



HEIDENHAIN



TNC 128

The Compact Straight-Cut Control for Milling, Drilling and Boring Machines

**Information for the
Machine Tool Builder**

TNC straight cut control from HEIDENHAIN

General information

TNC 128

- Straight cut control for **milling, drilling and boring machines**
- Axes: 6 control loops, of which up to 2 are configurable as spindles
- Analog nominal-value interface to the drives ($\pm 10\text{ V}$)
- Compact design: Screen, keyboard and main computer all in one unit
- Dimensions: 400 mm x 450 mm x 91 mm
- Integral 12.1-inch TFT color flat-panel display
- Storage medium for NC programs: CompactFlash memory card
- Programming in HEIDENHAIN conversational format
- Standard milling, drilling and boring cycles
- Touch probe cycles
- Short block processing time



System test

Controls, motors and encoders from HEIDENHAIN are in most cases integrated as components in larger systems. In these cases, comprehensive tests of the complete system are required, irrespective of the specifications of the individual devices.

Expendable parts

In particular the following parts in controls from HEIDENHAIN are subject to wear:

- Buffer battery
- Fan

Standards

Standards (ISO, EN, etc.) apply only where explicitly stated in the catalog.

Note

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Validity

The features and specifications described here apply for the following control and NC software versions:

TNC 128 with NC software version

771841-05 (no export license required)

This brochure supersedes all previous editions, which thereby become invalid. **Subject to change without notice.**

Requirements

Some of these specifications require particular machine configurations. Please note also that, for some functions, a special PLC program must be created by the manufacturer.

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Please refer to the **page references** in the **tables** with the specifications.

Overview tables

Overview of TNC 128 components

Control system	TNC 128	Page
Main computer	MC 128	12
Memory medium	CFR CompactFlash memory card	12
NC software license	On SIK component	13
Screen	12.1-inch color flat-panel display (integrated)	
Operating panel	Integrated	
Machine operating panel	Integrated	14
Encoder input board	Necessary as of 4 axes and closed-loop spindle	13
Connecting cables	✓	24

Accessories

Accessories	TNC 128	Page
Electronic handwheels	<ul style="list-style-type: none"> • HR 510 portable handwheel or • HR 520 portable handwheel with display or • HR 550 FS portable wireless handwheel with display, or • HR 130 panel-mounted handwheel or • Up to three HR 150 panel-mounted handwheels via HRA 110 handwheel adapter 	17
Workpiece touch probes	<ul style="list-style-type: none"> • TS 260 touch trigger probe with cable connection or • KT 130 edge finder with cable connection 	16
Tool touch probes	• TT 160 touch trigger probe	16
PLC input/output system	For additional internal PLC inputs and outputs PL 510 consisting of PLB 51x basic module and I/O modules	15
USB hub	✓	41
Snap-on keys	For the control For handwheels	22 20
Accessories / Software	TNC 128	Page
PLCdesign¹⁾	PLC development software	37
KinematicsDesign¹⁾	Software for kinematic configuration	31
TNCremo²⁾	Data transfer software	41
TNCremoPlus²⁾	Data transfer software with “live” screen	41
ConfigDesign¹⁾	Software for configuring the machine parameters	33
CycleDesign¹⁾	Software for creating cycle structures	39
TNCkeygen¹⁾	Software for enabling SIK options for a limited time, and for day-by-day access to the OEM area	13
TNCscope¹⁾	Software for data recording	34
TeleService¹⁾	Software for remote diagnostics, monitoring, and operation	34
RemoTools SDK¹⁾	Function library for developing customized applications for communication with HEIDENHAIN controls	
TNCtest¹⁾	Software for creation and execution of acceptance tests	35
TNCanalyzer¹⁾	Software for the analysis and evaluation of service files	35

¹⁾ Available to registered customers for downloading from the Internet

²⁾ Available to all customers (without registration) for downloading from the Internet

Specifications

Specifications	TNC 128	Page
Axes	6 control loops, of which up to 2 are configurable as spindles	27
PLC axes	✓	27
Central drive	✓	27
Open-loop axes	✓	27
Spindle	<i>Milling:</i> Max. 2; second spindle can be controlled by PLC alternately with the first	
Analog nominal speed value	Up to 100 000 rpm	28
Digital control over PLC outputs	✓	
Position-controlled spindle	✓	28
Oriented spindle stop	✓	28
Gear shifting	✓	28
NC program memory	1.8 GB	
Input resolution and display step		
Linear axes	0.1 µm	27
Rotary axes	0.0001°	27
Axis feedback control	Analog speed command interface ± 10 V (X8)	30
With following error	✓	
With feedforward	✓	
Cycle times		
Block processing	6 ms	
Path interpolation	3 ms	
Permissible temperature range	Operation: In electrical cabinet: 5 °C to 40 °C In operating panel: 0 °C to 50 °C Storage: -20 °C to 60 °C	

Interfacing to the machine

Interfacing to the machine	TNC 128	Page
Error compensation	✓	32
Linear axis error	✓	32
Nonlinear axis error	✓	32
Backlash	✓	32
Hysteresis	✓	32
Thermal expansion	✓	32
Static friction	✓	32
Sliding friction	✓	32
Integrated PLC	✓	36
Program format	Statement list	36
Program input at the control	By external USB keyboard	36
Program input by PC	✓	36
Symbolic PLC-NC interface	✓	36
PLC memory	350 MB	36
PLC cycle time	9 ms to 30 ms (adjustable)	36
PLC inputs, DC 24 V ¹⁾	31 (expandable via PL)	15
PLC outputs, DC 24 V ¹⁾	31 (expandable by PL)	15
Inputs for PT 100 thermistors	Via PL	15
PLC functions	✓	36
Small PLC window	✓	36
PLC soft keys	✓	36
PLC positioning	✓	37
PLC basic program	✓	38
Integration of applications		37
High-level language programming	Python programming language used in combination with the PLC (option 46)	37
User interfaces can be custom-designed	Create specific user interfaces of the machine tool builder with the programming language Python. Programs up to a memory limit of 10 MB are enabled in standard mode. Additional enabling via option 46.	37

¹⁾ Further PLC inputs/outputs over PL 510 for connection to MC

Interfacing to the machine	TNC 128	Page
Commissioning and diagnostic aids		33
ConfigDesign	Software for creating the machine configuration	33
Integrated oscilloscope	✓	33
Trace function	✓	34
API DATA function	✓	34
Table function	✓	34
OLM (online monitor)	✓	34
Log	✓	34
Commissioning wizard	For analog axes	33
Data interfaces	✓	
Ethernet	1000BASE-T	40
USB	Rear: 2 x USB 3.0 Front: USB 2.0	40
RS-232-C	✓	40
Protocols		40
Standard data transfer	✓	40
Blockwise data transfer	✓	40
LSV2	✓	40
Encoder inputs		29
Position	4 (optional: 5)	29
Incremental	1 V _{PP}	29
Absolute	EnDat 2.1	29

1) Further PLC inputs/outputs over PL 510 for connection to MC

User functions

User function	Standard	Option	TNC 128
Short description	✓	0 1	Basic version: 3 axes plus closed-loop spindle 1st additional axis for 4 axes plus closed-loop or open-loop spindle 2nd additional axis for 5 axes plus open-loop spindle
Program entry	✓		HEIDENHAIN conversational
Position entry	✓ ✓ ✓		Nominal positions for lines in Cartesian coordinates Incremental or absolute dimensions Display and entry in mm or inches
Tool tables	✓		Multiple tool tables with any number of tools
Cutting data	✓		Automatic calculation of spindle speed, cutting speed, feed per tooth and feed per revolution
Fixed cycles	✓ ✓ ✓ ✓ ✓ ✓ ✓		Drilling, conventional and rigid tapping Rectangular pockets Face milling Peck drilling, reaming, boring, counterboring, centering Multioperation machining of rectangular pockets Cartesian and polar point patterns OEM cycles (special cycles developed by the machine tool builder) can be integrated
Program jumps	✓ ✓ ✓		Subprograms Program section repeats Calling any program as a subprogram
Coordinate transformation	✓		Shifting, mirroring, scaling (axis-specific)
Q parameters Programming with variables	✓ ✓ ✓ ✓ ✓		Mathematical functions =, +, -, *, /, sin α , cos α , tan α , arcus sin, arcus cos, arcus tan, a^n , e^n , ln, log, angle α of sin α and cos α , square root of a, square root of ($a^2 + b^2$) Logical operations (=, = /, <, >) Calculating with parentheses Absolute value of a number, constant π , negation, truncation of digits before or after the decimal point Functions for calculation of circles
Programming aids	✓ ✓ ✓ ✓ ✓ ✓		Calculator Complete list of all current error messages Context-sensitive help function for error messages TNCguide: The integrated help system. User information available directly on the TNC Graphic support for programming cycles Comment and structure blocks in the NC program
CAD viewer	✓		Display of standardized CAD data formats on the TNC
Teach-In	✓		Actual positions can be transferred directly into the NC program
Test graphics Display modes	✓ ✓ ✓		Graphic simulation before a program run, even while another program is running Plan view / projection in 3 planes / 3-D view, also in tilted working plane / 3-D line graphics Magnification of details
Programming graphics	✓		In the Programming and Editing mode, the contours of the NC blocks are drawn on screen while they are being entered (2-D pencil-trace graphics), even while another program is running
Program-run graphics Display modes	✓ ✓		Graphic simulation during real-time machining Plan view / projection in 3 planes / 3-D view

User function	Standard	Option	TNC 128
Machining time	✓ ✓		Calculation of machining time in the Test Run operating mode Display of the current machining time in the Program Run operating modes
Returning to the contour	✓ ✓		Mid-program startup in any block in the program, returning the tool to the calculated nominal position to continue machining Program interruption, contour departure and return
Datum management	✓		For saving any reference points
Datum tables	✓		Several datum tables for storing workpiece-related datums
Touch probe cycles	✓ ✓		Calibrating the touch probe Reference-point setting
Conversational languages	✓		English, German, Czech, French, Italian, Spanish, Portuguese, Dutch, Swedish, Danish, Finnish, Norwegian, Slovenian, Slovak, Polish, Hungarian, Russian (Cyrillic), Romanian, Turkish, Chinese (traditional and simplified), Korean

Options

Option number	Option	As of NC software 771841-	ID	Remark	Page
0	Additional axis 1	01	ID 354540-01	Additional control loop 1	13
1	Additional axis 2	01	ID 353904-01	Additional control loop 2	13
17	Touch probe functions	01	ID 634063-01	Touch probe cycles <ul style="list-style-type: none"> • Reference-point setting • Tool and workpiece measurement • Touch probe input enabled for non-HEIDENHAIN systems 	39
18	HEIDENHAIN DNC	01	ID 526451-01	Communication with external PC applications over COM component	42
46	Python OEM process	01	ID 579650-01	Execute Python applications	37

Control components

Main computer

TNC 128

- The standard version of the TNC 128 features four inputs for position encoders. It can be enhanced with options.
- The TNC 128 includes the MC 128 main computer with:
- Intel Celeron 1047 processor (1.4 GHz, dual-core)
 - 2 GB SDRAM main memory
 - 12.1-inch TFT color flat-panel display; resolution 1024 x 768 pixels
 - TNC keyboard
 - Machine operating panel
 - PLC
 - Interface to handwheel and touch probes
 - Further interfaces (PLC expansion, Ethernet, USB 2.0 on front, 2 x USB 3.0 on rear, RS-232-C/V.24)
- To be ordered separately, and installed in the main computer by the OEM:
- **CFR** CompactFlash memory card with the NC software
 - The **System Identification Key component**(SIK) for enabling control loops and options



MC 128

- | | |
|-----------------|---|
| Position inputs | 4 x 1 V _{PP} or EnDat
(optional 5 x 1 V _{PP} or EnDat) |
| Mass | 8 kg
ID 803344-xx |

Power supply

- | | |
|------------------------------|---------|
| Supply voltage ¹⁾ | 24 V DC |
| Power consumption | 60 W |
- ¹⁾ PELV according to EN 61800-5-1 for low voltage electrical separation

Memory medium

- The storage medium is a CFR (= CompactFlash Removable) compact flash memory card. It contains the NC software and is used to store NC and PLC programs. The storage medium is removable and must be ordered separately from the main computer.
- Please note:** These CFRs use the fast SATA protocol (CFast) for significantly shorter access times.

- | | |
|--------------------------------|---------------|
| CFR CompactFlash 8 GB | |
| Free capacity for NC programs | 1.8 GB |
| Free capacity for PLC programs | 350 MB |
| No export license required | ID 1038498-55 |



CFR CompactFlash

SIK component

The SIK component contains the **NC software license** for enabling control loops and software options. It gives the main computer an unambiguous ID code—the SIK number. The SIK component is ordered and shipped separately. It must be inserted in a special slot in the MC main computer.

The SIK component with the NC software license is available in various versions, depending on the enabled control loops and options. Further control loops can be enabled later by entering a keyword. HEIDENHAIN provides the keyword, which is based on the SIK number.

When ordering, please indicate the SIK number of your control. When the keywords are entered in the control, they are saved in the SIK component. This enables and activates the options. Should service become necessary, the SIK component must be inserted in the replacement control to enable all required options.



SIK component

Master keyword (General Key)

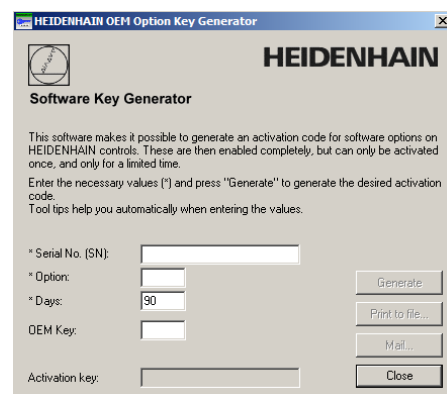
For commissioning the TNC 128, a general key can be used that will unlock all control loop options for a duration of 90 days. After this period, only those options with the correct keywords will be active. The general key is activated via a soft key.

TNCkeygen (accessory)

TNCkeygen is a collection of PC software tools for generating time-limited enabling keys for HEIDENHAIN controls.

OEM Key Generator is used to generate enabling keys for software options by entering the SIK number, the option to be enabled, the duration and a manufacturer-specific password. The enabling period is limited to 10 to 90 days. Each option can only be enabled once. Option enabling is independent of the general key.

The **OEM daily key generator** generates an enabling key for the protected area of the machine tool builder. This grants the operator access to the area on the day the key was generated.



NC software license

SIK with software license and enabling for

4 control loops (3 axes plus closed-loop spindle)

ID 822102-51

4 control loops and option 17 (touch probe)

ID 822102-55

5 control loops (4 axes plus closed-loop spindle)

ID 822102-52

6 control loops (5 axes plus open-loop spindle)

ID 822102-53

Axis options

With the NC software license for three axes, two additional control loops can be enabled later:

1st additional axis

ID 354540-01

2nd additional axis

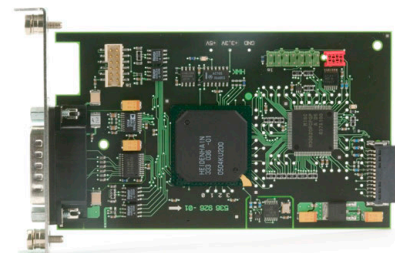
ID 353904-01

Encoder input board

An additional encoder input board is required for axis configurations with four or more axes plus closed-loop spindle.

Encoder input board

ID 554296-xx



Possible configurations

Closed-loop axes	Spindle ¹⁾	NC software license for	Necessary options
3	Closed loop	4 control loops	–
4	Open loop	4 control loops	1st additional axis
		5 control loops	–
4	Closed loop	4 control loops	1st additional axis Encoder input board
		5 control loops	Encoder input board
5	Open loop	4 control loops	1st additional axis 2nd additional axis Encoder input board
		5 control loops	2nd additional axis Encoder input board

¹⁾ For the *open-loop spindle*, the TNC specifies the spindle speed as analog nominal speed value. For the *closed-loop spindle*, position feedback is provided, for example for oriented spindle stop.

Options

The capabilities of the TNC 128 can also be adapted retroactively with options to meet new requirements. These options are described on page 11. They are enabled by entering keywords based on the SIK number, and are saved in the SIK component. Please indicate your SIK number when ordering new options.

TNC keyboard

The keys for the Z axis, axis IV and V are designed as snap-on keys and can be replaced by keys with other symbols (see Snap-on keys).

Export license

An **export license** is generally **not** required for the TNC 128.

Machine operating panel

The TNC 128 features an integrated machine operating panel.

- 24 snap-on keys, which can be addressed directly via the PLC, 3 snap-on keys can be wired as desired
- Operating elements (pre-assigned according to PLC basic program):
Control voltage on¹⁾; Emergency stop, NC start¹⁾; NC stop¹⁾; 4 axis keys; rapid traverse; unlock door; spindle start; spindle stop; coolant; rinse-water jet; chip removal (for other key symbols, see *Snap-on keys*)
- Additional connections:
Terminals for 8 PLC inputs and 8 PLC outputs (pre-assigned by default)

¹⁾ Keys illuminated, addressable via PLC

PL 510 PLC input/output system

PL 510

If the PLC inputs/outputs of the control do not suffice, you can connect additional PL 51x PLC input/output systems. These external modular I/O systems consist of a PLB 51x basic module and one or more PLD 16-8 and PLA 4-4 input/output modules.



PL 510

Basic modules

Basic modules feature slots for 4, 6 or 8 I/O modules. Mounted on standard NS 35 rails (DIN 46 227 or EN 50 022).

Supply voltage	24 V DC
Power consumption	≈ 20 W
Mass	0.36 kg (bare)

Basic modules with HEIDENHAIN PLC interface

PLB 510	Slots for 4 I/O modules	ID 358849-01
PLB 511	Slots for 6 I/O modules	ID 556941-01
PLB 512	Slots for 8 I/O modules	ID 557125-01

Up to four PLB 510 modules, and up to two PLB 511 or PLB 512 modules can be connected to the control. The maximum cable length to the last PLB 51x is 30 m.

I/O modules

The I/O modules consist of one module with digital inputs/outputs and one analog module. For partially occupied basic modules, the unused slots must be occupied by an empty housing.

PLD 16-8 ID 360916-11

I/O module for PL 5x0 with
16 digital inputs and
8 digital outputs.

The maximum power output per module is 200 W. A load of up to 2 A can be placed on each output. No more than four outputs may be loaded with 2 A at any given time.

Mass	0.2 kg
------	--------

PLA 4-4 ID 366423-01

Analog module for PL 5x0 with
4 analog inputs for PT 100 thermistors
4 analog inputs for ± 10 V

Mass	0.2 kg
------	--------

Empty housing

For unused slots	ID 383022-xx
------------------	--------------

Accessories

Touch probes

Overview

Before the TNC 128 leaves the factory, it is already prepared for the use of touch probes for workpiece or tool measurement. These touch probes generate a trigger signal that saves the current position value to the NC. For more information on the touch probes, ask for our brochure titled *Touch Probes*.

Workpiece measurement

The TS touch trigger probes and the KT edge finders have a stylus for probing workpieces. The HEIDENHAIN controls provide standard routines for presetting and workpiece measurement and alignment. The touch probes are available with various taper shanks. Assorted styli are available as accessories.

Touch probes with **cable connection for signal transmission** for machines with manual tool change:

KT 130

Edge finder for manual and controlled machines



KT 130

TS 260

New generation touch probe for NC machines



TS 260

Tool measurement

The touch probes for tool measurement from HEIDENHAIN are suited for probing stationary or rotating tools directly on the machine. The TNC 128 has standard routines for measuring the length and diameter of the tool as well as the individual teeth. The TNC 128 automatically saves the results of measurement in a tool table. It is also possible to measure tool wear between two machining steps.

With the triggering **TT touch probes**, the disk-shaped probe contact is deflected from its resting position by contact with the stationary or rotating tool and a trigger signal is transmitted to the TNC 128.

TT 160

New generation touch probe; signal transmission to the control over connecting cable



TT 160

Electronic handwheels

Overview

Support of electronic handwheels is standard on the TNC 128

- **HR 550 FS** radio handwheel, or
- **HR 510** or **HR 520** portable handwheel, or
- **HR 130** panel-mounted handwheel or
- Up to three **HR 150** panel-mounted handwheels via **HRA 110**

HR 510

Portable electronic handwheel with

- Keys for actual-position capture and the selection of 5 axes
- Keys for traverse direction and three preset feed rates
- Three keys for machine functions (see below)
- Emergency stop button and two permissive buttons (24 V)
- Magnetic holding pads

All keys are designed as snap-on keys and can be replaced by keys with other symbols (see overview for HR 510 in *Snap-on keys for HR*).

	Keys	Without detent	With detent
HR 510	NC start/stop, spindle start (for basic PLC program)	ID 1119971-xx	ID 1120313-xx
	FCT A, FCT B, FCT C	–	ID 1099897-xx
	Spindle right/left/stop	ID 1184691-xx	–
HR 510 FS	NC start/stop, spindle start (for basic PLC program)	ID 1120311-xx	ID 1161281-xx
	FCT A, FCT B, FCT C	–	ID 1120314-xx
	Spindle right/left/stop	–	ID 1119974-xx

Mass ≈ 0.6 kg



HR 510

HR 520

Portable electronic handwheel with

- Display for operating mode, actual position value, programmed feed rate and spindle speed, error messages
- Override potentiometer for feed rate and spindle speed
- Selection of axes via keys or soft keys
- Actual position capture
- NC start/stop
- Spindle on/off
- Keys for continuous traverse of the axes
- Soft keys for machine functions of the machine manufacturer
- Emergency stop button

	Without detent	With detent
HR 520	ID 670302-xx	ID 670303-xx
HR 520 FS	ID 670304-xx	ID 670305-xx

Mass ≈ 1 kg



HR 520

Mount for HR 520

For fastening on machine

ID 591065-xx

	HR 510	HR 510 FS	HR 520	HR 520 FS	HR 550 FS with HRA 551 FS	
Dummy plug for standard handwheels	✓	–	✓	–	–	ID 271958-03
Dummy plug for handwheels with FS	–	✓	–	✓	–	ID 271958-05

¹⁾ For maximum cable lengths up to 20 m between the MB and HRA 551 FS

²⁾ For maximum cable lengths up to 50 m between the MB and HRA 551 FS

See also *Cable overview* on Page 24.

HR 130

Panel-mounted handwheel with ergonomic control knob.
It is attached to the MB 7x0 or the TE 7x5 either directly or via an extension cable.

HR 130	Without detent	ID 540940-03
	With detent	ID 540940-01
Mass	≈ 0.7 kg	



HR 130

HR 150

Panel-mounted handwheel with ergonomic control knob for connection to the **HRA 110** handwheel adapter.

HR 150	Without detent	ID 540940-07
	With detent	ID 540940-06
Mass	≈ 0.7 kg	



HR 150

HRA 110

Handwheel adapter for connection of up to three **HR 150** panel-mounted handwheels and two switches for axis selection and for selecting the subdivision factor. The first two handwheels are permanently assigned to axes 1 and 2. The third handwheel is assigned to the axes over a selection switch (accessory) or by machine parameters. The position of the second step switch (accessory) is evaluated over the PLC, for example to select the subdivision factor.

HRA 110		ID 261097-xx
Mass	≈ 1.5 kg	



HRA 110











Snap-on keys for HR

Snap-on keys





































The snap-on keys make it easy to replace the key symbols. In this way, the HR handwheel can be adapted to different requirements. The snap-on keys are available in packs of 5 keys.

Overview for HR 520/HR 550



























Axis keys Orange

	ID 330816-42		ID 330816-24		ID 330816-43		ID 330816-37
	ID 330816-26		ID 330816-36		ID 330816-38		
	ID 330816-23		ID 330816-25		ID 330816-45		

Gray

	ID 330816-95		ID 330816-69		ID 330816-0W		ID 330816-0R
	ID 330816-96		ID 330816-0G		ID 330816-0V		ID 330816-0D
	ID 330816-97		ID 330816-0H		ID 330816-0N		ID 330816-0E
	ID 330816-98		ID 330816-71		ID 330816-0M		ID 330816-65
	ID 330816-99		ID 330816-72		ID 330816-67		ID 330816-66
	ID 330816-0A		ID 330816-63		ID 330816-68		ID 330816-19
	ID 330816-0B		ID 330816-64		ID 330816-21		ID 330816-16
	ID 330816-0C		ID 330816-18		ID 330816-20		ID 330816-0L
	ID 330816-70		ID 330816-17		ID 330816-0P		ID 330816-0K





















Machine functions

	ID 330816-0X		ID 330816-75		ID 330816-0T		ID 330816-86
	Black ID 330816-1Y		ID 330816-76		ID 330816-81		ID 330816-87
	Black ID 330816-30		ID 330816-77		ID 330816-82		ID 330816-88
	Black ID 330816-31		ID 330816-78		ID 330816-83		ID 330816-94
	Black ID 330816-32		ID 330816-79		ID 330816-84		ID 330816-0U
	ID 330816-73		ID 330816-80		ID 330816-89		ID 330816-91
	ID 330816-74		ID 330816-0S		ID 330816-85		ID 330816-3L

Spindle functions











	Red ID 330816-08		ID 330816-40		Red ID 330816-47		ID 330816-48
	Green ID 330816-09		ID 330816-41		Green ID 330816-46		ID 385530-5X

Other keys











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	Green ID 330816-11		ID 330816-34		Black ID 330816-28		Black ID 330816-4M
	Red ID 330816-12		ID 330816-13		Black ID 330816-29		ID 330816-3M
	Green ID 330816-49		Green ID 330816-22		ID 330816-92		ID 330816-3N

Overview of HR 510







Axis keys
Orange

	ID 1092562-02		ID 1092562-05		ID 1092562-36		ID 1092562-08
	ID 1092562-03		ID 1092562-06		ID 1092562-09		
	ID 1092562-04		ID 1092562-07		ID 1092562-37		







Gray

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	ID 1092562-29		ID 1092562-32		ID 1092562-25		
	ID 1092562-30		ID 1092562-33		ID 1092562-26		













Machine
functions

	Black ID 1092562-14		ID 1092562-15		ID 1092562-16		ID 1092562-42
	ID 1092562-43		ID 1092562-44				

Spindle
functions

	ID 1092562-18		ID 1092562-19		Green ID 1092562-22		Red ID 1092562-17
	Red ID 1092562-38		ID 1092562-41				

Other keys

	Black ID 1092562-01		Green ID 1092562-23		ID 1092562-13		ID 1092562-35
	Green ID 1092562-20		ID 1092562-11		Black ID 1092562-10		ID 1092562-39
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

Snap-on keys for control

Snap-on keys







































The snap-on keys make it easy to replace the key symbols. In this way, the keyboard can be adapted to different requirements. The snap-on keys are available in packs of 5 keys.

Overview of control keys










































Keys Orange

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	ID 679843-32		ID 679843-55		ID 679843-C9		
	ID 679843-53		ID 679843-88		ID 679843-D3		



















Gray

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	ID 679843-04		ID 679843-14		ID 679843-94		ID 679843-C1
	ID 679843-05		ID 679843-43		ID 679843-B1		ID 679843-C2
	ID 679843-06		ID 679843-44		ID 679843-B2		ID 679843-C3
	ID 679843-07		ID 679843-67		ID 679843-B3		ID 679843-C4
	ID 679843-08		ID 679843-68		ID 679843-B4		ID 679843-C5
	ID 679843-09		ID 679843-69		ID 679843-B5		ID 679843-D9
	ID 679843-10		ID 679843-70		ID 679843-B6		ID 679843-E1
	ID 679843-11		ID 679843-91		ID 679843-B7		
	ID 679843-12		ID 679843-92		ID 679843-B8		































Machine functions

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	ID 679843-02		ID 679843-40		ID 679843-76		Black ID 679843-C7
	ID 679843-16		Green ID 679843-56		Black ID 679843-95		ID 679843-D6
	ID 679843-22		Red ID 679843-57		Black ID 679843-96		ID 679843-E3
	ID 679843-23		ID 679843-59		Black ID 679843-A1		ID 679843-E4
	ID 679843-24		ID 679843-60		ID 679843-A2		ID 679843-E6
	ID 679843-25		ID 679843-61		ID 679843-A3		ID 679843-E7
	ID 679843-26		ID 679843-62		ID 679843-A4		ID 679843-E8
	ID 679843-27		ID 679843-63		ID 679843-A5		
	ID 679843-28		ID 679843-64		ID 679843-A6		
	ID 679843-29		ID 679843-73		ID 679843-A9		

Spindle functions

	ID 679843-18		ID 679843-47		Red ID 679843-52		ID 679843-99
	ID 679843-19		ID 679843-48		ID 679843-65		Green ID 679843-D8
	ID 679843-20		ID 679843-49		Green ID 679843-71		ID 679843-F3
	ID 679843-21		ID 679843-50		ID 679843-72		
	ID 679843-46		ID 679843-51		Red ID 679843-89		

Other keys

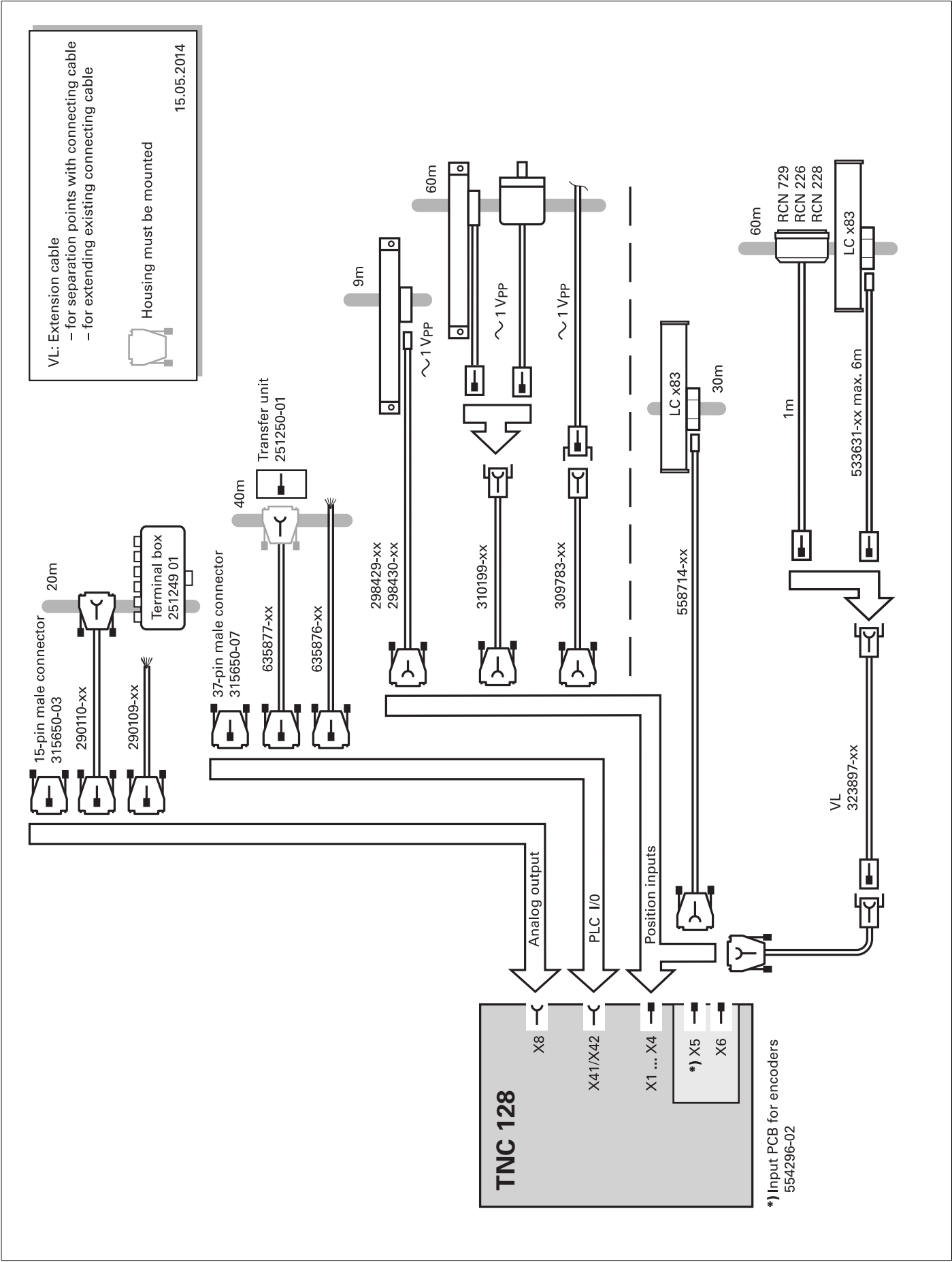
	ID 679843-15		ID 679843-39		ID 679843-97		Black ID 679843-E2
	ID 679843-17		ID 679843-41		ID 679843-98		ID 679843-E5
	ID 679843-33		ID 679843-42		ID 679843-A7		ID 679843-F2
	Black ID 679843-34		Red ID 679843-45		ID 679843-A8		ID 679843-F4
	Orange ID 679843-35		ID 679843-58		Black ID 679843-D1		ID 679843-F5
	ID 679843-36		ID 679843-66		Black ID 679843-D2		ID 679843-F6
	ID 679843-37		ID 679843-75		ID 679843-D5		
	ID 679843-38		Green ID 679843-90		Red ID 679843-D7		

Special keys

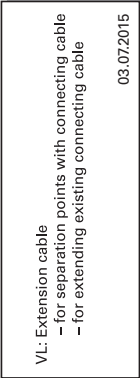
Snap-on keys with customized symbols for special applications can also be manufactured. The laser labeling differs optically from the labeling of the standard keys.

Cable overview

TNC 128



Accessories



Technical description

Operating system

HEROS 5

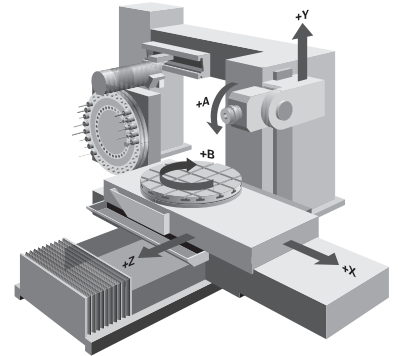
The TNC 128 operates with the Real-time Operating System (HEROS 5) from HEIDENHAIN. This future-focused operating system features powerful functions:

- **PDF files**, drawings, work instructions, etc. can be opened directly on the control.
- Direct Internet access from the TNC 128 thanks to the **integrated browser**. The browser can be run in a **Sandbox** to increase data security.
- Plays **audio and video files** (ogg)
- You can open various **file formats** directly on the TNC 128 and also edit some of them with the appropriate editors:
 - Text files (txt, ini)
 - Graphic files (gif, bmp, jpg, png)
 - Tables (xls, csv)
 - Internet (html)
- Standardized **display format** for operating system dialogs
- Setting up a firewall for additional **data security**
- Managing printers
- Backup function for backing up and restoring control data

Axes

Linear axes

The TNC 128 can control linear axes with any axis designation (X, Y, Z, U, V, W ...).



Display and programming

–99 999.999 to +99 999.999 [mm]

Feed rate in mm/min relative to the workpiece contour, or mm per spindle revolution

Feed rate override: 0 % to 150 %

Traverse range

–99 999.999 to +99 999.999 [mm]

The machine tool builder defines the traverse range. The user can set additional limits to the traverse range if he wishes to reduce the working space. Three different traverse ranges can be defined (selection by PLC).

Rotary axes

The TNC 128 can control rotary axes with any axis designation (A, B, C, U ...). Special parameters and PLC functions are available for rotary axes with Hirth coupling.

Display and programming

0° to 360° or
–99 999.999 to +99 999.999 [°]

Feed rate in degrees per minute [°/min]

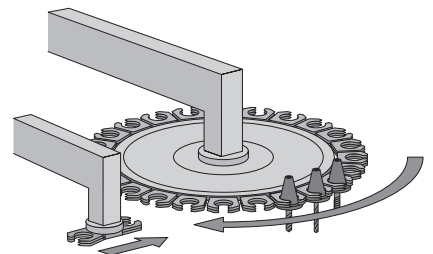
Traverse range

–99 999.999 to +99 999.999 [°]

The machine tool builder defines the traverse range. The user can set additional limits to the traverse range if he wishes to reduce the working space. Various traverse ranges can be defined per axis using parameter sets (selection by PLC).

PLC axes

Axes can be controlled by the PLC. They are programmed through M functions or OEM cycles. The PLC axes are positioned independently of the NC axes and are therefore designated as asynchronous axes.

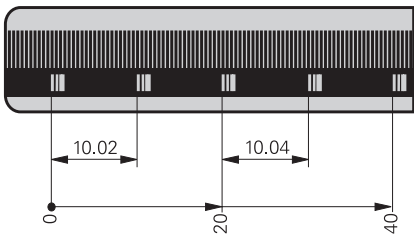


Spindle

Analog nominal speed value	Up to 100 000 rpm
Position-controlled spindle	The position of the spindle is monitored by the control.
Encoder	HEIDENHAIN rotary encoder with sinusoidal voltage signals (1 V _{pp}) or EnDat interface.
Tapping	There are special cycles for tapping with or without floating tap holder. For tapping without floating tap holder, the spindle must be operated under position control.
Oriented spindle stop	With a position-controlled spindle, the spindle can be positioned exactly to 0.1°.
Spindle override	0 to 150 %
Gear ranges	A separate nominal speed is defined for each gear range. The gear stages are controlled by the PLC.
Multiple main spindles	Up to 2 spindles can be controlled alternately. The spindles are switched by the PLC. One control loop is required for each active spindle.

Encoders

Overview	For speed and position control of the axes and spindle, HEIDENHAIN offers both incremental and absolute encoders.
Incremental encoders	Incremental encoders have as measuring standard a grating consisting of alternate lines and spaces. Relative movement between the scanning head and the scale causes output of sinusoidal scanning signals. The measured value is calculated by counting the signals.
Reference mark	When the machine is switched on, the machine axes need to traverse a reference mark for an accurate reference to be established between measured value and machine position. For encoders with distance-coded reference marks, the maximum travel until automatic reference mark evaluation for linear encoders is only 20 mm or 80 mm, depending on the model, or 10° or 20° for angle encoders.
Evaluation of reference marks	The routine for traversing the reference marks can also be started for specific axes via the PLC during operation (reactivation of parked axes).
Output signals	Incremental encoders with sinusoidal output signals with ~ 1 V _{pp} levels are suitable for connection to HEIDENHAIN numerical controls.
Absolute encoders	With absolute encoders, the position information is contained in several coded tracks. Thus, an absolute reference is available immediately after switch-on. Reference-mark traverse is not necessary. Additional incremental signals are output for highly dynamic control loops.
EnDat interface	<p>The TNC 128 features the serial EnDat 2.1 interface for the connection of absolute encoders.</p> <p>Note: The EnDat interface on HEIDENHAIN encoders differs in its pin assignment from the interface on Siemens motors with integrated absolute ECN/EQN rotary encoders. Special adapter cables are available.</p>
Encoder inputs for position control	Incremental and absolute linear, angular or rotary encoders from HEIDENHAIN can be connected to encoder inputs of the TNC 128.



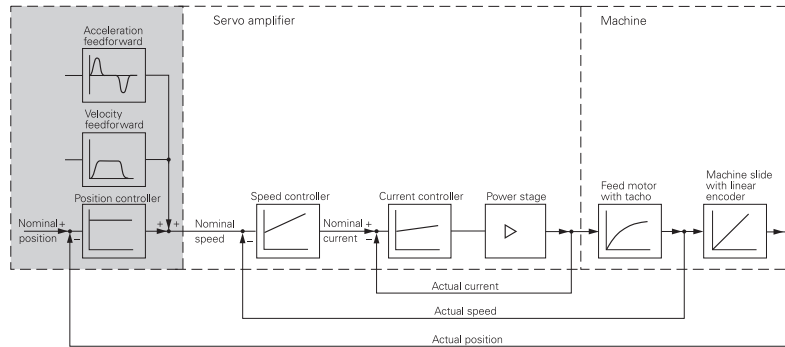
Channel inputs	Signal level/Interface ¹⁾	Input frequency ¹⁾
Incremental	~1 V _{pp}	33 kHz/350 kHz
Absolute	EnDat 2.1 ~1 V _{pp}	– 33 kHz/350 kHz

¹⁾ Switchable

Servo control

Analog speed command interface

The position controller is integrated in the TNC 128. The motor speed controller and the current controller are located in the servo amplifier. The nominal speed command signal (= velocity) is sent by the TNC to the servo amplifier through an analog ± 10 V interface (connection X8).



Axis feedback control

The TNC 128 can be operated with following error or feedforward control.

Operation with following error

The term "following error" denotes the distance between the momentary nominal position and the actual position of the axis. The velocity is calculated as follows:

$$v = k_v \cdot s_a$$

v = Velocity
 k_v = Position loop gain
 s_a = Following error

Operation with feedforward control

Feedforward means that the speed and the acceleration are adjusted to fit the machine. Together with the values calculated from the following error, it forms the nominal value. This greatly reduces the following error (to within a few μm). The feedforward is adjustable from 0 to 100 % via a machine parameter.

Central drive

It is possible to use one common drive for several or all machine axes. The NC software allows the user to use the same nominal position value output for more than one axis.

The most important basic requirements for realizing a machine with central drive:

- Common drive package with an analog nominal position value input for all axes
- The PLC must handle the machine axes as clamping axes
- The PLC monitors the drive regarding movement in multiple axes and outputs an error message if necessary

Axis clamping

The control loop can be opened through the PLC in order to clamp specific axes.

Open-loop axes

One or more axes can be defined as open-loop axes (manual axes, counter axes). They have position encoders for determining and displaying the current position value, but no nominal-value outputs. The target position is reached manually (e.g. through mechanical handwheels). If an NC block is reached with the non-controlled axis, a dialog window prompts the machine operator to move the axis to the nominal coordinates.

Monitoring functions

Description

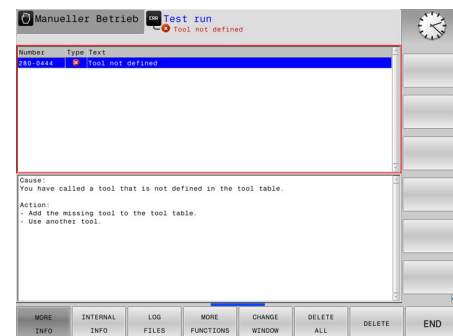
During operation the control monitors the following:

- Amplitude of the encoder signals
- Edge separation of the encoder signals
- Absolute position from encoders with distance-coded reference marks
- Current position (following error monitoring)
- Actual path traversed (movement monitoring)
- Position deviation at standstill
- Checksum of safety-related functions
- Supply voltage
- Buffer battery voltage
- Operating temperature of the MC and CPU
- Run time of the PLC program

In the event of hazardous errors, an EMERGENCY STOP message is sent to the external electronics via the control-is-ready output, and the axes are brought to a stop. The correct connection of the TNC 128 in the machine's EMERGENCY STOP loop is checked when the control system is switched on. In the event of an error, the control displays a message in plain language.

Context-sensitive help

The HELP and ERR keys provide the user with context-sensitive help. This means that in the event of an error message, the control displays information on the cause of the error and proposes solutions. The machine tool builder can also use this function for PLC error messages.



KinematicsDesign (accessory)

KinematicsDesign is a PC program for creating adaptable kinematic configurations. It supports:

- Complete kinematic configurations
- Transfer of configuration files between control and PC
- Description of tool-carrier kinematics

Kinematics descriptions developed for the iTNC 530 can also be converted to kinematics descriptions for the TNC 640/620/320/128.

If KinematicsDesign is connected to a control online (operation is also possible with the programming station software), then machine movements can be simulated and the axes are moved.

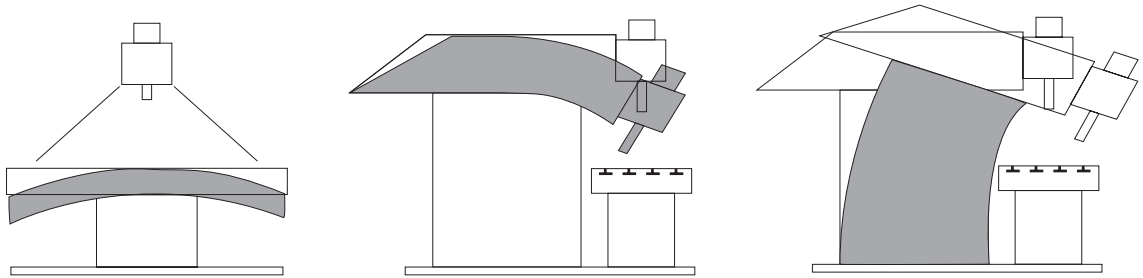
The comprehensive displaying possibilities range from a pure listing of the transformation chain to a wire model to the depiction of the entire work envelope on the TNC 640 and iTNC 530.

Error compensation

Overview The TNC 128 automatically compensates mechanical errors of the machine.

Linear error Linear error can be compensated over the entire travel range for each axis.

Nonlinear error The TNC 128 can compensate for ball-screw pitch errors and sag errors simultaneously. The compensation values are stored in a table. Nonlinear axis-error compensation also makes it possible to compensate for position-dependent backlash.



Backlash The play between table movement and rotary encoder movement on direction changes can be compensated in length measurements by spindle and rotary encoder. This backlash is outside the controlled system.

Hysteresis The hysteresis between table movement and motor movement is also compensated in direct length measurements. In this case the hysteresis is within the controlled system.

Static friction At very low feed rates, high static friction can cause the slide to stop and start repeatedly for short periods. This is commonly known as stick-slip. The TNC 128 can compensate for this problem condition.

Sliding friction Sliding friction is compensated by the speed controller of the TNC 128.

Thermal expansion To compensate thermal expansion, the machine's expansion behavior must be known.

The temperature can be recorded via thermistors connected to the analog inputs of the TNC 128. The PLC evaluates the temperature information and transfers the compensation value to the NC.

Commissioning and diagnostic aids

Overview

The TNC 128 provides comprehensive internal commissioning and diagnostic aids. It also includes highly effective PC software for diagnosis, optimization and remote control.

ConfigDesign (accessory)

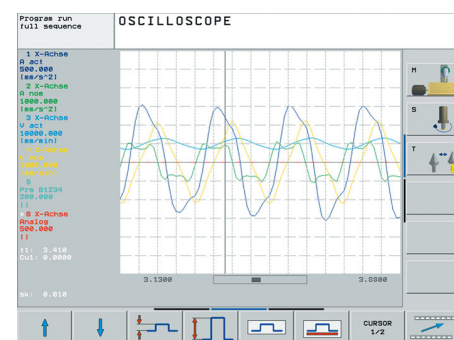
PC software for configuring the machine parameters

- Machine-parameter editor for the control; all support information; additional data and input limits are shown for each parameter
- Configuration of machine parameters
- Comparison of parameters from different controls
- Importing of service files: easy testing of machine parameters in the field
- Rule-based creation and management of machine configurations for multiple controls (together with PLCdesign)

Oscilloscope

The TNC 128 features an integrated oscilloscope. Both X/t and X/Y graphs are possible. The following characteristic curves can be recorded and stored in six channels:

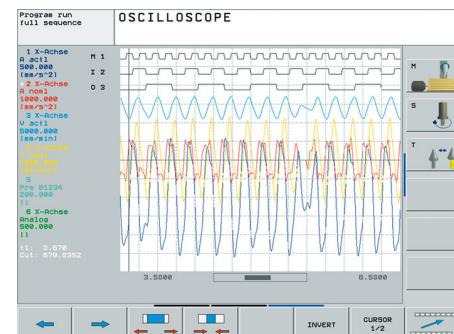
- Actual value and nominal value of the axis feed rate
- Contouring feed rate
- Nominal and actual position
- Following error of the position controller
- Nominal values for speed, acceleration and jerk
- Actual values for acceleration and jerk
- Nominal value of analog output
- Content of PLC operands
- Encoder signal (0° – A) and (90° – B)
- Nominal velocity value



Logic signals

Simultaneous graphic representation of the logic states of up to 16 operands (markers, words, inputs, outputs, counters, timers)

- Marker (M)
- Input (I)
- Output (O)
- Timers (T)
- Counter (C)
- IpoLogik (X)



Commissioning wizard

In order to simplify the adaptation of the axes and spindle, the Commissioning Wizard for analog axes guides you step-by-step through the commissioning of any axis parameter set. You can define the following machine parameters with the aid of the commissioning wizard:

- Ascertain the algebraic sign of the axis
- Ascertain the axis traverse direction
- Ascertain the velocity with 9 V analog voltage
- Ascertain the maximum acceleration of the axis
- Ascertain the k_v factor of the axis
- Ascertain acceleration feedforward control for the axis

Online Monitor (OLM)	<p>The online monitor is a component part of the TNC 128 and is called over a code number. It supports commissioning and diagnosis of control components by:</p> <ul style="list-style-type: none">• Display of control-internal variables for axes and channels• Display of controller-internal variables (if a CC is present)• Display of hardware signal states• Various trace functions• Activation of spindle commands• Enabling control-internal debug outputs								
TNCscope (accessory)	<p>PC software for transferring the oscilloscope files to a PC. With TNCscope you can record and save up to 16 channels simultaneously.</p> <p>Note: The trace files are saved in the TNCscope data format.</p>								
API DATA	<p>The API DATA function enables the control to display the states or contents of the symbolic API markers and API double words. This function requires that your PLC program use the symbolic memory interface.</p> <p>Note: The API DATA function does not provide usable display values with the iTNC 530-compatible memory interface (API 1.0)</p>								
Table function	<p>The current conditions of the markers, words, inputs, outputs, counters and timers are displayed in tables. The conditions can be changed through the keyboard.</p>								
Trace function	<p>The current content of the operands and the accumulators is shown in the statement list in each line in hexadecimal or decimal code. The active lines of the statement list are marked.</p>								
Log	<p>For the purposes of error diagnostics, all error messages and keystrokes are recorded in a log. The entries can be read using the PLCdesign or TNCremo software for PCs.</p>								
TeleService (accessory)	<p>PC software for remote diagnostics, remote monitoring and remote operation of the control. For more information, please ask for the <i>Remote Diagnosis with TeleService</i> Technical Information sheet.</p>								
<table><tr><td>Single station license</td><td></td><td>ID 340449-xx</td></tr><tr><td rowspan="2">Network license</td><td>For 14 workstations</td><td>ID 340454-xx</td></tr><tr><td>For 20 workstations</td><td>ID 340455-xx</td></tr></table>		Single station license		ID 340449-xx	Network license	For 14 workstations	ID 340454-xx	For 20 workstations	ID 340455-xx
Single station license		ID 340449-xx							
Network license	For 14 workstations	ID 340454-xx							
	For 20 workstations	ID 340455-xx							

TNCtest

Acceptance tests on machine tools with external or integrated Functional Safety (FS) must be conducted reproducibly and verifiably.

The program packages TNCtest and TestDesign programs can be used to plan and perform acceptance tests for machine tools with HEIDENHAIN controls. The acceptance tests are planned with TestDesign and run with TNCtest.

The TNCtest programs are designed to provide support during acceptance testing, provide required information, perform automatic configurations, record data and evaluate them semiautomatically. Whether a test case passes or fails must be evaluated manually by the tester.

TNCanalyzer

The TNCanalyzer application from HEIDENHAIN provides for simple and intuitive evaluation of service files and log files.

Function

- Loading of log and service files
- Analysis of temporal sequences and static states
- Filters and search functions
- Data export (HELogger, CSV and JSON formats)
- Definition of application-specific analysis profiles
- Preconfigured analysis profiles
- Graphic display of signals via TNCscope
- Interaction with other tools that are intended for the display of special sections of the service file

Integrated PLC

Overview The PLC program is created by the machine manufacturer either at the control or with the PLC development software **PLCdesign** (accessory). Machine-specific functions are activated and monitored via the PLC inputs/outputs. The number of PLC inputs/outputs required depends on the complexity of the machine.

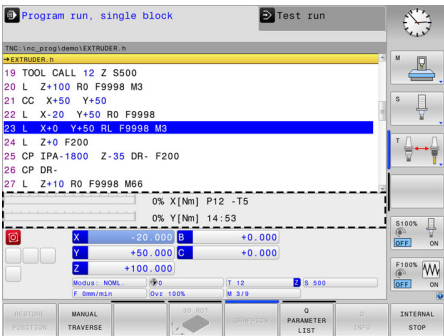
PLC expansion If the PLC inputs/outputs of the TNC 128 do not suffice, you can connect the external PLC input/output system PL 510.

Rated operating current MC main computer: 0.15 A per output
PL 510: see *PL 510 PLC input/output systems*

PLC programming	Format	Statement list
	Memory	350 MB
	Cycle time	9 ms to 30 ms (adjustable)
	Command set	<ul style="list-style-type: none">• Bit, byte and word commands• Logical operations• Arithmetic commands• Comparisons• Nested calculations (parentheses)• Jump commands• Subprograms• Stack operations• Submit programs• Timers• Counter• Comments• PLC modules• Strings

PLC window PLC error messages can be displayed by the TNC in the dialog line during operation.

Small PLC window The TNC can show additional PLC messages and bar diagrams in the small PLC window.

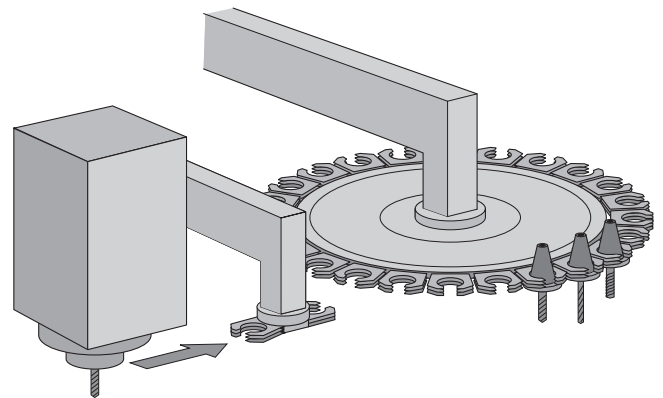


Small PLC window

PLC soft keys The machine manufacturer can display his own PLC soft keys in the vertical soft-key row on the screen.

PLC positioning

All closed-loop axes can be also positioned via the PLC. PLC positioning of the NC axes cannot be superimposed on NC positioning.



PLC axes

Axes can be controlled by the PLC. They are programmed by M functions or OEM cycles. The PLC axes are positioned independently of the NC axes.

PLCdesign (accessory)

PC software for PLC program development. The PC program **PLCdesign** can be used for easy creation of PLC programs. Comprehensive examples of PLC programs are included with the product.

Functions:

- Easy-to-use text editor
- Menu-guided operation
- Programming of symbolic operands
- Modular programming method
- "Compiling" and "linking" of PLC source files
- Operand commenting, creation of the documentation file
- Comprehensive help system
- Data transfer between the PC and control
- Creation of PLC soft keys

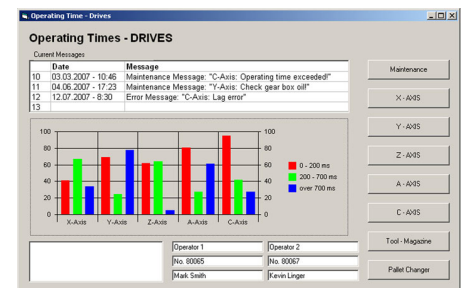
Python OEM process (option 46)

The Python OEM Process option is an effective tool for the machine tool builder to use an object-oriented high-level programming language in the control (PLC). Python is an easy-to-learn script language that supports the use of all necessary high-level language elements.

Python OEM Process can be used universally for machine functions and complex calculations, as well as to display special user interfaces. User-specific or machine-specific solutions can be efficiently implemented. Numerous libraries on the basis of Python and GTK are available, regardless of whether you want to create special algorithms for special functions, or separate solutions such as an interface for machine maintenance software.

The applications you create can be included via the PLC in the familiar PLC windows, or they can be displayed in separate free windows that can be expanded to the control's full screen size.

Simple Python scripts (e.g. for display masks) can also be executed without enabling the Python OEM Process (option 46) software option. 10 MB of dedicated memory are reserved for this function. For more information, refer to the *Python in HEIDENHAIN Controls Technical Manual*.



PLC basic program

The PLC basic program serves as a basis for adapting the control to the requirements of the respective machine. It can be downloaded from the Internet.

These essential functions are covered by the PLC basic program:

- Controlling all axes
- Clamped axes
- Homing the axes; reference end positions
- Positioning the axes after reference run
- Compensating the axis temperature
- Feed rate control
- Spindle control and orientation
- Tool changer
- Vertical PLC soft-key row
- Displaying and managing PLC error messages
- Status display in the small PLC window
- Hydraulic control
- Control of the coolant system (internal, external, air)
- M functions
- Lubrication
- Chip conveyor
- Operation of the second spindle alternately with the first
- S-coded spindle
- Positioning the spindle as an axis
- Operation with clamped axes
- Axes with central drive
- Axes with Hirth grid
- Indexing fixture
- PLC log
- Touch probes
- PLC support for handwheels
- Control of doors

Interfacing to the machine

OEM cycles

The machine tool builder can create and store his own cycles for recurring machining tasks. These OEM cycles are used in the same way as standard HEIDENHAIN cycles.

CycleDesign (accessory)

The soft-key structure for the cycles is managed using the **CycleDesign** PC program. In addition, CycleDesign can be used to store help graphics and soft keys in BMP format in the TNC. Graphic files can be compressed to ZIP format to reduce the amount of memory used.

Tool management

With integral PLC, the tool changer is moved either via proximity switch or as a controlled axis. Tool management including tool life monitoring and replacement tool monitoring is carried out by the TNC 128.

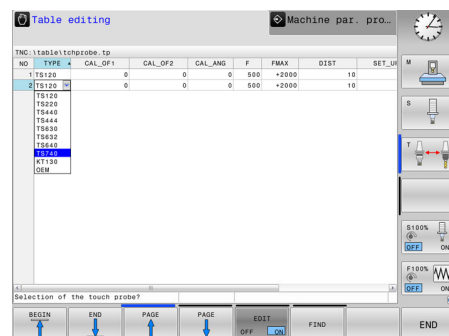
Tool calibration

Tools can be measured and checked using the **TT** tool touch probes (accessory). The control features standard cycles for automatic tool measurement. The control calculates the probing feed rate and the optimal spindle speed. The measured data is stored in a tool table.



Touch probe configuration

All touch-probe data can be configured conveniently through a table. All HEIDENHAIN touch probe systems are preconfigured and can be selected through a drop-down menu.



Data transfer and communication

Data interfaces

Overview	The TNC 128 is connected to PCs, networks and other data storage devices via data interfaces.							
Ethernet	<p>The TNC 128 can be interconnected via the Ethernet interface. For connection to the data network, the control features a 1000BASE-T (twisted pair Ethernet) connection.</p> <p>Maximum transmission distance: Unshielded 100 m Shielded 400 m</p>							
Protocol	The TNC 128 communicates using the TCP/IP protocol.							
Network connection	<ul style="list-style-type: none">• NFS file server• Windows networks (SMB)							
Data transfer speed	Approx. 400 to 800 Mbps (depending on file type and network utilization)							
RS-232-C/V.24	Data interface according to DIN 66 020 or EIA standard RS-232-C. Maximum transmission distance: 20 m							
Data transfer rate	115 200; 57 600; 38 400; 19 200; 9600; 4800; 2400; 1200; 600; 300; 150; 110 bps							
Protocols	The TNC 128 can transfer data using various protocols.							
Standard data transfer	The data is transferred character by character. The number of data bits, stop bits, the handshake and character parity must be set by the user.							
Blockwise data transfer	The data is transferred blockwise. For data backup, a so-called block check character (BCC) is used. This method improves data security.							
LSV2	Bidirectional transfer of commands and data as per DIN 66 019. The data is divided into telegrams (blocks) and transmitted.							
Adapter block	<p>For connecting the interface to the electrical cabinet or operating panel.</p> <table><tr><td rowspan="2">RS-232-C adapter</td><td>9-pin</td><td>ID 363987-xx</td></tr><tr><td>25-pin</td><td>ID 310085-xx</td></tr></table>			RS-232-C adapter	9-pin	ID 363987-xx	25-pin	ID 310085-xx
RS-232-C adapter	9-pin	ID 363987-xx						
	25-pin	ID 310085-xx						
USB	<p>The TNC 128 features USB ports for the connection of standard USB devices, such as a mouse, drives, etc. On the back panel of the MC 128 there are 2 USB 3.0 ports. One easily accessible USB 2.0 port is on the front of the unit. A cover cap protects it from contamination. The USB ports are rated for a maximum of 0.5 A.</p>							
USB cables	<table><tr><td>Cable length up to 5 m</td><td>ID 354770-xx</td></tr><tr><td>Cable length 6 m to 30 m with integrated amplifier; USB 1.1.</td><td>ID 624775-xx</td></tr></table>			Cable length up to 5 m	ID 354770-xx	Cable length 6 m to 30 m with integrated amplifier; USB 1.1.	ID 624775-xx	
Cable length up to 5 m	ID 354770-xx							
Cable length 6 m to 30 m with integrated amplifier; USB 1.1.	ID 624775-xx							

USB hub

If you need further USB ports or if the supply current is not sufficient, a USB hub is required. The USB hub from HEIDENHAIN offers four free USB 2.0 ports.

USB hub

ID 582884-xx

Voltage supply: DC 24 V/max. 300 mA



Cover

The USB hub can be installed in the operating panel in such a way that two USB ports can be accessed from the outside. An optionally available cover cap can be used to protect the ports from contamination.

Cover

ID 508921-xx

Software for data transfer

We recommend using HEIDENHAIN software to transfer files between the TNC 128 and a PC.

TNCremo (accessory)

This PC software package helps the user to transfer data from the PC to the control. The software transfers data blockwise with block check characters (BCC).

Functions:

- Data transfer (also blockwise)
- Remote control (only serial)
- File management and data backup of the control
- Reading out the log
- Print-out of screen contents
- Text editor
- Managing more than one machine

TNCremoPlus (accessory)

In addition to the features you are already familiar with from TNCremo, TNCremoPlus can also transfer the current content of the control's screen to the PC (live screen). This makes it very simple to monitor the machine.

Additional functions:

- Request of DNC data (NC up time, Machine up time, Machine running time, Spindle running time, pending errors, data from the data servers, e.g. symbolic PLC operands)
- Targeted overwriting of tool data using the values of a tool presetter

TNCremoPlus

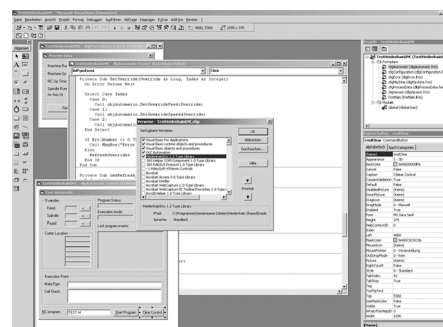
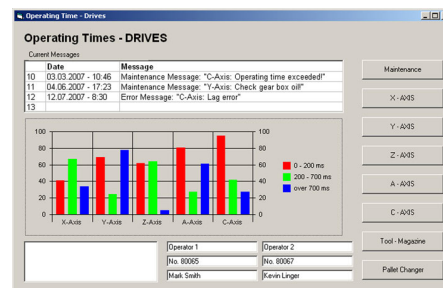
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DNC applications

Overview

The development environments on Windows operating systems are particularly well suited as flexible platforms for application development in order to come to terms with the increasingly complex requirements of the machine's environment. The flexibility of the PC software and the large selection of ready-to-use software components and standard tools in the development environment enable you to develop PC applications of great use to your customers in a very short time, for example:

- Error reporting systems that, for example, send the customer a text message to his cell phone reporting problems on the currently running machining process
- Standard or customer-specific PC software that decidedly increases process reliability and equipment availability
- Software solutions controlling the processes of manufacturing systems
- Information exchange with job management software



HEIDENHAIN DNC (option 18)

The HEIDENHAIN DNC software interface is an attractive communication platform for this purpose. It provides all the data and configuration capabilities needed for these processes so that an external PC application can evaluate data from the control and, if required, influence the manufacturing process.

RemoTools SDK (accessory)

To enable you to use HEIDENHAIN DNC effectively, HEIDENHAIN offers the RemoTools SDK development package. It contains the COM component and the ActiveX control for integration of the DNC functions in development environments.

RemoTools SDK

ID 340442-xx

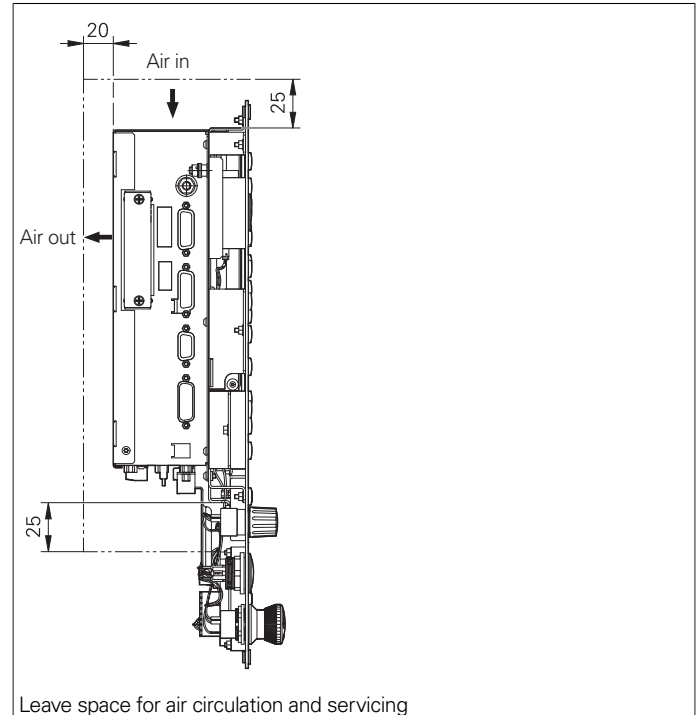
For more information, refer to the *HEIDENHAIN DNC* brochure.

Mounting information

Clearances and mounting

Proper minimum clearance

When mounting the control components, please observe proper minimum clearances, space requirements, length and position of the connecting cables.



Mounting and electrical installation

Observe the following points during mounting and electrical connection:

- National regulations for low-voltage installations at the operating site of the machine or components
- National regulations regarding interference and noise immunity at the operating site of the machine or components
- National regulations regarding electrical safety and operating conditions at the operating site of the machine or components
- Specifications for the installation position
- Specifications of the Technical Manual

Degrees of protection

The following components fulfill the requirements for IP54 (dust protection and splash-proof protection):

- TNC 128 (installed)
- Machine operating panel (installed)
- Handwheel

Electromagnetic compatibility

Protect your equipment from interference by observing the rules and recommendations specified in the Technical Manual.

Intended place of operation

This unit fulfills the requirements for EN 50370-1 and is intended for operation in industrially zoned areas.

Likely sources of interference

Interference is produced by capacitive and inductive coupling into electrical conductors or into device connections, caused by e.g.:

- Strong magnetic fields from transformers or electric motors
- Relays, contactors and solenoid valves
- High-frequency equipment, pulse equipment and stray magnetic fields from switch-mode power supplies
- Power lines and leads to the above equipment

Protective measures

- Keep a minimum distance of 20 cm from the MC, CC and its leads to devices that carry interference signals
- Keep a minimum distance of 10 cm from the MC, CC and its leads to cables that carry interference signals. For cables in metallic ducting, adequate decoupling can be achieved by using a grounded separation shield.
- Shielding according to EN 50 178
- Use equipotential bonding lines according to the grounding plan. Please refer to the Technical Manual of your control.
- Use only genuine HEIDENHAIN cables and connecting elements

Installation elevation

The maximum altitude for installation of HEIDENHAIN control components (MC, CC, PLB, MB, TE, BF, IPC, etc.) is 3000 m above sea level.

Overall dimensions

Main computer

MC 128

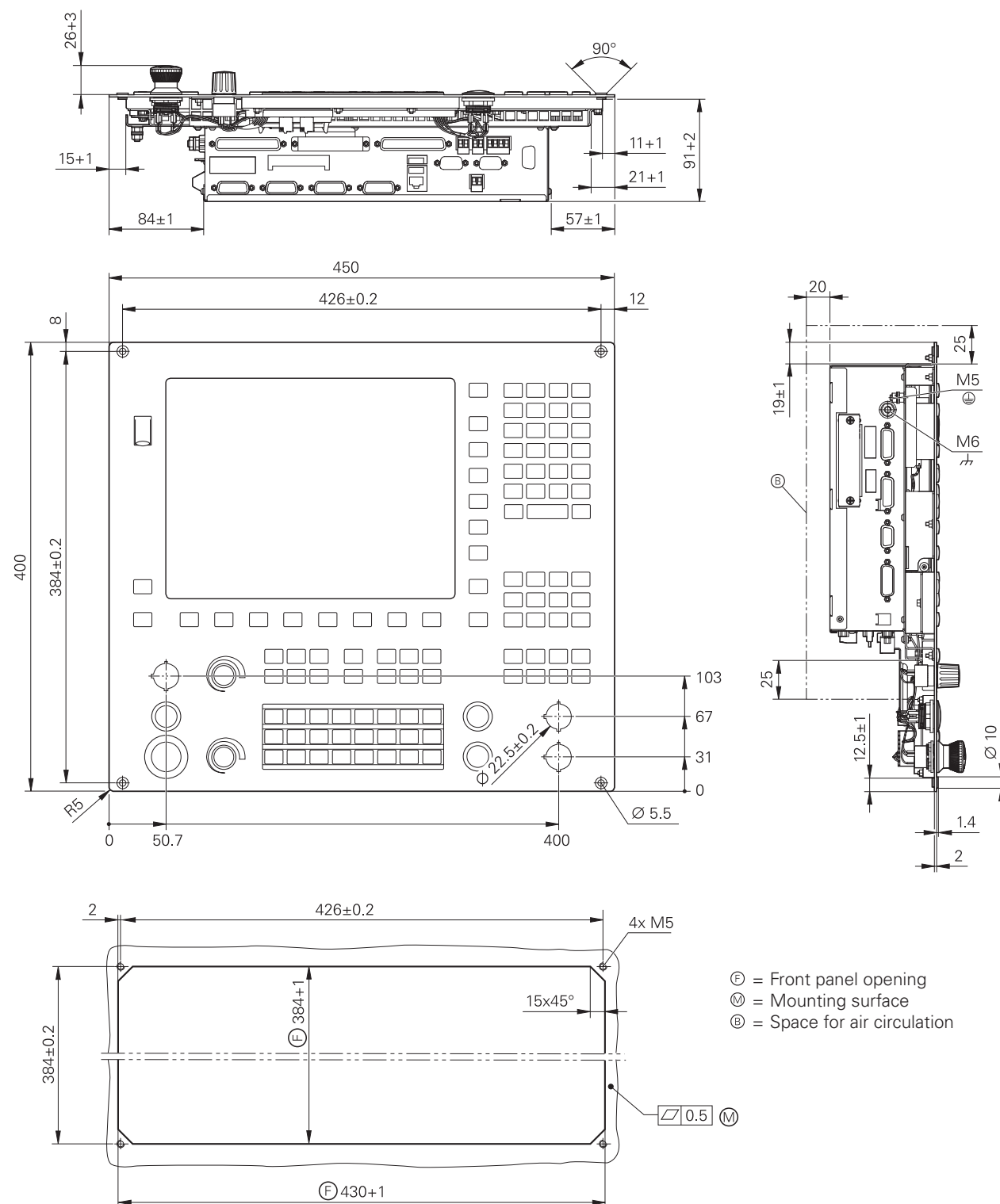
mm



Tolerancing ISO 8015

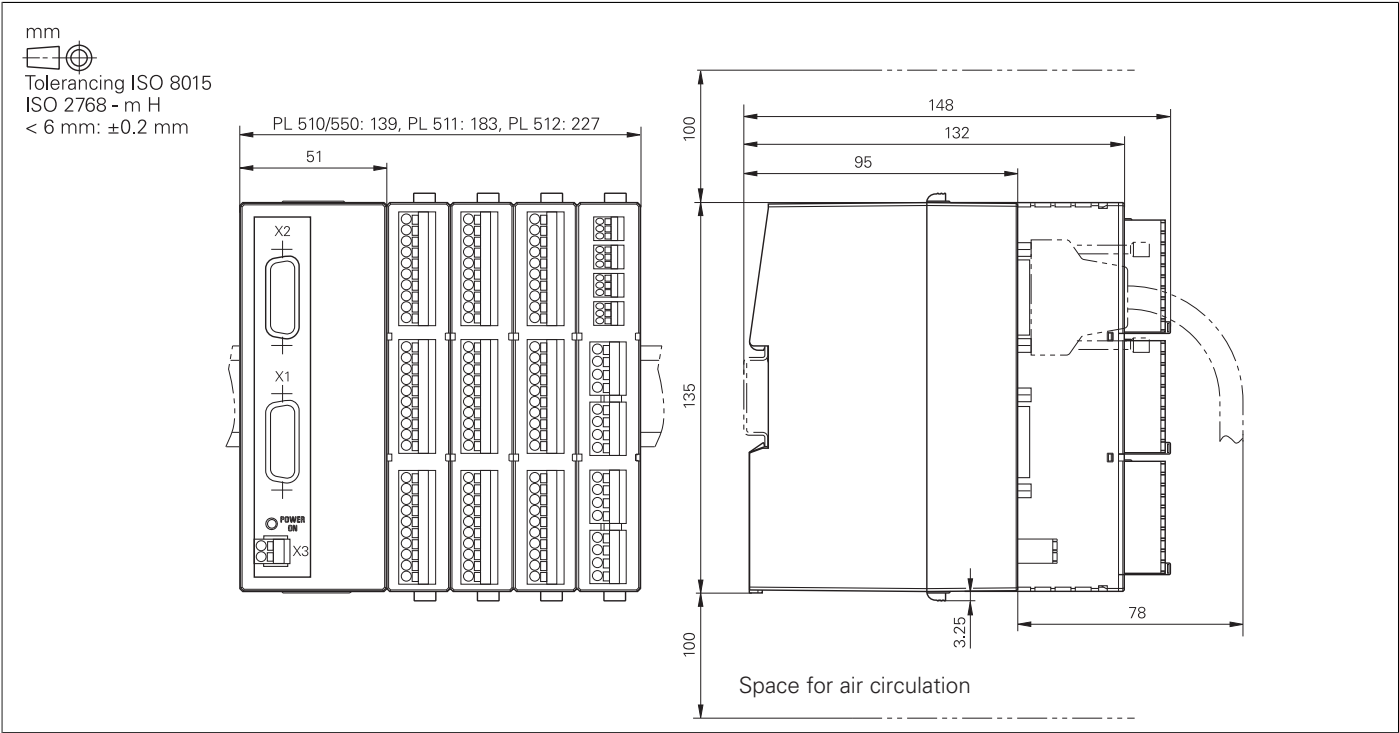
ISO 2768 - m H

< 6 mm: ± 0.2 mm



PLC inputs and outputs

PL 510



Electronic handwheels

HR 510

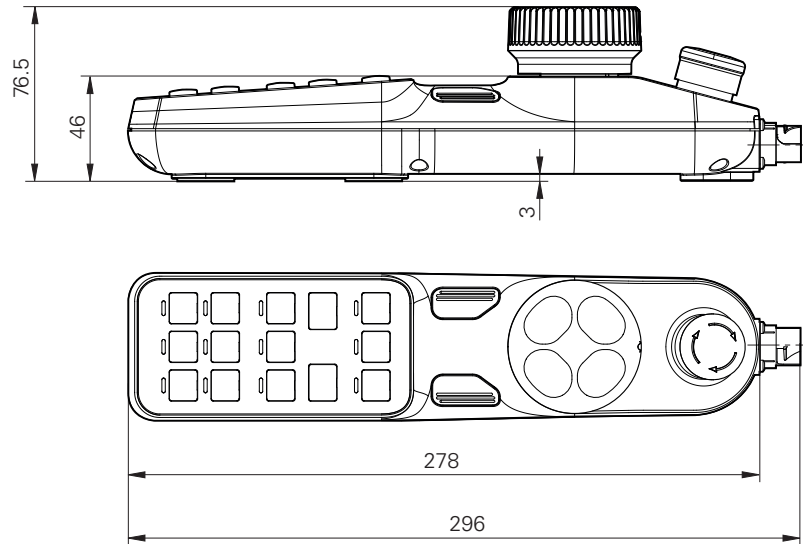
mm



Tolerancing ISO 8015

ISO 2768 - m H

< 6 mm: ± 0.2 mm



Adapter cable for HR 510 and HR 520

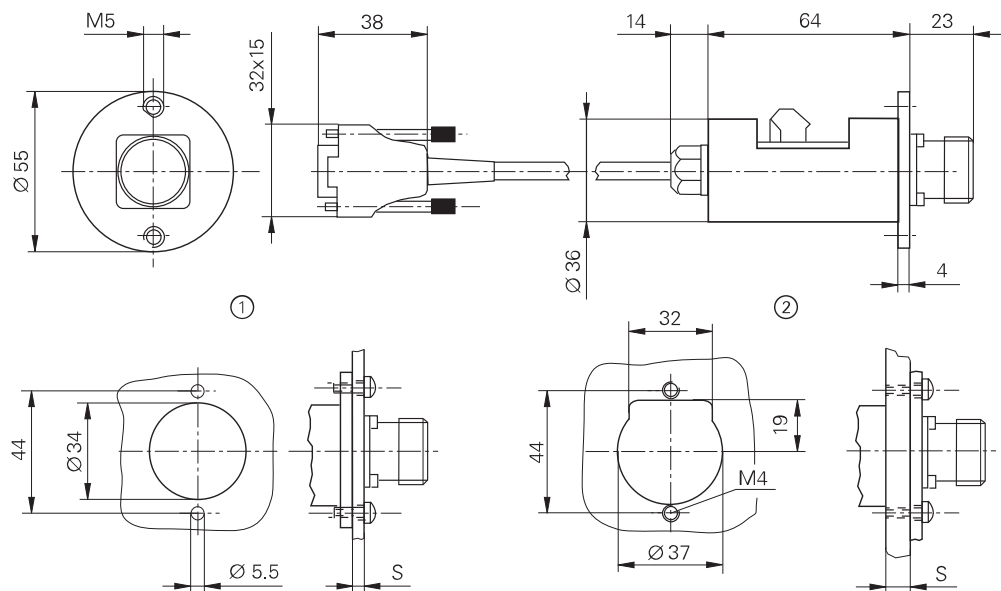
mm



Tolerancing ISO 8015

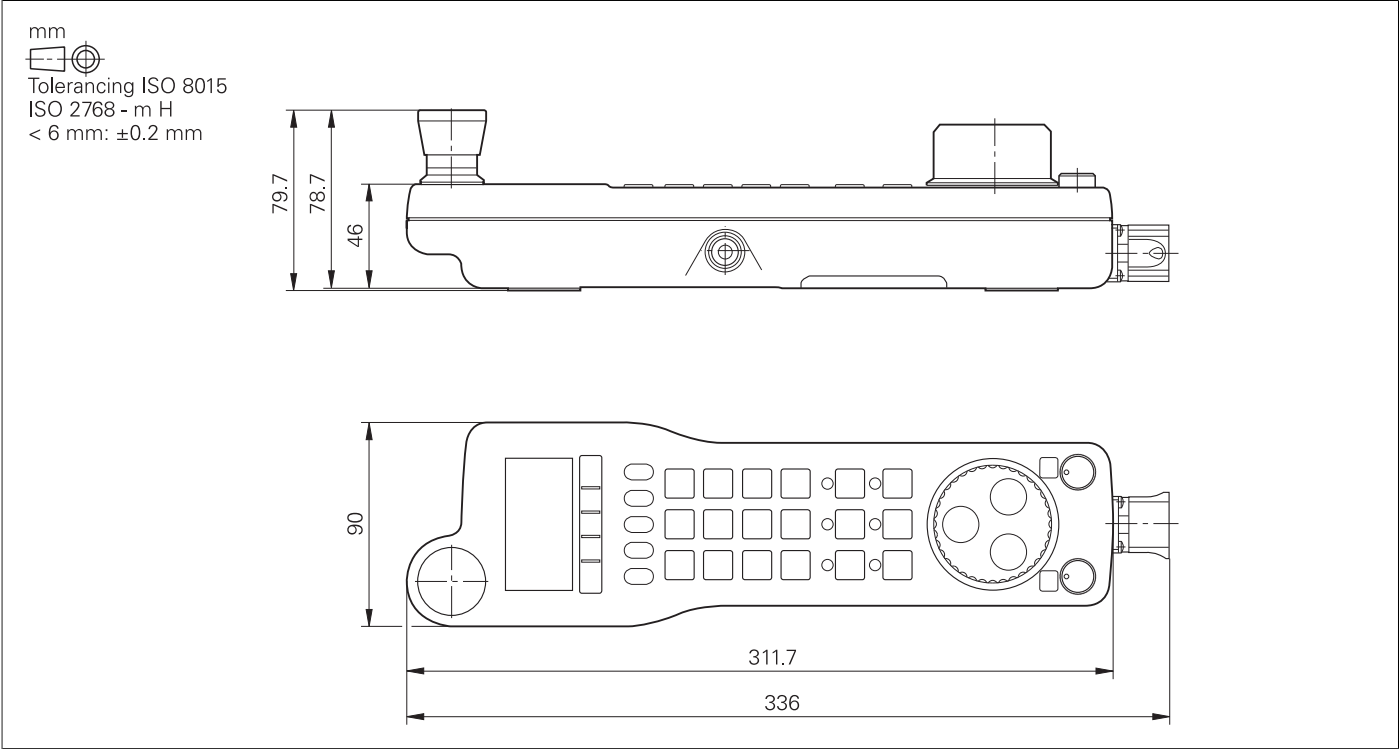
ISO 2768 - m H

< 6 mm: ± 0.2 mm

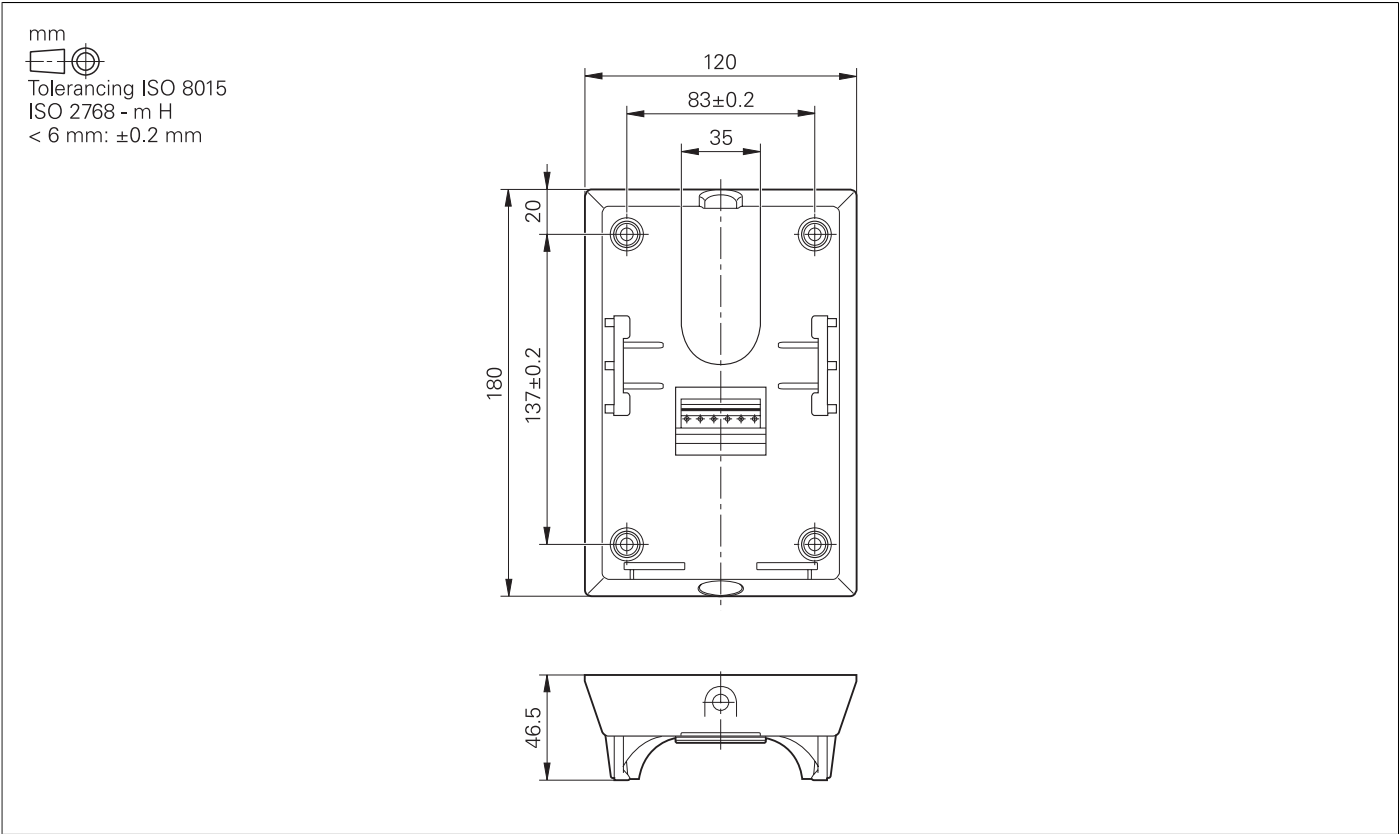


- ① Mounting opening for wall thickness S = 4 or more
- ② Mounting opening up to wall thickness S = 4

HR 520



Mount for HR 520

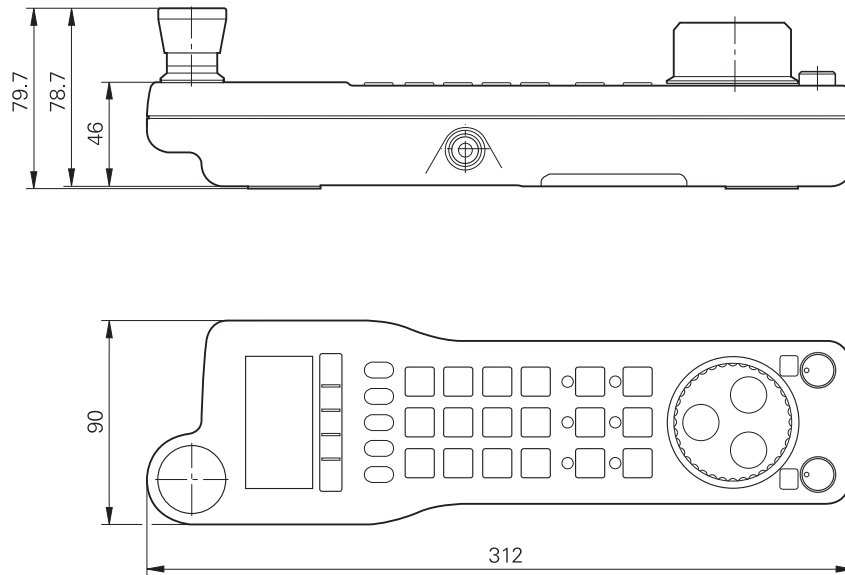


HR 550 FS

mm



Tolerancing ISO 8015
ISO 2768 - m H
< 6 mm: ± 0.2 mm

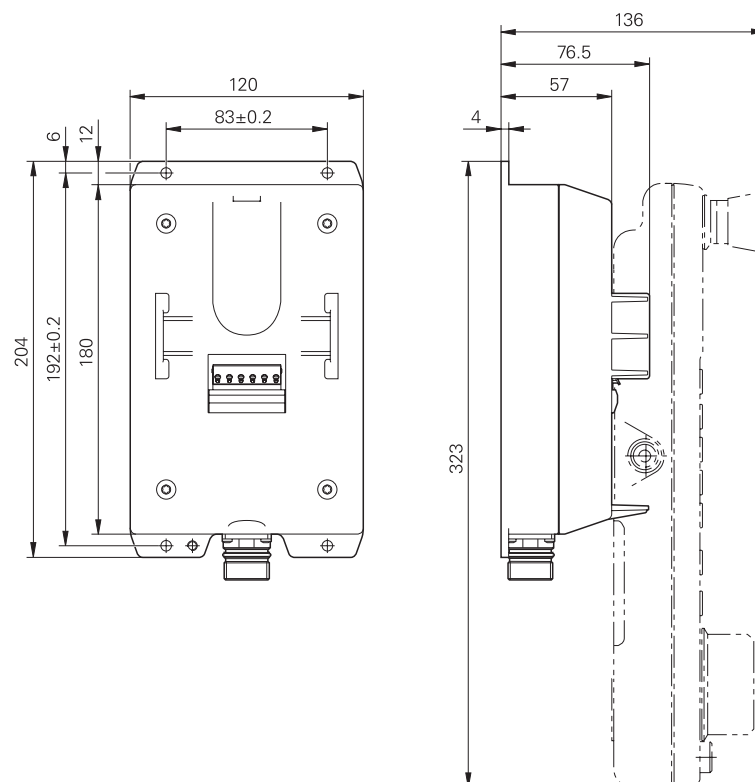


HRA 551 FS

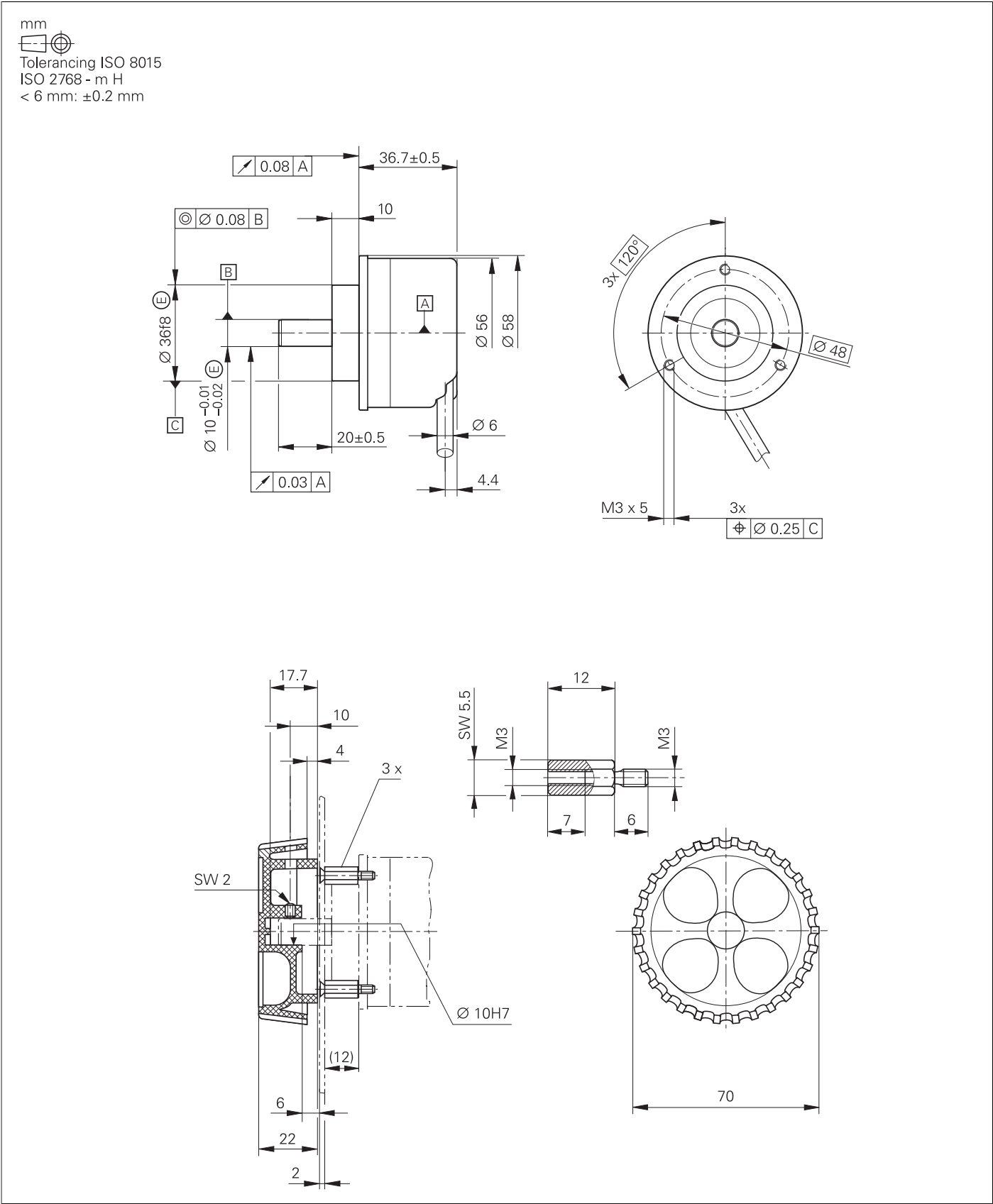
mm



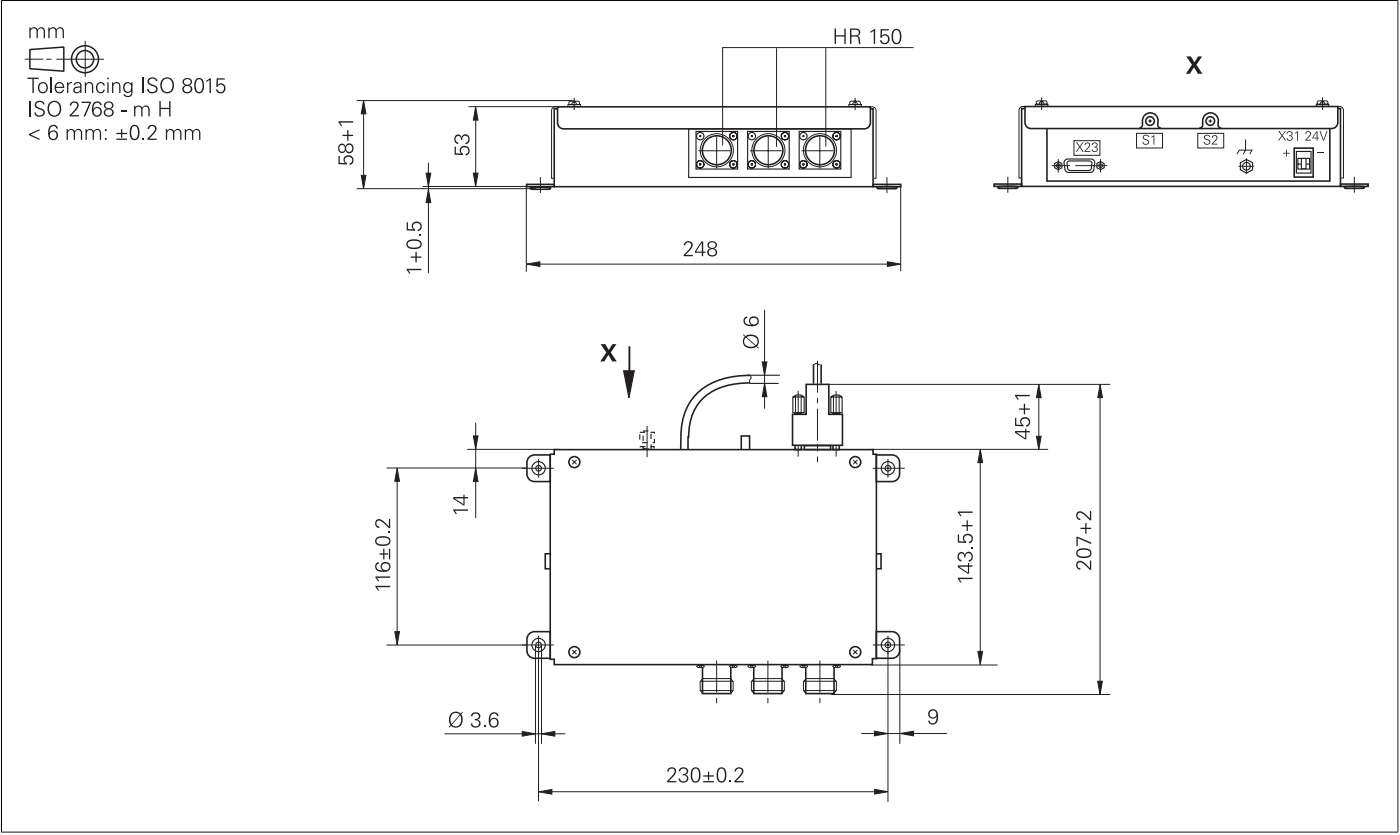
Tolerancing ISO 8015
ISO 2768 - m H
< 6 mm: ± 0.2 mm



HR 130, HR 150 with control knob

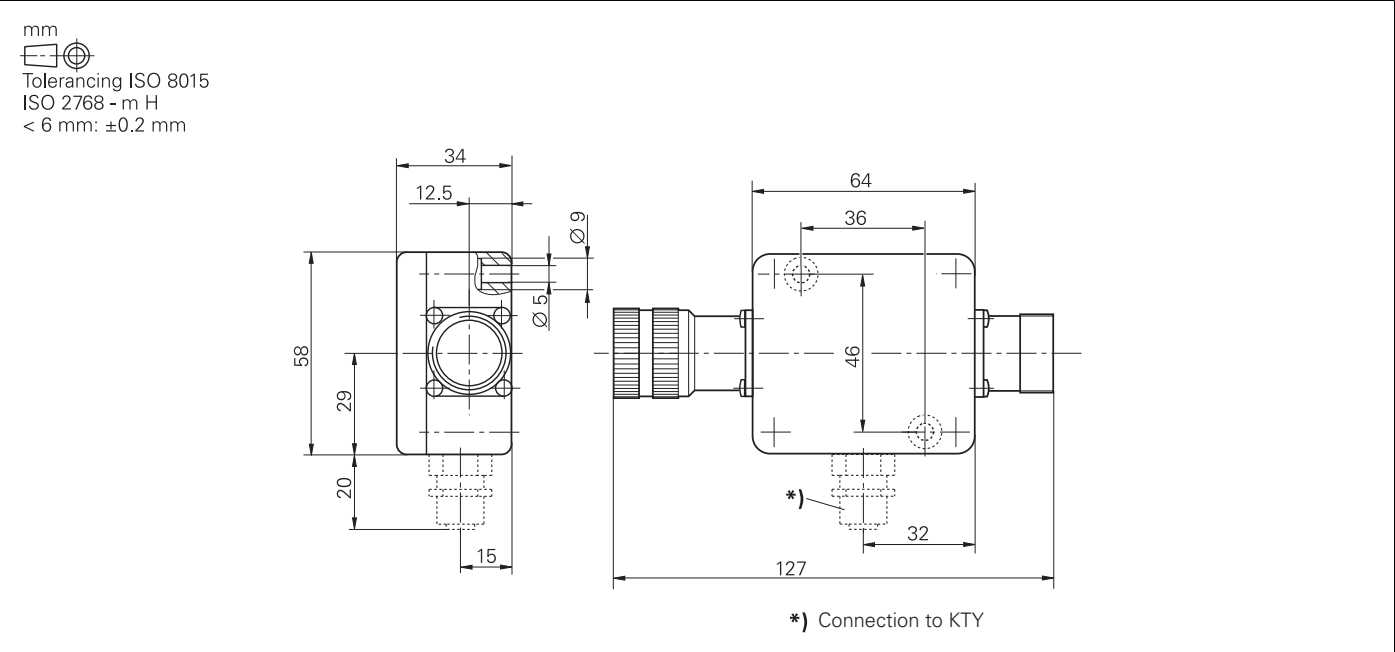


HRA 110

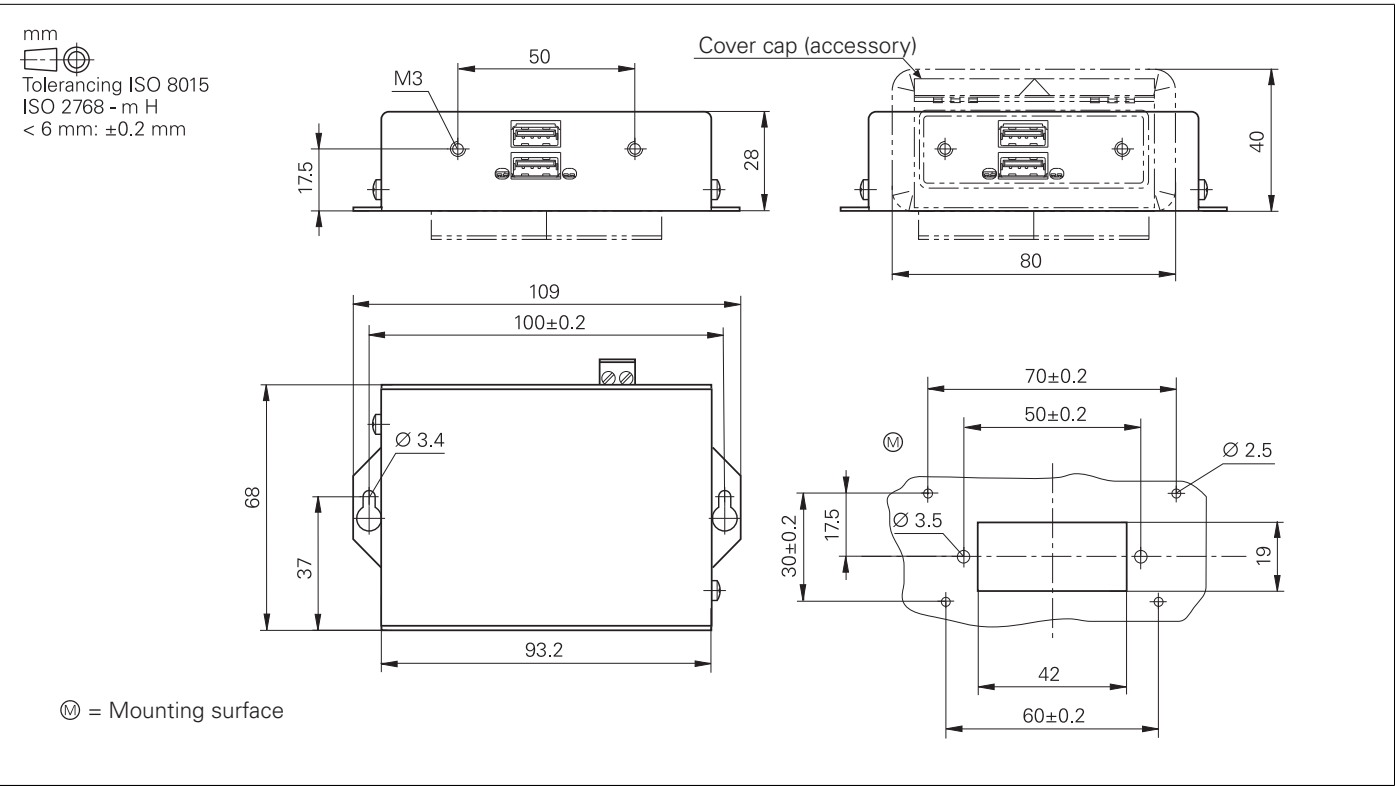


Interface accessories

Line-drop compensator for encoders with EnDat interface



USB hub



USB extension cable with hubs

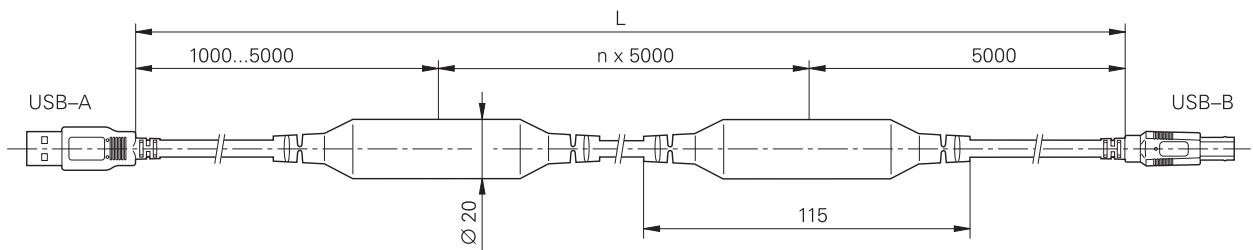
mm



Tolerancing ISO 8015

ISO 2768 - m H

< 6 mm: ± 0.2 mm



n = 0 ... 4

L = Ordering length

General information

Documentation

Technical documentation	<ul style="list-style-type: none"> • TNC 128 Technical Manual • TS 260 Mounting Instructions • TT 160 Mounting Instructions 	ID 1109223-xx; in PDF format on HESIS-Web including Filebase ID 808652-9x ID 808654-xx
User - documentation	TNC 128 <ul style="list-style-type: none"> • HEIDENHAIN Conversational Programming User's Manual Miscellaneous <ul style="list-style-type: none"> • TNCremo User's Manual • TNCremoPlus User's Manual • PLCdesign User's Manual • CycleDesign User's Manual • KinematicsDesign User's Manual 	ID 819494-xx As integrated help As integrated help As integrated help As integrated help As integrated help
Other documentation	<ul style="list-style-type: none"> • TNC 128 brochure • Touch Probes brochure • HEIDENHAIN DNC brochure • Remote Diagnosis with TeleService Product Overview • Touch Probes CD-ROM • HR 550FS Product Information 	ID 827137-xx ID 1113984-xx ID 628968-xx ID 348236-xx ID 344353-xx PDF
Safety parameters	For HEIDENHAIN products (such as control components, encoders or motors), the safety characteristics (such as failure rates, statements on fault exclusion) are available on product-specific request from your HEIDENHAIN contact person.	

Service and training

Technical support	HEIDENHAIN offers the machine manufacturer technical support to optimize the adaptation of the TNC to the machine, including on-site support.														
Exchange control system	In the event of a fault, HEIDENHAIN guarantees the rapid supply of a replacement control system (usually within 24 hours in Europe).														
Helpline	<p>Our service engineers are naturally at your disposal by telephone if you have any questions on the interfacing of the control or in the event of faults:</p> <table><tr><td>NC support</td><td>+49 8669 31-3101 E-mail: service.nc-support@heidenhain.de</td></tr><tr><td>PLC programming</td><td>+49 8669 31-3102 E-mail: service.plc@heidenhain.de</td></tr><tr><td>NC programming</td><td>+49 8669 31-3103 E-mail: service.nc-pgm@heidenhain.de</td></tr><tr><td>Encoders / machine calibration</td><td>+49 8669 31-3104 E-mail: service.ms-support@heidenhain.de</td></tr><tr><td>APP programming</td><td>+49 8669 31-3106 E-mail: service.app@heidenhain.de</td></tr></table> <p>If you have questions about repairs, spare parts or exchange units, please contact our Service Department:</p> <table><tr><td>Service, national</td><td>+49 8669 31-3121 E-mail: service.order@heidenhain.de</td></tr><tr><td>Customer service, international</td><td>+49 8669 31-3123 E-mail: service.order@heidenhain.de</td></tr></table>	NC support	+49 8669 31-3101 E-mail: service.nc-support@heidenhain.de	PLC programming	+49 8669 31-3102 E-mail: service.plc@heidenhain.de	NC programming	+49 8669 31-3103 E-mail: service.nc-pgm@heidenhain.de	Encoders / machine calibration	+49 8669 31-3104 E-mail: service.ms-support@heidenhain.de	APP programming	+49 8669 31-3106 E-mail: service.app@heidenhain.de	Service, national	+49 8669 31-3121 E-mail: service.order@heidenhain.de	Customer service, international	+49 8669 31-3123 E-mail: service.order@heidenhain.de
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Service, national	+49 8669 31-3121 E-mail: service.order@heidenhain.de														
Customer service, international	+49 8669 31-3123 E-mail: service.order@heidenhain.de														
Machine calibration	On request, HEIDENHAIN engineers will calibrate your machine's geometry, e. g. with a KGM grid encoder.														
Technical courses	<p>HEIDENHAIN provides technical customer training in the following subjects:</p> <ul style="list-style-type: none">• NC programming• PLC programming• TNC optimization• TNC service• Encoder service• Special training for specific customers <p>For more information on dates, registration, etc. call in Germany: +49 8669 31-2293 or 31-1695 +49 8669 31-1999 E-mail: mtt@heidenhain.de training.heidenhain.de</p>														

Other HEIDENHAIN controls

Examples

TNC 320

Information: TNC 320 brochure

- Compact contouring control for **milling, drilling and boring machines**
- Axes: 6 control loops, of which up to 2 are configurable as spindles
- Analog nominal-value interface to the drives (± 10 V)
- Compact design: Screen, keyboard and main computer all in one unit
- Dimensions: 400 mm x 470 mm x 105 mm
- Integrated 15-inch TFT color flat-panel display
- Storage medium for NC programs: CompactFlash memory card
- Programming in HEIDENHAIN conversational format
- Standard milling, drilling and boring cycles
- Touch probe cycles
- Short block processing time



TNC 620

Information:

TNC 620 *brochure*

- Compact contouring control for **milling, drilling and boring machines**
- Axes: 6 control loops, of which up to 2 are configurable as spindles
- For operation with HEIDENHAIN inverter systems and preferably HEIDENHAIN motors
- Uniformly digital with HSCI interface and EnDat interface
- Compact size
- Storage medium for NC programs: CompactFlash memory card
- Programming in HEIDENHAIN conversational format or according to DIN/ISO
- Standard milling, drilling and boring cycles
- Touch probe cycles
- Short block processing time (1.5 ms)

Version with touchscreen:

- 19" screen (vertical), keyboard and main computer in one unit (MC 8410)
- Integration of the keyboard in the lower screen area
- Multi-touch operation
- MC 8410 is compatible in its installation dimensions with the MC 7410

Version with operating keys:

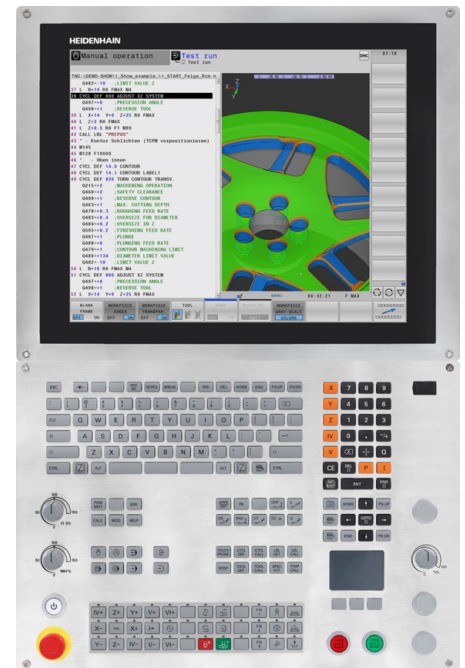
- 15" screen, keyboard and main computer in one unit (MC 7410)
- Screen and main computer in one unit (MC 7420) and separate keyboard with integrated ASCII keys



TNC 640

Information:
TNC 640 brochure

- Contouring control for **milling/turning machines and machining centers**
- Axes: 20 control loops, of which up to 4 are configurable as spindles
- For operation with HEIDENHAIN inverter systems and preferably with HEIDENHAIN motors
- Uniformly digital with HSCI interface and EnDat interface
- TFT color flat-panel display:
 - 19" or 15" versions with operating keys
 - 19" version with touchscreen for multitouch operation
- Storage medium: HDR hard disk with 160 GB or SSDR solid state disk with 32 GB
- Programming in HEIDENHAIN conversational format or according to DIN/ISO
- Comprehensive cycle package for milling and turning operations
- Constant surface speed for turning operations
- Tool-tip radius compensation
- Touch probe cycles
- Free contour programming (FK)
- Special function for fast 3-D machining
- Short block processing time (0.5 ms)



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