	Max. Spindle	Axis		1	2	6	2	4	2	4	6								
	Max. Simultaneous Axis Control	Axis		3	4	4	4		4	4	4	5	4	5	4	5			
	Min. Control	mm		0.0001		0.0001		0.0001		0.0001		0.0001		0.0001					
	Max. number of program coordinate	Set		32		100		100		32		100		100					
	Max. Number of Table Tools	Set		96		96		96		96		96		96					
	Multi-Channel Function Group	Set		4		4		4		4		4		4					
Look-Ahead Blocks no.	Blocks/Sec		100		2000		1000		100		2000		2000						
Block Processing timT	Blocks/Sec		300		3000		2500		600		2500		3000	4000	3000	4000			
Hardware Specifications	Storage(DISKA)	MB		256		256		512		512		512		256					
	Standard I/O	-		32/32		64/64		32/32		64/64		32/32		32/32					
	Optional I/O	-		-		128/128		-		128/128		-		96/96		96/96			
	DA	Set		2		1		2		2		2		1					
	Monitor	Inch		8		10.4		10.4		8		8/10.4/12/15		10.4/15					
	CF Card	Set	Front side	-		1		-		-		-		1					
	USB	Set		2		1		2		2		2		1					
	CF Card	Set	Back side	0		2		0		0		0		2					
	RJ-45	Set		1		2		1		1		1		2					
	VGA Output	Set		0		1		0		0		0		1					
	PS/2	Set		0		1		0		0		0		1					
	RS-232	Set		0		1		0		0		0		1					
	RS-422	Set		0		1		0		0		0		1					
	RS-485	Set		1		1		1		1		1		1					
USB	Set	0		2		0		0		0		2							
SRI	Set		-		-		-		-	1	-	1	-						
Servo Control	Pulse Train (A/B Phase)			0		0		0		-		-		-					
	Pulse Train (CW/CCW)			0		0		0		-		-		-					
	Mechatrolink II(Yaskawa serial bus)			-		-		-		0		0		0					
	Mechatrolink III(Yaskawa serial bus)			-		-		-		-	0	-	0	-					
Compensation	Backlash Compensation			0		0		0		0		0		0					
	Pitch Error Compensation			0		0		0		0		0		0					
	Angular Error Compensation			0		0		0		0		0		0					
	Temperature Error Compensation			0		0		0		0		0		0					
	2 Dimension Error Compensation			-		0		0		-		0		0					
Operation	MPG Simulation			0		0		0		0		0		0					
	Dry Run			0		0		0		0		0		0					
	Optional Stop			0		0		0		0		0		0					
	Single Block			0		0		0		0		0		0					
	Virtual MPG			0		0		0		0		0		0					
	Restart at Feedhold			0		0		0		0		0		0					
	Restart at Break Point			0		0		0		0		0		0					
	Tool Return			0		0		0		0		0		0					
Fixture Offsets			0		0		0		0		0		0						
MPG Offsets			0		0		0		0		0		0						
Programming	Optional Skip	Skip blocks starting with"/"		0		0		0		0		0		0					
	B-Stop			0		0		0		0		0		0					
	Absolute Zero Point Coordinate	G92/G92.1		0		0		0		0		0		0					
	Interrupt Macro	M96/M97		0		-		-		0		0		0					
	M198 call Subroutines			0		-		-		0		0		0					
	Expandable G Code			0		0		0		0		0		0					
HSHP	Constant Jerk Control			0		0		0		0		0		0					
	Multiblocks S-curve motion plan			-		0		0		-		0		0					
	Auto declaration in Corner			0		0		0		0		0		0					
	Speed Limit for Round Radius			0		0		0		0		0		0					
	Multiple Sets of HSHP Parameters			-		0		0		-		0		0					
	Quick Parameter Setup			-		0		0		-		0		0					
	SPA Feature			0		0		0		0		0		0					
	Virtual Radius Function (for Rotary Axis)			-		0		-		0		0		0					
	HSHP Control Mode I (G05.1 Q1)	G05.1 Q1		-		0		0		-		0		0					
HSHP Control Mode II (G05P10000)	G05P10000		-		Δ		0		-		0		Δ						
NURBS Interpolation Ability			-		Δ		0		-		0		Δ						

				General Purpose					Serial BUS								
				6 Series		10 Series	11 Series		6 Series		21 Series		200 Series				
	Items	Units	Remark	MA	MB	MF	MA	MB	MD	MD-H*	MA	MA-H*	MA	MA-5	MB	MB-5	
Tool Management	Auto Tool Setting			0	0	0			0	0							
	Auto Tool Management		Works with Renishaw hardware only	0	0	0			0	0							
	Tool Life Management		Function needs to be customized	0	0	0			0	0							
Accessibility	Machine Lock (R bit)			0	0	0			0	0							
	Software Limit			0	0	0			0	0							
	Spindle Speed Arrival Check			0	0	0			0	0							
	Axis Synchronize Feature			0	0	0			0	0							
	Dynamic Axis Synchronize Feature			0	0	0			0	0							
	Dynamic Axis Synchronize Feature			0	0	0			0	0							
	Rapid Retraction for Rigid Tapping			0	0	0			0	0							
	Virtual Axis Feature			0	0	0			0	0							
	Axis Change Feature			0	0	0			0	0							
	Axial Torque Limit			-	-	-			0	0							
	Serial Bus Setting Feature(CNC Axis)			-	-	-			0	0							
	Driver Information Display(CNC Axis)			-	-	-			0	0							
	Spindle Application Feature(CNC Axis)			-	-	-			0	0							
	Serial Bus PLC Axis			-	-	-			0	0							
	ROT Element			-	-	-			0	0							
	Dipole Front and Back System			-	0	0			-	0							
	Data Backup Recovery		Maker Backup		0	0	0			0	0						
	Customized Opening Screen				0	0	0			0	0						
My Favorites		Only Eight key system supports		-	-	0			-	0							
Project Protection Feature				0	0	0			0	0							
Limit Access Manager				0	0	0			0	0							
Remote AP Monitor				0	0	0			0	0							
Program Edit	Background Edit			0	0	0			0	0							
	Edit Protection			0	0	0			0	0							
	Immediate Grammar Check			0	0	0			0	0							
PLC	PLC Diagnosis Feature(FORCE I Point)			-	0	0			0	0							
Data Transfer	Network			0	0	0			0	0							
	FTP			0	0	0			0	0							
	RS-485			0	0	0			0	0							
	DNC(NETWORK)			0	0	0			0	0							
	DNC(USB)			0	-	0			0	0							
Information Display	Operation CV Display			0	0	0			0	0							
	Graphic Simulation			0	0	0			0	0							
	Partial Graphic Simulation			0	0	-			0	0							
	Dynamic Multi-Language Switch			-	0	0			0	0							
Inclined Plane	Feature Coordinate(Inclined Plane Process)		G68.2,G68.3	-	Δ	-			-	Δ					Δ		
	Feature Coordinate Teach			-	Δ	-			-	Δ					Δ		
5 axis feature	5 Axis RTCP		G43.4	-	-	-			-	-			-	Δ	-	Δ	
	Smooth TCP			-	-	-			-	-			-	Δ	-	Δ	
G code command	High Precision Locus Control Mode		G05P10000	-	Δ	0			-	0					Δ		
	Smoothing Path Mode		G05.1	-	0	0			0	0					0		
	NURBS Interpolation		G06.2	-	Δ	0			-	0					Δ		
	Thread Cutting		G33	0	0	0			0	0					0		
	Auto Tool Measurement		G37	0	0	0			0	0					0		
	Tool of Offsets		G45~G48	0	0	0			0	0					0		
	High Speed Peck Drilling Cycle		G73	0	0	0			0	0					0		
	Left Handed Tapping		G74	0	0	0			0	0					0		
	High Precision Boring Cycle		G76	0	0	0			0	0					0		
	Drilling cycling		G81	0	0	0			0	0					0		
	Chopping		G81.1	-	0	0			-	0					0		
	Bottom Feed Hold Drilling Cycle		G82	0	0	0			0	0					0		
	Peck Drilling Cycle		G83	0	0	0			0	0					0		
	Tapping Cycle		G84	0	0	0			0	0					0		
	Boring Cycle		G85	0	0	0			0	0					0		
	High Speed Boring Cycle		G86	0	0	0			0	0					0		
	Back Boring Cycle		G87	0	0	0			0	0					0		
	Semi Automatic Finishing Boring Cycle		G88	0	0	0			0	0					0		
Bottom Feed Hold Boring Cycle		G89	0	0	0			0	0					0			
Multi-Group HSHP Parameter		G120.1		-	0	0			0	0				0			

Remark * Only sell in Mainland China O: standard function,
 ** Only sell in Taiwan Δ: optional function,
 *** VGA is only provided in the rear half -: Not available function
 **** 210TB-H5 is only 10.4" .