



Machining units with applicable functions and 5 standard programs

- Program 1:**
Rapid advance, controlled feed, retract
- Program 2:**
Rapid advance, drill, 2 × peck-feed, retract
- Program 3:**
Rapid advance, left-hand tap, reverse (with length compensation)
- Program 4:**
Rapid advance, controlled feed 1, jump, controlled feed 2, retract
- Program 5:**
Rapid advance, continuous peck-feed, retract

Feed motion is controlled with the servomotor. 43 available application commands enable programming and operation of virtually all motion profiles for a single-axis system. The AC-spindle motor can be programmed and operated with a reversing contactor for clock- and counter-clockwise rotation. Spindle speed is determined by selection of pulley sizes. Spindle motor is not controlled. Tapping operations can be done with length compensating toolholders. Positioning programming in absolute or stack-up dimensions. Multiturn absolute value encoder is standard equipment.

Note: An FI-safety device can not be used with this control system (ref. EN 50178/1994, section 5.3.2.3.).

Options:

- Extended cable length
- Special programs
- Profibus DP-interface
- Motion Manager software
- AC-frequency inverter
- Actuation for clamping
- Other languages

- For the most economical drive control package, SOMEX selected Rexroth-Indramat, a worldwide and proven supplier for digital drive components.
- The operation of 1-axis CNC control systems for the 5 most common preprogrammed applications are shown in section 5. Feed rates and spindle position are programmable with an operator interface.
- New programs can be established and keyed-in at the operator interface. Sub-routine programming is possible.
- The operator interface BTM 04 allows un-complicated step-by-step programming. Signal exchange with digital inputs and outputs. Measuring units are defined in mm, inch and degrees.

Program memory	
NC program	1000 steps
Tasks	3
Variables	400
Marker	224
Logic Task	1000
Language options	English / German
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Technical Data	
Indramat control module	DKC 21.3, DKS 1.1
Voltage	3* 230/400/460 VAC
Maximum capacity	5.5 kW
Connection cables	Plug-in cable 5 m length
Linear axis servomotor	MKD 041 / MKD 071
Measuring system: Multiturn absolute value encoder	
Spindle AC-motor	max. 3 kW
Number of inputs	7
Number of outputs	6
Language	English / German
Color	RAL 7012
Weight	54 kg
Dimensions	500/500/350

Order reference

Description / Technical Data	
IDM 1	Turnkey digital servodrive control system with OP-interface, 1 axis plug in and ready to operate one CNC machining unit. Programmable with OP-interface. Including menu-driven software and 5 m (15 ft) connection cables to the unit.
ECO 1	Hardware Kit – digital servodrive control module, 1 axis single-drive control module for the integration with main control panel including 5 m (15 ft) cables.