Milling Controller

Lathe Controller

SYNTEC
新 代 科 技

Next Generation CNC Controller

22 PLUS & 220 PLUS Series

Profile
About Syntec

Syntec Technology has long been dedicated to the research and development of both software and hardware technologies for machine tools controllers. In recent years, Syntec has expanded its product range to servo solutions, offering products such as drives, motors and encoders. These integrate seamlessly with Syntec CNC controller to deliver not only high performance servo product but also a comprehensive, one-stop solution service for machine tools. Syntec has earned customer trust through excellent after-sales service and has embraced Industrial 4.0 as a core focus of its technological development. Syntec is now one of the most influencial and promosing brands in the Asia-Pacific market.

01 Next Generation Controller

Latest design with advanced communication control & powerful performance

Brand New Design - Next Generation Controller   01

- Sleek and modern designed display screen
- Provide touch screen option for easier operation
- Available in 15' & 10' screen size for various machine models
- 15" controller features new button layout for efficient operation

- 10" controller features special compact design
- Reliable, oil & dust proof and excellent heat dissipation
- Suitable for 5-Axis machining centre & Turn-Mill machine
- Modular design and automatic system back-up

Powerful & Diversified Communication Interface   02

Serial connection, high speed and reliable

Factory Cloud Connectivity
Dual RJ-45 network ports supports both cloud connectivity and on-site tuning or diagnostics simultaneously

Syntec SRI Interface
Expandable A/D, D/A and up to 4096 I/O points through SRI communication interface (Syntec Remote Interface). Supports Modbus RS-485 communication to connect with PLC modules and inverters
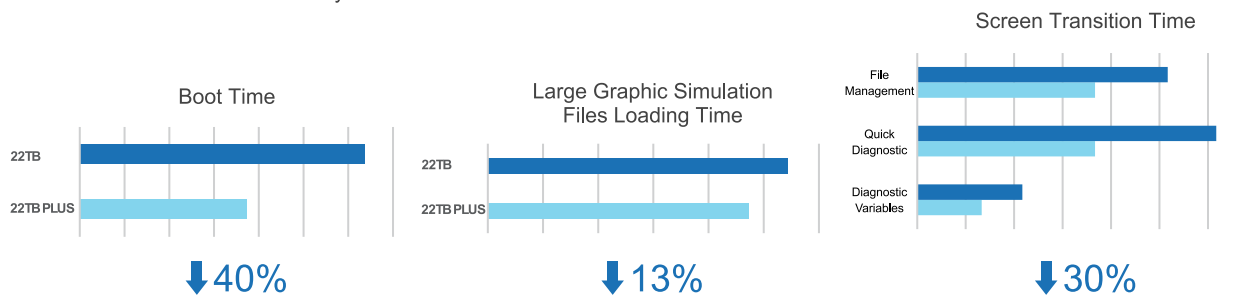
Universal CNC Controller
Supports multiple serial communication interfaces, such as Mechatrolink-III & EtherCat

MECHATROLINK   EtherCAT.

PLUS Series : Significant Performance Enhancement   03
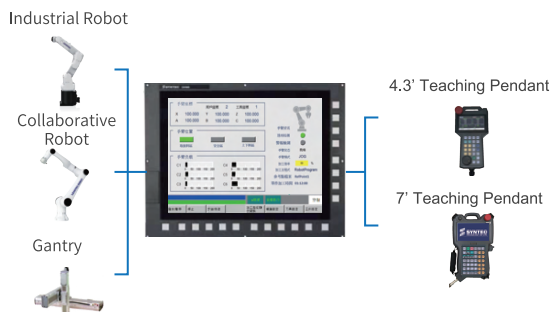
- System boot time reduced by 40%
- Large graphic simulation files loading time reduced by 13%
- Screen transition time reduced by 30%

Boot Time

22TB

22TB PLUS

⬇40%

Large Graphic Simulation Files Loading Time

22TB

22TB PLUS

⬇13%

Screen Transition Time

File Management

Quick Diagnostic

Diagnostic Variables

⬇30%

All-In-One Control   04

Industrial Robot

Collaborative Robot

Gantry

4.3' Teaching Pendant

7' Teaching Pendant

- Integration of CNC machining with pick-and-place control functionality
- Flexible robot teaching with pendant controller
- Cost effective and user friendly

Best Combination : Syntec Servo Product 05

Spindle & Multi Drives   Electro Spindle   Linear Motor

Spindle & Servo Motor   ROT Servo Turret   DD Motor

Various servo products for machine tools

- Collaborate with well known manufacturers to provide comprehensive servo products solution
- Professional tuning and services make us your best electrical control partner

03 Panel Configuration

Syntec Lathe Controller

Syntec lathe controller features integrated design, high standardization, low wiring costs and minimal space requirements, thereby enhancing cost-effectiveness. By incorporating the latest embedded architecture technology and serial communication interfaces such as Mechatrolink 3 and EtherCAT, it offers superior servo control performance and improved electromechanical integration.

15-inch Lathe Controller

Keyboard VK15
Panel ST4022T

10-inch Lathe Controller

Panel ST4025T   Keyboard VK10   Keyboard HK-900
                                  Panel 3025T   Panel 4425T2

Controller Type		Standard		Turn-Mill Machine				Multi-Path Turn-Mill Machine			
		6TA-E*	7TA	21TA-E	21TB-E	22TA PLUS	22TB PLUS	210TB-E	210TB-E5	220TB PLUS	220TB-5 PLUS
Axis No.		3(5)	3(4)	4	6(8)	4	6(8)	12(18)		12(18)	
DA		2	△	2		△		2		△	
I/O	RIO	—	64/64								
	SRI	○									
	Direct I/O	32/32	—	32/32		—		32/32		—	
Type & Size	With Panel	8"	8"	8"/10.4"		8"/10.4"/15"		8"/10.4"	10.4"	10.4"/15"	—
	With Panel (Full Flat)	—	—	—		10.4"/15"		—		10.4"/15"	
	Standalone	—	—	○		—		○	—	—	
Servo		M3/EtherCAT									
VGA		—	—	○***		—		○***		—	
Communication		Ethernet/RS485/SRI		Ethernet/RS485/SRI		Ethernet/RS485/SRI		Ethernet/RS485/SRI		Ethernet/RS485/SRI	
Multi Path		1	1	2		2		4		4	
Storage		512MB	4GB	512MB		4GB		4GB	4GB	4GB	4GB
Tilted Working Plane Machining		—	—	△				△			
RTCP		—	—	—				△			

Remarks: * NOT Available in Taiwan   ** Only available in China   *** VGA available for Standalone type only

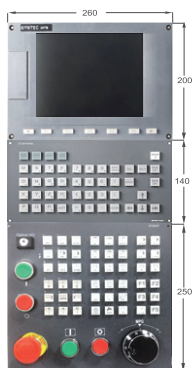○ Standard Function   △ Optional Function   - Unavailable

8-inch Lathe Controller

Panel 4018T3
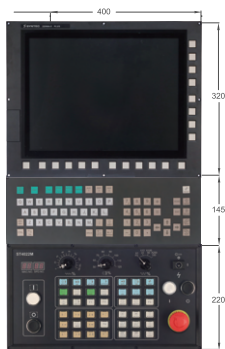
Keyboard VK8-900
Panel 2625T

Panel 4012T2

05 **Panel Configuration**

Syntec Milling Controller

Syntec Milling controller adopts the latest embedded architecture, offering high efficiency, stability, and reliability. It supports serial communication interface such as Mechatrolink 3 and EtherCAT, which not only reduce noise interference but also deliver excellent multi-axis synchronous control performance and enhanced scalability for electromechanical integration.

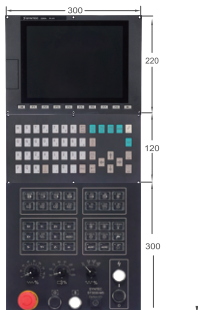## 15-inch Milling Controller

Keyboard VK15
Panel ST4022M
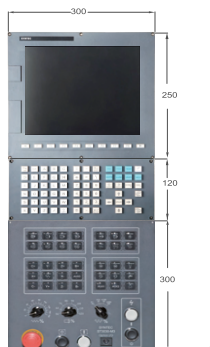

8-inch Milling Controller
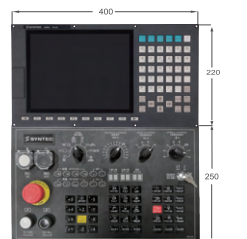
Panel 4012M

10-inch Milling Controller

Keyboard VK10
Panel 3030M5

Keyboard VK-900
Panel 3030M3

Panel 4025M

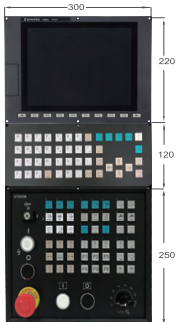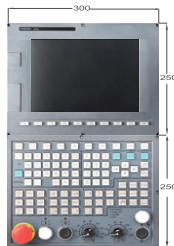| Controller Type		Standard		Multi-Function Milling		Composite Milling				Five Axis Machine			
		6MA-E	6MB-E	21MA-E	22MA PLUS	210MA-E	210MB-E	220MA PLUS	220MB PLUS	210MA-E5	210MB-E5	220MA-5 PLUS	220MB-5 PLUS
Axis No.		3	4(5)	6	6	8(9)	12(18)	8(9)	12(18)	8(9)	12(18)	8(9)	12(18)
DA		2		2	△	2		△		2		△	
I/O	RIO	64/64											
	SRI	○											
	Direct	32/32	32/32	32/32	—	32/32	32/32	—		32/32	32/32	—	
Type & Size	With Panel	8"		8"/10.4"/15'	8"/10.4"/15"	10.4"		10.4"/15"		10.4"		10.4"/15"	
	With Panel (Full Flat)	—	—	—	10.4"/15"	—		10.4"/15"		—		10.4"/15"	
	Standalone	—	○	○	—	○		—		○		—	
Servo		M3/ECAT											
VGA		—		○***	—	○***		—		○***		—	
Communication		Ethernet/RS485/SRI											
Multi Path		2		2		4		4		4		4	
Storage		4GB											
RTCP		—		—		—				△			
4-Axis RTCP		—		△		△				△			
Tilted Working Plane Machining		—		△		△				△			
HPCC		—		○		○				○			

Remarks:　* NOT Available in Taiwan　** Only available in China　*** VGA available for Standalone type only

○ Standard Function　△ Optional Function　- Unavailable

10-inch Milling Controller

Keyboard VK10
Panel 3025M

Panel SK6M

Keyboard HK-900
Panel 4421M2

07 System Components

Cloud

SynFactory
SynMachine
Public/Private Cloud Solution

Ethernet

PLUS Series Controller

Software

Analytics

- Servo Tuning
- Machine Analysis
- Oscilloscope

SYNTEC IDE

- EHMI Customization Tool
- PLC EDITOR
- SIMULATOR
- OP Log
- Parameter Editor

Serial Control Panel

Option A

RIO-BASIC I/O Module

Pulse MPG

Option B

iTB I/O Module

Syntec Servo

SPD Spindle Drive
SVD Servo Drive
SMD Multi Axis Drive
SMH Multi Axis Drive

Encoder and Expansion Module

Magnetic Encoder
Gear Encoder
Encoder Expansion Module

Motor Solution

Syntec Servo Motor
α Series Spindle Motor
β Series Spindle Motor
C Series Spindle Motor
H Series Spindle Motor

Lathe Controller

Trusted lathe controller with advanced turning function

- Complete ISO G Code, corresponds to turning and milling processes
- Friendly insertion of canned cycle enables easy programming
- MPG simulation allows user to control feed rate using MPG wheel
- Suitable for all types of lathe machining including turn-mill, auto lathe, multi-path turning center and 5 axis turn-mill lathe
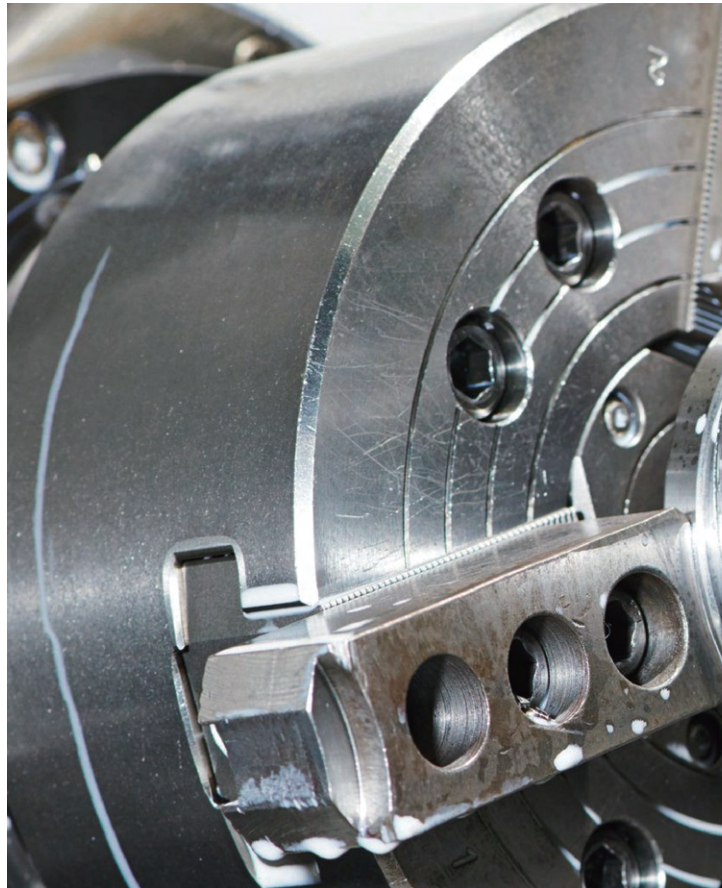
Friction Compensation (VFF)

- Reduce friction caused by direction reversal
- Easy and quick automatic parameters tuning
- Supports multiple RF.Velocity tuning (Max 5 sets), automatic compensation for different radius & feedrate
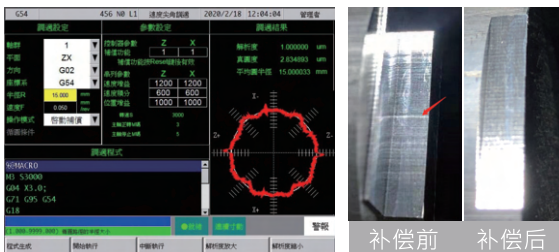
Tilted Working Plane Machining

- Intuitive and easy to program NC by rotary absolute coordinate system
- Milling, drilling, and tapping on inclined planes can be easily performed through NC program without complex CAD/CAM processing
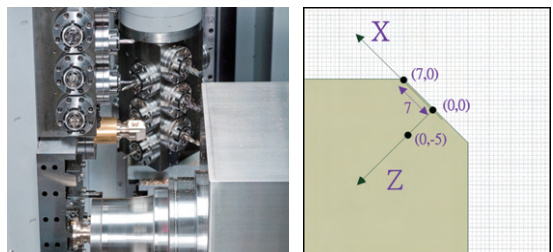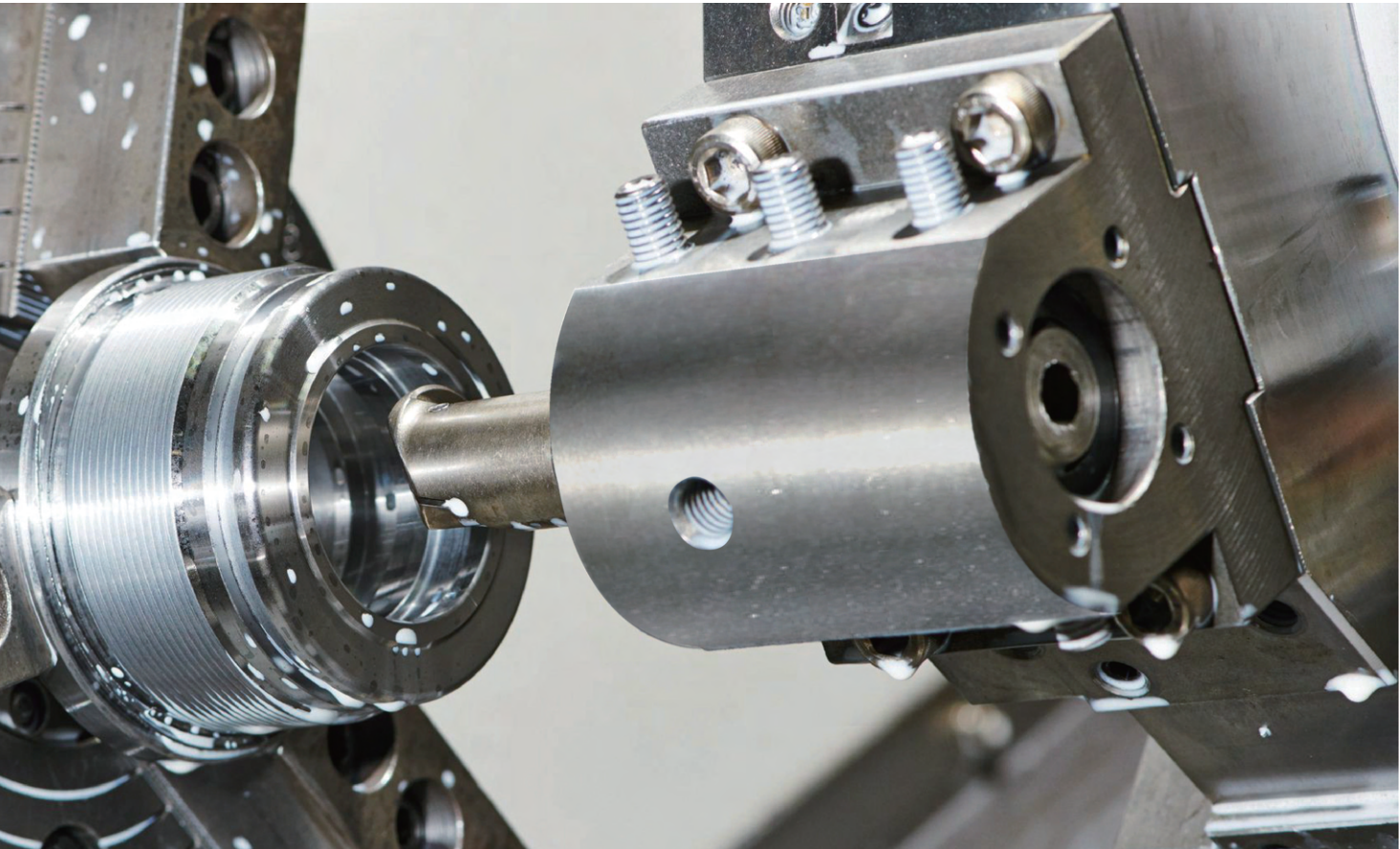
Modern HMI with Graphical Simulation

- New HMI design with unchanged operation process
- MDI function allows quick command input and execution
- Support colour configuration for different tools ID
- Support G12.1 machining path simulation (Optional)

Servo Tailstock & Auto Tool Measurement

- Torque controlled for servo tailstock with dedicated HMI
- Provides multiple force setting configuration
- Supports auto tool measurement for turning & milling tools
- Complete manual and automatic tool measurement operation
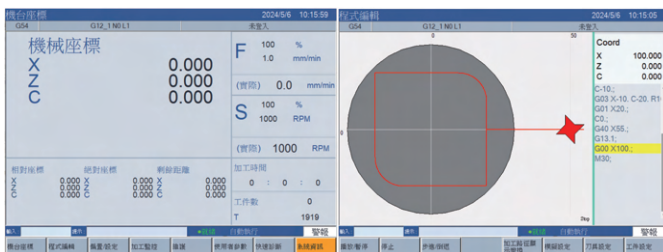
11 Milling Controller

High-performance milling controller equipped with multiple high-speed & precision features

- Powerful computing performance : Process up to 3,000 blocks per second
- High speed & precision : Servo lag compensation, high-precision trajectory control & multiple machining condition
- Flexible axis configuration : Up to 18 axes, suitable for machining centers, tapping machines, five-axis & multi-path milling machines

Tapping Center Tool Magazine Tuning

Stable Tool Change & Easy Tuning

- Dedicated interface for point teaching
- Smoother and faster tool change
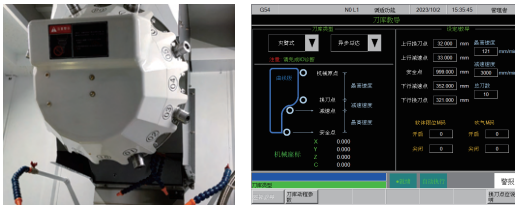
Smooth Acceleration Mode (G64.4)

High Speed High Precision

- Optimize speed for short blocks generated by CAD/CAM software, enhancing movement stability and smoothness
- Suitable for complex surface mold machining, such as wheel rim processing

Function Off

Function On
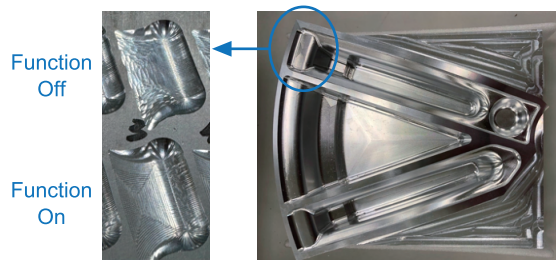
Smooth Precision Advance (SPA3.0)

Enhanced servo response boosts machining accuracy

- Eliminates servo lag and enhance arc path accuracy under high speed machining
- Improves overcut during G0 feed for cutting tools

Function Off   Function On
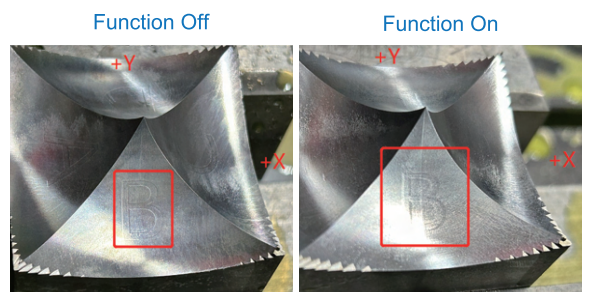
Gantry Machining Center Solution

Gantry Calibration & Balance Tuning

- Gantry calibration: Automatically aligns mechanical coordinates to improve repeatability and accuracy
- Gantry balance tuning: Aligns the load of two gantry axes to minimize twisting and distortion
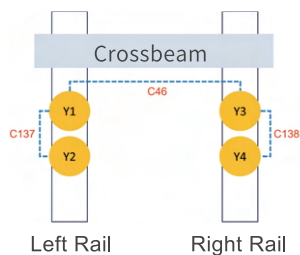
Rotary Axis Auxiliary Function

Index Table & Automatic Braking

- Index Table, prevent mechanical damage in automatic and manual mode
- Automatic Braking, auto release and engage brake without M-Code input
- Index Table can work in conjunction with the automatic brake function

Syntec reserves the right to modify product specifications if necessary
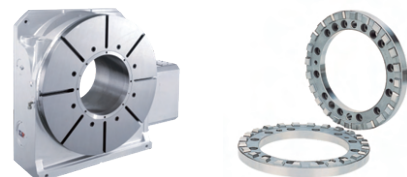
13 Milling Controller

5-Axis CNC Solution (Optional for specific models)

Rotation Tool Center Point (RTCP) 01

Scenario :

Workpiece with varying curvature, 5-Axis Machining Center, 5-Axis Woodworking Machine etc.

Instructions :

Rotation Tool Center Point (RTCP) function provides high machining precision by transferring the control target from tool holder to tool tip through five-axis compensation

RTCP(Off)   RTCP(On)
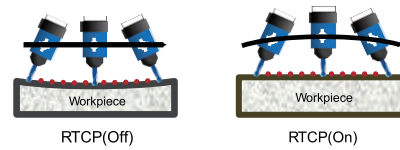
G-Code:
G43.4
G43.5

Smooth Tool Orientation 02

Scenario :

Machining issue caused by unexpected block variation in tool vector generated by CAM.

Instruction :

The controller pre-process the machining path, smoothing the tool orientation and reducing TCP jerking issue
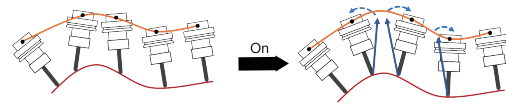
G-Code:
G43.4 L2

Feature Coordinate System 03

Scenario :

Three-axis machining on the feature plane of the workpiece

Instructions :

Also known as inclined plane coordinate system, it allows machining on any workpiece plane using three-axis machining programs without the need of complicated CAM
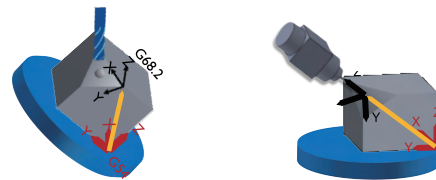
G-Code :
G68.2 X_ Y_ Z_ I_ J_ K_ ;
G68.3 X_ Y_ Z_ R_
G68.3 P1 X_ Y_ Z_

Spatial Alignment of Workpiece 04

Scenario :

No need to re-adjust or re-clamp workpiece on jig, reduce preparation time.

Instructions :

By inputting rotation angle in the workpiece coordinate system and rotation compensation can be activated in the NC program using G54.4 P1.
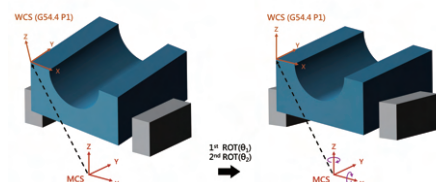
Tangential Control   05

Scenario :

Cutting tool and NC file machining path must maintain a fixed angle to cut workpiece

Instruction :

Using G41.1/G42.1, the cutting tool is maintained at a consistent angle relative to the path

direction. CAM only needs to generate TCP path (X, Y, Z).
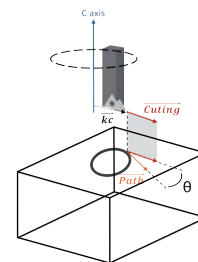
3D Tool Compensation   06

Scenario :

Compensation for tool radius or wear on the side edge is required during machining under RTCP,

without the need to regenerate machining file in CAM.

Instruction :

Using G41.2, G42.2, G41.6, and G42.6, tool radius and wear compensation can be applied to paths with

tool orientation changes, while supporting two TCP control modes, G43.4 and G43.5.
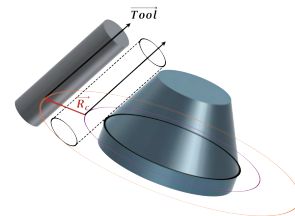
Constant Surface Speed Mode   07

Scenario :

Suitable for machining paths with small TCP displacement and large rotational axis displacement,

preventing a reduction in cutting speed that could affect the surface quality of the workpiece.

Instruction :

Constant surface cutting speed control improves cutting speed stability, while enhancing surface

accuracy and finish quality.
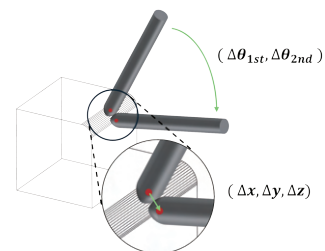
Multi Kinematic Chain   08

Scenario :

Cross head machine, stone machine and machine with multiple mechanism chain

Instruction :

Suitable for five-axis machine with multiple mechanism chain. Allow users to set

and enable multiple mechanism parameters and activation of TCP control
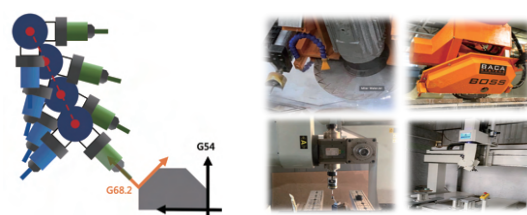
15 # Intelligent Peripherals

Syntec Servo Solutions   01

SVD/SPD Single-Axis Servo Drive

- Supports multiple serial communication encoder
- Complete electromechanical integration
- Power : 1~55 (KW)

SMD/SMH Multi-Axis Servo Drive

- Suitable for machine tool industry
- Supports up to 3+1 axis servo control
- Enhanced features (Auto tool retraction, friction compensation etc)
- Axial Power 1~3 (KW) ; Spindle Power 7.5~18.5 (KW)

AM Servo Motor

- IP67 waterproof and dustproof protection rating
- Power : 0.1~15 (KW)
- Maximum Torque : 0.32~224 (Nm)
- Maximum Speed : 2,000~6,000 (RPM)

SP Spindle Motor

- Syntec high resolution encoder, precise & stable
- IP54 waterproof and dustproof protection rating
- Power (S2) : 5.5~37.5 (KW)
- Maximum Torque : 10.4~355 (NM)
- Maximum Speed : 6,000~24,000 (RPM)
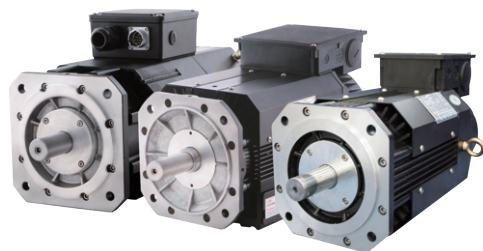
Live Tool Motor

- Designed specifically for turn-mill cutting tools
- IP67 waterproof and dustproof protection rating
- Power : 1.7~5.7 (KW)
- Rated Torque : 8~18 (NM)
- Maximum Speed : 8,000 (RPM)

Syntec Disk Type Spindle Motor

- External mounted ultra thin disk type spindle motor
- Seamless upgrade to integrated spindle motor
- Simple Structure : No bearings, no fans & no belts
- Supports usage with spindles ranging from A2-4 to A2-6
- Power (S2) : 6.3~22.5 (KW)
- Rated Torque : 17~90 (NM)
- Maximum Speed : 4,000~8,000 (RPM)

C-Series Water-Cooled Spindle Motor

- Enhanced temperature control, reduced vibration & fanless design enables excellent machining quality
- Suitable for long duration, high precision machining
- Maximum speed 12000/15000 RPM, optional central coolant outlet
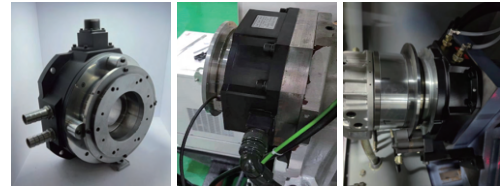
Syntec Encoder

- Support side & top connection
- High precision & resolution, suitable in harsh environment
- Resolution : 262,144~1,335,296 (Pulse)
- Poles : 64, 82, 102, 124, 162, 242, 326

Syntec reserves the right to modify product specifications if necessary

<u>17</u> Intelligent Peripherals

Controller and Drive Integration   02

Syntec controllers and drives offer extensive integrated functions, enabling servo data to be synchronized with controller in real time through Mechatrolink-3 communication interface, achieving intelligent integration between controller and drive.

Intelligent Power Failure Protection

- Controller will initiate deceleration to stop and raise the Z-axis if power outage is detected, preventing potential damage to the machine and personnel from an abrupt power loss.
- Controller will only initiate deceleration to stop in order to prevent damage to the machine during tapping or other special process
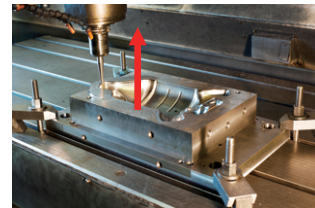
High Speed G31

- Drive reads and sends signals from probe and tool presetter to controller, achieving faster response times than I/O scanning
- Improve measurement speed & repeatability, effectively enhancing measurement efficiency.
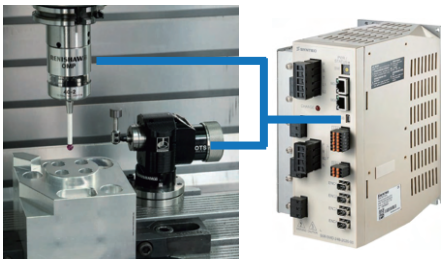
Syntec Tuning（One Step Tuning）

- Simple and fast servo tuning through controller HMI without computer
- Functions: Inertia ratio, resonance suppresion & velocity loop gain tuning

Syntec Robot Solution

81R Robot Controller
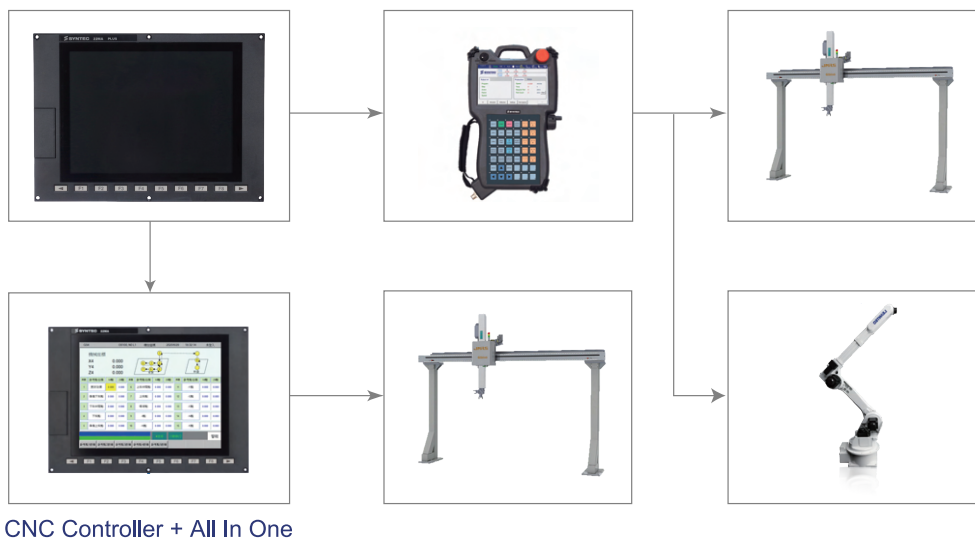
CNC Controller + All In One

81R Robot Controller	
Features	• Easy point teaching with handheld controller • User friendly tray setting interface • Suitable for complicated pick and place application
Application	• Robot arm for complicated movement • Any length of stroke • Robot arm attached to lathe machine

All In One	
Features	• Control by G-Code & M-Code • Connect to CNC directly, reduce usage of external signal • Easy to customize
Application	• Gantry attached to machine • Built-in robot

Features Introduction

• Highly integrated machine & robot, lower the barriers of automation implementation

• Friendly setting and programming GUI

• Single controller fulfills both CNC machining and gantry pick-and-place function

• Supports multiple functions such as safety zone configuration, reference point setting etc

19 Intelligent Peripherals

Intelligent Measurement 04

Syntec's tool integration module incorporates tool setters and probes, offering a variety of measurement modules. These modules are continuously updated to meet industry-specific applications, helping machining factories achieving intelligent upgrades.

Tool Measurement

Probing
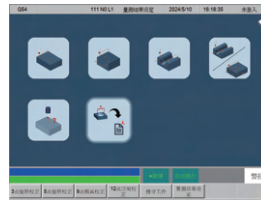
iCheck-5 (5 Axis Mechanism Chain Measurement/Analysis/Verification)
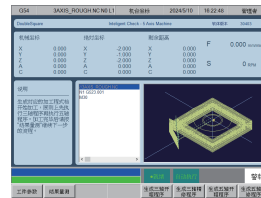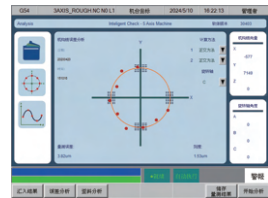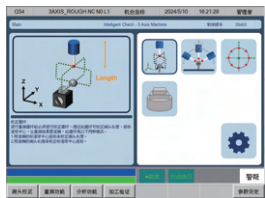
Controller Measurement Integration 05

Syntec Technology, in collaboration with Renishaw, has developed a series of user-friendly inspection GUIs that significantly simplify the measurement and inspection process, helping users effectively improve workflows and increase machining yields

Inspection Plus (Probing System Solution)
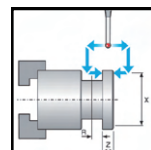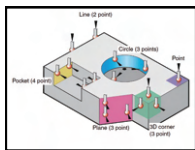
AxiSet (Multi Axis Machine Performance Inspection)

Tool Calibration Solution

SynFactory
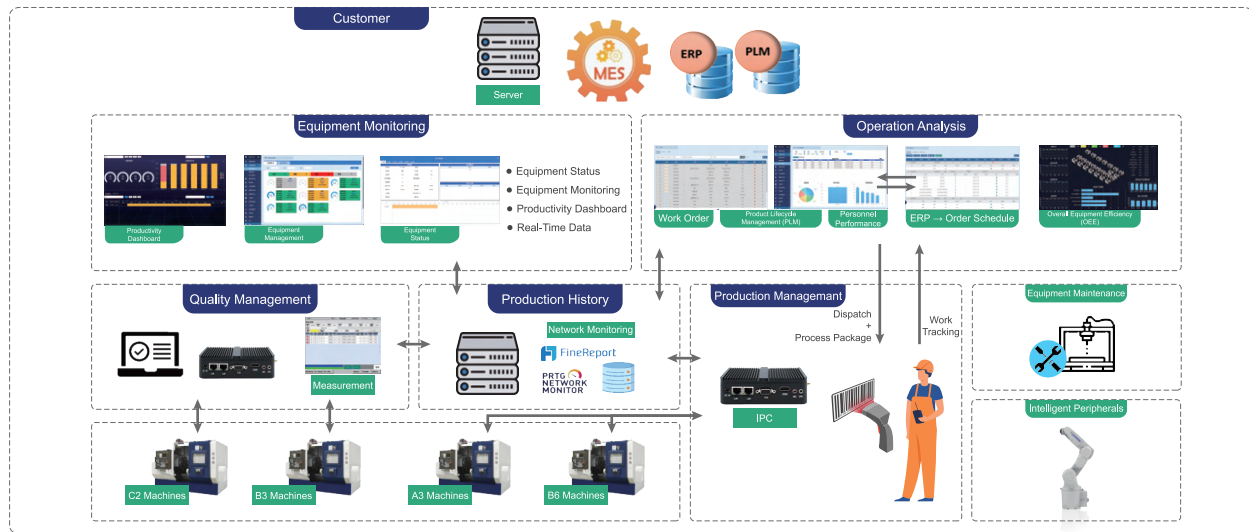
Analytic Platform

Syntec analysis software provides quick servo tuning & NC commands/feedback visualization for easy troubleshooting
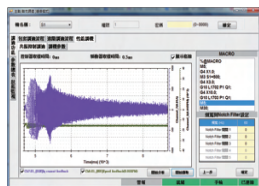
| Complete Servo Tuning | Adjacent Path Analysis | PLC Timing Analysis | 3D Curvature Analysis |
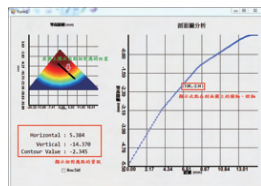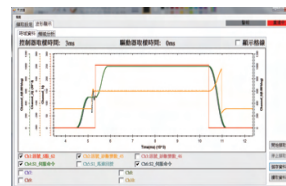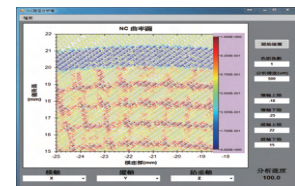
Syntec CADCAM

Syntec CADCAM offers highly integrated turn-mill technology with Syntec controller.
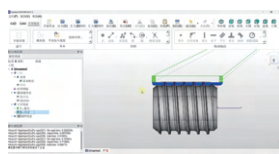
Irregular Threading   Dynamic Turning   Collision Detection
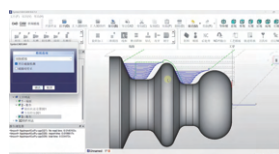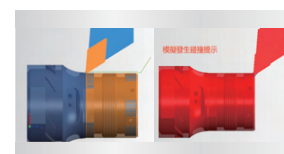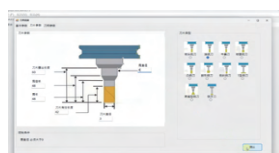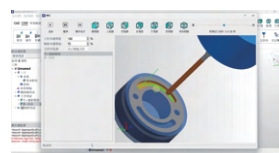
Tool Setting   End Face Interpolation Milling   Spiral Milling
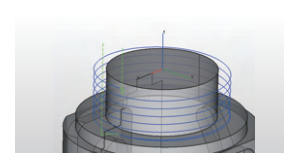
Syntec reserves the right to modify product specifications if necessary

21 Specification - Lathe

Category	Items	Unit	Remarks	6 Series*	7 Series*	21 Series	21 Series	22 Series	22 Series	210 Series	210 Series	220 Series	220 Series
				6TA-E	7TA	21TA-E	21TB-E	22TA PLUS	22TB PLUS	210TB-E	210TB-E5	220TB PLUS	220TB-5 PLUS
Product Specification	Max. Controlled Path	Path		1	1	2	2	2	2	4	4	4	4
	Max. PLC Controlled Path	Path		1	1	1	1	1	1	3	3	3	3
	Standard Axis	Axis		3	3	4	6	4	6	12	12	12	12
	Max. Axis (Optional)	Axis		5	4	4	8	4	8	18	18	18	18
	Max. Spindle	Axis		3	3	2	4	2	4	6	6	6	6
	Max. Synchronized Axis	Axis		3	3	4	4	4	4	4	5	4	5
	Min. Control Unit (mm)			0.0001	0.0001	0.0001	0.0001	0.0001	0.0001	0.0001	0.0001	0.0001	0.0001
	Workpiece Coordinate Group	Set		100	100	100	100	100	100	100	100	100	100
	Tool Compensation Group	Set		32	32	96	96	96	96	96	96	96	96
	Function Group	Set		4	4	4	4	4	4	4	4	4	4
	Block Processing Time	Block/s	Block Processing Capability	300	300	500	500	1000	1000	1000	1000	1000	1000
Hardware Specification	Storage (DISKA)	MB		4096	4096	4096	4096	4096	4096	4096	4096	4096	4096
	I/O — RIO	Point		—	64/64	64/64	64/64	64/64	64/64	64/64	64/64	64/64	64/64
	I/O — SRI				○	○	○	○	○	○	○	○	○
	I/O — Direct I/O	Point		32/32	—	32/32	32/32	—	—	32/32	32/32	—	—
	DA	Set		2	—	2	2	—	—	2	2	—	—
	Type & Size — All-in One	Inch		8"	8"	8"/10.4"	8"/10.4"	8"/10.4"/15"	8"/10.4"/15"	8"/10.4"	10.4"	10.4"/15"	15"
	Type & Size — All-in One (Full Flat)	Inch		—	—	—	—	10.4"/15"	10.4"/15"	—	—	10.4"/15"	10.4"/15"
	Type & Size — Standalone			—	—	○	○	—	—	○	—	—	—
	USB	Set		2	2	2	2	2	2	2	2	2	2
	RJ-45	Set		1	2	1	1	2	2	1	1	2	2
	VGA	Set		—	—	1***	1***	—	—	1***	—	—	—
	RS-485	Set	Back Side	1	1	1	1	1	1	1	1	1	1
	USB	Set		—	2	0	0	2	2	—	—	2	2
	SRI	Set		1	1	1	1	1	1	1	1	1	1
Servo Control	Mechatrolink III / EtherCat			○	○	○	○	○	○	○	○	○	○

Remarks： *6 Series NOT available in Taiwan; 7 Series only available in China / **Only support power head spindle application / ***VGA available on standalone type only

○ Standard Function △ Optional Function - Unavailable

Categories	Items	Instruction	Software Function	Series									
				6 Series*	7 Series*	21 Series		22 Series		210 Series		220 Series	
				6TA-E	7TA	21TA-E	21TB-E	22TA PLUS	22TB PLUS	210TB-E	210TB-E5	220TB PLUS	220TB-5 PLUS
Compensation	Backlash Compensation			O	O	O		O		O		O	
	Pitch Error Compensation			O	O	O		O		O		O	
	Quad Peak Compensation			O	O	O		O		O		O	
	2D Error Compensation			O	O	O		O		O		O	
Operation	MPG Simulation			O	O	O		O		O		O	
	Dry Run			O	O	O		O		O		O	
	Optional Stop			O	O	O		O		O		O	
	Single Block			O	O	O		O		O		O	
	Virtual MPG			O	O	O		O		O		O	
	Restart at Feed Hold			O	O	O		O		O		O	
	Restart at Break Point			O	O	O		O		O		O	
	Tool Return			—	—	—		—		—		—	
	Fixture Offset			O	O	O		O		O		O	
	MPG Offset			—	—	—		—		—		—	
Programming	Optional Skip			O	O	O		O		O		O	
	B-Stop / Program End			O	O	O		O		O		O	
	Absolute Zero Point Coordinate	G92/G92.1		O	O	O		O		O		O	
	Interrupting MACRO	M96/M97		O	O	O		O		O		O	
	M198 Call Subroutines			O	O	O		O		O		O	
	Expandable G-Code			O	O	O		O		O		O	
High Speed High Precision	Constant Jerk Control			O	O	O		O		O		O	
	Multiblock S-Curve Motion Plan			O	O	O		O		O		O	
	Auto Decceleration in Corner			O	O	O		O		O		O	
	Arc Radius Speed Limit			O	O	O		O		O		O	
	Smooth Precision Advance (SPA3.0)			—	O	O		O		O		O	
	Virtual Radius Function			O	O	O		O		O		O	

Remarks： *6 Series NOT available in Taiwan; 7 Series only available in China　/　**Only support power head spindle application
　/　***VGA available on standalone type only
　○ Standard Function　△ Optional Function　- Unavailable

23

Categories	Items	Instruction	Software Function	Series										
				6 Series*	7 Series*	21 Series		22 Series		210 Series		220 Series	
				6TA-E	7TA	21TA-E	21TB-E	22TA PLUS	22TB PLUS	210TB-E	210TB-E5	220TB PLUS	220TB-5 PLUS
Tool Management	Tool Wear Detection			O	O	O		O		O		O	
	Tool Life Management			O	O	O		O		O		O	
Tool Turret	ROT Servo Turret	PLC Component		O	O	O		O		O		O	
Spindle	Support Syntec Spindle			—(**)	O	O		O		O		O	
Operation	Machine Lock (R Bit)			O	O	O		O		O		O	
	Software Limit			O	O	O		O		O		O	
	Spindle Speed Arrival Check			O	O	O		O		O		O	
	Axial Coupling			O	O	O		O		O		O	
	Dynamic Axial Coupling			O	O	O		O		O		O	
	Coupling Feedback			O	O	O		O		O		O	
	Tapping Retraction			O	O	O		O		O		O	
	Virtual Axis			—	—	—		—		—		—	
	Axis Change			O	O	O		O		O		O	
	Axial Torque Limit			—	—	—		—		—		—	
	Serial Tuning (CNC Axis)			O	O	O		O		O		O	
	Drive Information Display (CNC Axis)			O	O	O		O		O		O	
	Spindle Adjustment Tuning (CNC Axis)			O	O	O		O		O		O	
	Serial PLC Axis			O	O	O		O		O		O	
	High Speed Spindle Positioning	Syntec Spindle		O	O	O		O		O		O	
	Data Backup & Recovery	Maker Backup		O	O	O		O		O		O	
	Customized Boot Screen			O	O	O		O		O		O	
	My Favourites	Only support ARM 8 key system		O	O	O		O		O		O	
	Project Protection Features			O	O	O		O		O		O	
	Access Control Management			O	O	O		O		O		O	
	Remote AP Monitoring			—	O	O		O		O		O	
Program Edit	Background Edit			O	O	O		O		O		O	
	Edit Protection			O	O	O		O		O		O	
	Real-Time Program Syntax Check			O	O	O		O		O		O	
PLC	PLC Diagnose (Force I Point)			O	O	O		O		O		O	

Remarks： *6 Series NOT available in Taiwan; 7 Series only available in China / **Only support power head spindle application
/ ***VGA available on standalone type only
○ Standard Function   △ Optional Function   - Unavailable

Categories	Items	Instruction	Software Function	6 Series* 6TA-E	7 Series* 7TA	21 Series 21TA-E	21TB-E	22 Series 22TA PLUS	22TB PLUS	210 Series 210TB-E	210TB-E5	220 Series 220TB PLUS	220TB-5 PLUS
Data Transfer	Network			O	O	O		O		O		O	
	FTP			O	O	O		O		O		O	
	RS-485	PLC Component		O	O	O		O		O		O	
	DNC (Network)			O	O	O		O		O		O	
	DNC (USB)			O	O	O		O		O		O	
Information Display	Operation History Display			O	O	O		O		O		O	
	Graphic Simulation			O	O	O		O		O		O	
	Partial Graphic Simulation			O	O	O		O		O		O	
	Dynamic Multilingual Switching			O	O	O		O		O		O	
G Code	Arc Interpolation (CW/CCW)	G02, G03		O	O	O		O		O		O	
	Ellipse Interpolation	G02.1		O	O	O		O		O		O	
	Parabola Interpolation	G02.2		—	—	—		—		—		—	
	Cylinder Interpolation	G07.1		O	O	O		O		O		O	
	Polar Coordinate Interpolation	G12.1		—	—	—		—		—		—	
	Outer(Inner) Surface Turning Cycle	G20		O	O	O		O		O		O	
	Threading Cycle	G21		O	O	O		O		O		O	
	Mid-Section Threading Cycle	G21.2		O	O	O		O		O		O	
	End Face Turning Cycle	G24		O	O	O		O		O		O	
	Skip Function	G31		O	O	O		O		O		O	
	Thread Cutting	G33		O	O	O		O		O		O	
	Variable Pitch Thread Cutting	G34		O	O	O		O		O		O	
	Polygon Cutting	G51.2		O	O	O		O		O		O	
	Work Coordinate System	G54~G59.9		O	O	O		O		O		O	
	Enable/Disable Turret Mirror Function	G68		O	O	O		O		O		O	
	Complex Canned Cycle	G72~G78		—	O	O		O		O		O	
	Canned Cycle for Drilling	G80, G83~G89		O	O	O		O		O		O	
	Reset Absolute Coordinate System	G92.1		O	O	O		O		O		O	
	Inverse Time Feed	G93		—	—	—		—		O		O	
	Constant Surface Speed Control	G96		O	O	O		O		O		O	

Categories	Items	Instruction	Software Function	6 Series* 6TA-E	7 Series* 7TA	21 Series 21TA-E	21 Series 21TB-E	22 Series 22TA PLUS	22 Series 22TB PLUS	210 Series 210TB-E	210 Series 210TB-E5	220 Series 220TB PLUS	220 Series 220TB-5 PLUS
G Code	Enable/Disable Spindle Synchronization	G114.1		—	—	○	○	○	○	○	○	○	○
G Code	Enable/Disable Spindle Superimposition	G114.3		—	—	○	○	○	○	○	○	○	○
Five Axis	Feature Coordinate (Tilted Plane Machining)	G68.2 G68.3	OP13	—	—	△	△	△	△	△	△	△	△
Five Axis	Five Axis RTCP	G43.4 G43.5	OP12	—	—	—	—	—	—	△	△	△	△
Five Axis	Multiple Kinematic Chain Group	GG10 L5000 P_ Q_	OP27	—	—	△	△	△	△	△	△	△	△
Five Axis	Intelligent Check - 5		OP46	—	—	—	—	—	—	—	△	—	△
Five Axis	3D Tool Compensation	G41.1/G41.2 G41.6/G42.6	OP61	—	—	—	—	—	—	—	—	—	△
Turn-Mill	New HMI		MID-24	—	—	—	—	△	△	△	△	△	△
Turn-Mill	Auto Tool Measurement		MID-24	—	—	—	—	△	△	—	—	△	△
Turn-Mill	G12.1 Graphic Simulation		MID-24	—	—	—	—	△	△	—	—	△	△
Turn-Mill	Basic Thermal Compensation		MID-24	—	—	—	—	△	△	—	—	△	△
Turn-Mill	Servo Tailstock		MID-24	—	—	—	—	△	△	—	—	△	△
Turn-Mill	Disc Type Spindle Dynamic Balancing		MID-24	—	—	—	—	△	△	—	—	△	△
Turn-Mill	Abnormal Disturbance Torque Protection	DTRQ	MID-24	—	—	—	—	△	△	—	—	△	△
Turn-Mill	Advanced Look-Ahead for Turn-Mill	High BPT Performance	OP33	—	—	△	△	△	△	△	△	△	△
Others	Smart Thermal Compensation	Spindle	OP49	△	△	△	△	△	△	△	△	△	△
Others	Smart Thermal Compensation (Axis)	Axis	OP50	△	△	△	△	△	△	△	△	△	△
Others	ROT Servo Turret	PLC Component	OP32	○	○	○	○	○	○	○	○	○	○
Others	All-in-One Gantry		OP20	△	△	△	△	△	△	△	△	△	△

Remarks： *6 Series NOT available in Taiwan; 7 Series only available in China   / **Only support power head spindle application
/ ***VGA available on standalone type only
○ Standard Function   △ Optional Function   - Unavailable

Specification - Milling

Categories	Items		Unit	Remarks	Standard		Functional Milling		Compound Milling Machine							
					6 Series		21 Series	22 Series	210 Series				220 Series			
					6MA-E	6MB-E	21MA-E	22MA PLUS	210MA-E	210MA-E5	210MB-E	210MB-E5	220MA PLUS	220MA-5 PLUS	220MB PLUS	220MB-5 PLUS
Product Specification	Max. Controlled Path		Path		2	2	2	2	4				4			
	Max. PLC Controlled Path		Path		1	1	1	1	3				3			
	Standard Axis		Axis		3	4	6	6	8		12		8		12	
	Max. Axis (Optional)		Axis		3	5	6	6	9		18		9		18	
	Max. Spindle		Axis		3	5	4	4	6				6			
	Max. Synchronized Axis		Axis		3	4	4	4	4	5	4	5	4	5	4	5
	Min. Control Unit (mm)				0.0001		0.0001	0.0001	0.0001				0.0001			
	Workpiece Coordinate Group		Path		100		100	100	100				100			
	Tool Compensation Group		Path		96		200	200	200				200			
	Function Group		Path		4		4	4	4				4			
	Block Processing Time		Block/s	Block Processing Capability	600		2500	3000	3000	4000	3000	4000	3000	4000	3000	4000
Hardware Specification	Storage (DISKA)		MB		4096		4096	4096	4096				4096			
	I/O	RIO	Point		—		64/64	64/64	64/64				64/64			
		SRI			O		O	O	O				O			
		Direct I/O	Point		32/32		32/32	—	32/32				—			
	DA		Set		2		2	—	2				—			
	Type & Size	All-in One	Inch		8"		8"/10.4"/15"		10.4"				10.4"/15"			
		All-in One (Full Flat)	Inch		—		—	10.4"/15"	—				10.4"/15"			
		Standalone			—		O	—	O				—			
	CF Card		Set	Front Side	—		—	—	—				—			
	USB		Set		2		2	2	2				2			
	CF Card		Set		—		—	—	—				—			
	RJ-45		Set		1		1	2	1				2			
	VGA		Set	Back Side	—		1*	—	1*				—			
	RS-485		Set		1		1	1	1				1			
	USB		Set		—		—	2	—				2			
	SRI		Set		1		1	1	1				1			
Servo Control	Mechatrolink III / EtherCat				O		O	O	O				O			

Remarks： *6 series Not available in Taiwan; **Only available in China / ***VGA available on standalone type only

　　　　○ Standard Function　　△ Optional Function　　- Unavailable

Categories	Items	Instruction	Standard 6 Series 6MA-E	6MB-E	Functional Milling 21 Series 21MA-E	22 Series 22MA PLUS	Compound Milling Machine 210 Series 210MA-E	210MA-E5	210MB-E	210MB-E5	220 Series 220MA PLUS	220MA-5 PLUS	220MB PLUS	220MB-5 PLUS
Compensation	Backlash Compensation		O	O	O	O	O	O	O	O	O	O	O	O
	Pitch Error Compensation		O	O	O	O	O	O	O	O	O	O	O	O
	Quad Peak Compensation		O	O	O	O	O	O	O	O	O	O	O	O
	2D Error Compensation		O	O	O	O	O	O	O	O	O	O	O	O
Operation	MPG Simulation		O	O	O	O	O	O	O	O	O	O	O	O
	Dry Run		O	O	O	O	O	O	O	O	O	O	O	O
	Optional Stop		O	O	O	O	O	O	O	O	O	O	O	O
	Single Block		O	O	O	O	O	O	O	O	O	O	O	O
	Virtual MPG		O	O	O	O	O	O	O	O	O	O	O	O
	Restart at Feed Hold		O	O	O	O	O	O	O	O	O	O	O	O
	Restart at Break Point		O	O	O	O	O	O	O	O	O	O	O	O
	Tool Return		O	O	O	O	O	O	O	O	O	O	O	O
	Fixture Offset		O	O	O	O	O	O	O	O	O	O	O	O
	MPG Offset		O	O	O	O	O	O	O	O	O	O	O	O
Programming	Optional Skip		O	O	O	O	O	O	O	O	O	O	O	O
	B-Stop / Program End		O	O	O	O	O	O	O	O	O	O	O	O
	Absolute Zero Point Coordinate	G92/G92.1	O	O	O	O	O	O	O	O	O	O	O	O
	Interrupt MACRO	M96/M97	O	O	O	O	O	O	O	O	O	O	O	O
	M198 Call Subroutines		O	O	O	O	O	O	O	O	O	O	O	O
	Expandable G-Code		O	O	O	O	O	O	O	O	O	O	O	O
High Speed High Precision (HSHP)	Constant Jerk Control		O	O	O	O	O	O	O	O	O	O	O	O
	Auto Decceleration in Corner		O	O	O	O	O	O	O	O	O	O	O	O
	Arc Radius Speed Limit		O	O	O	O	O	O	O	O	O	O	O	O
	Multiple HSHP Machining Parameters		—	—	O	O	O	O	O	O	O	O	O	O
	Smooth Precision Advance (SPA3.0)		O	O	O	O	O	O	O	O	O	O	O	O
	Virtual Radius Function		O	O	O	O	O	O	O	O	O	O	O	O
	HSHP Control Mode I	G05.1Q1	—	—	O	O	O	O	O	O	O	O	O	O
	NURBS Interpolation		—	—	O	O	O	O	O	O	O	O	O	O

Remarks： *6 series NOT available in Taiwan; **Only available in China / ***VGA available on standalone type only

○ Standard Function　△ Optional Function　- Unavailable

Categories	Items	Instruction	Standard		Functional Milling		Compound Milling Machine							
			6 Series		21 Series	22 Series	210 Series				220 Series			
			6MA-E	6MB-E	21MA-E	22MA PLUS	210MA-E	210MA-E5	210MB-E	210MB-E5	220MA PLUS	220MA-5 PLUS	220MB PLUS	220MB-5 PLUS
Tool Management	Auto Tool Measuring		O		O	O	O				O			
	Tool Life Management		O		O	O	O				O			
Tool Magazine	ATC Auto Tool Change		—		O	O	O				O			
Spindle	Support Syntec Spindle		—		O	O	O				O			
Support Functions	Machine Lock (R Bit)		O		O	O	O				O			
	Software Limit		O		O	O	O				O			
	Spindle Speed Arrival Check		O		O	O	O				O			
	Axis Coupling		O		O	O	O				O			
	Dynamic Axis Coupling		O		O	O	O				O			
	Coupling Feedback		O		O	O	O				O			
	Tapping Retraction		O		O	O	O				O			
	Virtual Axis		O		O	O	O				O			
	Axis Change		O		O	O	O				O			
	Axial Torque Limit		O		O	O	O				O			
	Serial Tuning (CNC Axis)		O		O	O	O				O			
	Drive Information Display (CNC Axis)		O		O	O	O				O			
	Spindle Adjustment Tuning (CNC Axis)		O		O	O	O				O			
	Serial PLC Axis		O		O	O	O				O			
	Data Backup & Recovery	Maker Backup	O		O	O	O				O			
	Customized Boot Screen		O		O	O	O				O			
	My Favourites	Only support ARM 8 key system	O		O	O	O				O			
	Project Protection Features		—		O	O	O				O			
	Limit Access Manager		O		O	O	O				O			
	Teaching & Measurement		—		—	O	—				O			
	Remote AP Monitoring		O		O	O	O				O			
Program Edit	Background Edit		O		O	O	O				O			
	Edit Protection		O		O	O	O				O			
	Real-Time Program Syntax Check		O		O	O	O				O			

Remarks： *6 series NOT available in Taiwan; **Only available in China / ***VGA available on standalone type only

○ Standard Function　△ Optional Function　- Unavailable

Categories	Items	Instruction	Standard		Functional Milling		Compound Milling Machine							
			6 Series		21 Series	22 Series	210 Series				220 Series			
			6MA-E	6MB-E	21MA-E	22MA PLUS	210MA-E	210MA-E5	210MB-E	210MB-E5	220MA PLUS	220MA-5 PLUS	220MB PLUS	220MB-5 PLUS
PLC	PLC Diagnose (Force I Point)		O		O	O	O				O			
Data Transfer	Network		O		O	O	O				O			
	FTP		O		O	O	O				O			
	RS-485		O		O	O	O				O			
	DNC (Network)		O		O	O	O				O			
	DNC (USB)		O		O	O	O				O			
Information Display	Operation History Display		O		O	O	O				O			
	Graphic Simulation		O		O	O	O				O			
	Partial Graphic Simulation		O		O	O	O				O			
	Dynamic Multilingual Switching		O		O	O	O				O			
G Code	Spiral, Conical & Helical Interpolation	G02, G03	—		O	O	O				O			
	Path Smoothing	G05.1	—		O	O	O				O			
	NURBS Curve Interpolation	G06.2	—		O	O	O				O			
	Thread Cutting	G33	O		O	O	O				O			
	Auto Tool Preset & Measurement	G37	O		O	O	O				O			
	Tool Offset	G45~G48	O		O	O	O				O			
	High Speed Peck Drill Cycle	G73	O		O	O	O				O			
	Left Hand Tapping Cycle	G74	O		O	O	O				O			
	Fine Boring Cycle	G76	O		O	O	O				O			
	Chopping	G81	O		O	O	O				O			
	Drilling Cycle with Dwelling at hole bottom	G82	O		O	O	O				O			
	Peck Drill Cycle	G83	O		O	O	O				O			
	Tapping Cycle	G84	O		O	O	O				O			
	Drilling Cycle	G85	O		O	O	O				O			
	High Speed Drilling Cycle	G86	O		O	O	O				O			
	Fine Boring Cycle on Back Side	G87	O		O	O	O				O			
	Semiautomatic Fine Boring Cycle	G88	O		O	O	O				O			
	Boring Cycle with Dwelling at hole bottom	G89	O		O	O	O				O			

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○ Standard Function　△ Optional Function　- Unavailable

Categories	Items	Instruction	Software Function	Standard 6 Series 6MA-E	6MB-E	Functional Milling 21 Series 21MA-E	21 Series 21MA PLUS	Compound Milling Machine 210 Series 210MA-E	210MA-E5	210MB-E	210MB-E5	220 Series 220MA PLUS	220MA-5 PLUS	220MB PLUS	220MB-5 PLUS
G Code	Polygon cutting	G51.2		—	—	—	O	—	O	—	O	O	O	O	O
	Enable/Disable Spindle Synchronization	G114.2		—	—	—	O	—	O	—	O	O	O	O	O
	Machining Conditions Selection	G120.1		O	O	O	O	O	O	O	O	O	O	O	O
Five Axis	Feature Coordinate System (Inclined Plane Processing)	G68.2 G68.3	OP13	—	△	△	△	△	△	△	△	△	△	△	△
	Five-Axis RTCP	G43.4 G43.5	OP12	—	—	—	—	—	△	—	△	—	△	—	△
	Four-Axis RTCP		OP29	—	△	△	△	△	△	△	△	△	△	△	△
	Multiple Kinematic Chain Group	G10 L5000 P_ Q_	OP27	—	△	△	△	△	△	△	△	△	△	△	△
	Intelligent Check - 5		OP46	—	—	—	—	—	△	—	△	—	△	—	△
	Intelligent Measurement		OP47	△	△	△	△	△	△	△	△	△	△	△	△
	3D Tool Compensation	G41.1/G42.2 G41.6/G42.6	OP61	—	—	—	—	—	—	—	—	—	△	—	△
Others	High Precision Contour Control (HPCC)	G05 P10000	OP11	—	—	O	O	O	O	O	O	O	O	O	O
	3D Arc Interpolation		OP19	—	—	O	O	O	O	O	O	O	O	O	O
	All-in-One Gantry		OP20	△	△	△	△	△	△	△	△	△	△	△	△
	ROT Servo Turret	PLC Component	OP32	O	O	O	O	O	O	O	O	O	O	O	O
	Chopping	G81.1	OP44	—	—	O	O	O	O	O	O	O	O	O	O
	Smart Thermal Compensation	Spindle	OP49	—	—	—	△	—	—	—	—	△	△	△	△
	Smart Thermal Compensation (Axis)	Axis	OP50	—	—	—	△	—	—	—	—	△	△	△	△
	OPCUA Server		OP51	△	△	△	△	△	△	△	△	△	△	△	△
	Abnormal Disturbance Torque Protection	DTRQ	OP52	—	—	—	O	—	—	—	—	O	O	O	O
	Intelligent Check APP	Tool & Workpiece Measurement	OP47	△	△	△	△	△	△	△	△	△	△	△	△
	Tangential Control	G40.1 G41.1 G42.1	OP59	—	—	△	△	△	△	△	△	△	△	△	△

Remarks： *6 series NOT available in Taiwan / **Only available in China / ***VGA available on standalone type only

○ Standard Function　　△ Optional Function　　- Unavailable

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