TNC 620 HSCI
For Gen 3 Drives
The Compact Contouring Control for Milling, Drilling, and Boring Machines
Information for the Machine Tool Builder
TNC contouring control with drive system from HEIDENHAIN

General information

TNC 620

• Compact contouring control for milling, drilling, and boring machines
• Axes: 8 control loops, of which up to 2 can be configured as spindles
• For operation with HEIDENHAIN inverter systems and ideally HEIDENHAIN motors
• Uniformly digital with HSCI interface and EnDat interface
• Compact size
• CompactFlash memory card
• Programming in HEIDENHAIN Klartext format or G-code (ISO)
• Standard milling, drilling, and boring cycles
• Touch probe cycles
• Short block processing time (1.5 ms)

19-inch screen (portrait) design

• Monitor, keyboard, and main computer in one unit (MC 8410)
• Integration of the keyboard in the lower screen area
• Multi-touch operation

15-inch screen (landscape) design

• Monitor and main computer in one unit (MC 8420)
• Separate keyboard unit
• Multi-touch operation

System test

Controls, power modules, motors, and encoders from HEIDENHAIN are usually integrated as components into complete systems. In such cases, comprehensive testing of the complete system is required, irrespective of the specifications of the individual devices.

Parts subject to wear

Controls from HEIDENHAIN contain parts subject to wear, such as a backup battery and fan.

Standards

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

Note

Intel, Intel Xeon, Core, and Celeron are registered trademarks of Intel Corporation.

Validity

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

TNC 620 with NC software versions
817600-17 (export license required)
817601-17 (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 also note that, for some functions, a special PLC program must be created by the manufacturer.

Functional safety (FS)

If standard components and FS components (FS = Functional Safety) are not explicitly differentiated, then the information applies to both versions (e.g. TE 735, TE 735 FS).

Components for which there is also a version with functional safety bear the identifier "FS" at the end of the product designation, e.g., UEC 3xx (FS)
### Overview tables

#### Components

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<td>Keyboard</td>
<td>Integrated in screen</td>
<td>TE 73x or TE 73x FS</td>
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<td>Machine operating panel</td>
<td>PLB 6001, PLB 600x FS (HSCI adapter for OEM machine operating panel)</td>
<td>20</td>
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<td>MB 721, MB 721 FS</td>
<td></td>
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<td></td>
<td>MB 720, MB 720 FS</td>
<td></td>
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<td>PLC inputs/outputs</td>
<td>PL 6000 consisting of PLB 62xx basic module (system PL) or PLB 61xx (expansion PL) and I/O modules</td>
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<td></td>
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#### Accessories

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<td>Tool touch probes</td>
<td>• TT 160 triggering touch probe with cable connection</td>
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<td></td>
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<td>Control software for PCs for programming, archiving, and training</td>
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<td></td>
</tr>
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<td></td>
<td>• Network license with operation via virtual keyboard</td>
<td></td>
</tr>
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<td>• Demo version with virtual keyboard or PC keyboard—free of charge</td>
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1) May be necessary depending on the configuration
2) For more information, refer to the Inverter Systems for Gen 3 Drives brochure
3) Available to registered customers for downloading from the Internet
4) Available to all customers (without registration) for downloading from the Internet
5) Software release module required

Please note: The MC main computer does not have any PLC inputs/outputs. Therefore one PL 6000, UEC, or UMC is necessary for each control. They feature safety-relevant inputs/outputs as well as the connections for touch probes.
## Specifications

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<tr>
<td>Axes</td>
<td>8 control loops, of which up to 2 can be configured as spindles</td>
<td>50</td>
</tr>
<tr>
<td>Rotary axes</td>
<td>✅</td>
<td></td>
</tr>
<tr>
<td>Synchronized axes</td>
<td>✅</td>
<td></td>
</tr>
<tr>
<td>PLC axes</td>
<td>✅</td>
<td></td>
</tr>
<tr>
<td>Main spindle</td>
<td>Mwing: max. 2; second spindle can be controlled by PLC alternately with the first</td>
<td>53</td>
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<tr>
<td>Speed</td>
<td>Max. 60,000 rpm for motors with a single pole pair (with software option 49: max. 120,000 rpm)</td>
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<td>Operating mode switchover</td>
<td>✅</td>
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<td>Oriented spindle stop</td>
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<td>53</td>
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<td>Gear shifting</td>
<td>✅</td>
<td>53</td>
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<td>NC program memory</td>
<td>7.7 GiB</td>
<td>16</td>
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<td>Input resolution and display step</td>
<td>Down to 0.01 µm</td>
<td>50</td>
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<td>Linear axes</td>
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<td>For applications with up to</td>
<td>● SIL 2 as per EN 61508</td>
<td></td>
</tr>
<tr>
<td></td>
<td>● Category 3, PL d as per EN ISO 13849-1: 2008</td>
<td></td>
</tr>
<tr>
<td>Interpolation</td>
<td>In 4 axes; in max. 5 axes with software option 9</td>
<td></td>
</tr>
<tr>
<td>Circle</td>
<td>In 2 axes; in 3 axes with software option 8</td>
<td></td>
</tr>
<tr>
<td>Helical</td>
<td>✅</td>
<td></td>
</tr>
<tr>
<td>Axis feedback control</td>
<td>✅</td>
<td>55</td>
</tr>
<tr>
<td>With servo lag</td>
<td>✅</td>
<td></td>
</tr>
<tr>
<td>With feedforward</td>
<td>✅</td>
<td></td>
</tr>
<tr>
<td>Axis clamping</td>
<td>✅</td>
<td>50</td>
</tr>
<tr>
<td>Maximum feed rate</td>
<td>60,000 r.p.m.</td>
<td>50</td>
</tr>
<tr>
<td></td>
<td>Applies to ( f_{\text{PWM}} = 5000 ) Hz</td>
<td></td>
</tr>
</tbody>
</table>

### Function safety (FS)

- With FS components, SPLC and SKERN
- For applications with up to:
  - SIL 2 as per EN 61508
  - Category 3, PL d as per EN ISO 13849-1: 2008

### Interpolation

- Straight line: In 4 axes; in max. 5 axes with software option 9
- Circle: In 2 axes; in 3 axes with software option 8
- Helical: ✅

### Axis feedback control

- ✅
- ✅
- ✅
- ✅

### Maximum feed rate

\[
\text{Maximum feed rate} = 60,000 \text{ r.p.m.}
\]

 Applies to \( f_{\text{PWM}} = 5000 \) Hz

### Cycle times

<table>
<thead>
<tr>
<th>Cycle times of main computer</th>
<th>MC</th>
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<tr>
<td>Block processing</td>
<td>&lt; 1.5 ms</td>
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### Cycle times of controller unit

<table>
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<th>CC/UEC/UMC</th>
<th>Single-speed: 0.2 ms Double-speed: 0.1 ms (software option 49)</th>
<th>56</th>
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<tr>
<td>Path interpolation</td>
<td>Applies to ( f_{\text{PWM}} = 5 ) kHz</td>
<td></td>
</tr>
</tbody>
</table>

### Speed controller

- \( f_{\text{PWM}} \):
  - 3333 Hz
  - 4000 Hz
  - 5000 Hz
  - 6666 Hz with software option 49
  - 8000 Hz with software option 49
  - 10,000 Hz with software option 49
  - 13,333 Hz with software option 49
  - 16,000 Hz with software option 49

- \( T_{\text{ACT}} \):
  - 150 µs
  - 125 µs
  - 100 µs
  - 75 µs with software option 49
  - 62.5 µs with software option 49
  - 50 µs with software option 49
  - 37.5 µs with software option 49
  - 31.25 µs with software option 49

### 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

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<tr>
<th>Error compensation</th>
<th>✓</th>
<th>65</th>
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<td>Linear axis error</td>
<td>✓</td>
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<td>Nonlinear axis error</td>
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<td>Backlash</td>
<td>✓</td>
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<td>Reversal spikes during circular movement</td>
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<td>Hysteresis</td>
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<td>65</td>
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<tr>
<td>Thermal expansion</td>
<td>✓</td>
<td>65</td>
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<tr>
<td>Static friction</td>
<td>✓</td>
<td>65</td>
</tr>
<tr>
<td>Sliding friction</td>
<td>✓</td>
<td>65</td>
</tr>
<tr>
<td>Dynamic compliance during acceleration phases</td>
<td>✓</td>
<td>61</td>
</tr>
</tbody>
</table>

### Integrated PLC

- Program format: Statement list
- Program input at the control: MC 8410: by screen keyboard, MC 8420: via TE 73x or TE 73x FS
- Program input by PC: ✓
- Symbolic PLC-NC interface: ✓
- PLC memory: ≈ 4 GiB
- PLC cycle time: 9 ms to 30 ms (adjustable)

### PLC inputs/outputs

- PLC inputs, DC 24 V: Via PL, UEC, UMC
- PLC outputs, DC 24 V: Via PL, UEC, UMC
- Analog inputs ±10 V: Via PL
- Inputs for PT 100 thermistors: Via PL
- Analog outputs ±10 V: Via PL

### PLC functions

- Small PLC window: ✓
- PLC soft keys: ✓
- PLC positioning: ✓
- PLC Basic Program: ✓

### Integration of applications

- High-level language programming: Use of the Python programming language in conjunction with the PLC (software option 46)
- User interfaces can be custom-designed: Creation of individualized user interfaces by the machine manufacturer with the Python programming language with Qt/QML. Programs up to a memory limit of 10 MB are enabled in standard mode. More can be enabled via software option 46.

### Hardware interfaces

- Ethernet: ✓
- USB: ✓

### Communication protocols

- Standard data transmission: ✓
- Blockwise data transfer: ✓
### Functions for the user

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<th>Standard</th>
<th>Option</th>
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<td><strong>Short description</strong></td>
<td>✓</td>
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<tr>
<td>Basic version: 3 axes plus closed-loop spindle (standard)</td>
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<td></td>
</tr>
<tr>
<td>Up to 8 control loops, of which 2 can be configured as spindles</td>
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<tr>
<td>Digital current and speed control</td>
<td></td>
<td>✓</td>
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<td><strong>Program entry</strong></td>
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<tr>
<td>HEIDENHAIN Klartext</td>
<td></td>
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<tr>
<td>ISO programming</td>
<td></td>
<td>✓</td>
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<td>Direct loading of contours or machining positions from DXF files and saving as a Klartext contouring program or as a point table</td>
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<td><strong>Position values</strong></td>
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<td>Nominal positions for lines and arcs in Cartesian coordinates or polar coordinates</td>
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<td></td>
</tr>
<tr>
<td>Incremental or absolute dimensions</td>
<td></td>
<td>✓</td>
</tr>
<tr>
<td>Display and entry in mm or inches</td>
<td></td>
<td>✓</td>
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<tr>
<td><strong>Tool compensation</strong></td>
<td>✓</td>
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<td>Tool radius in the working plane, and tool length</td>
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<tr>
<td>Incremental or absolute dimensions</td>
<td></td>
<td>✓</td>
</tr>
<tr>
<td>Radial or absolute dimensions</td>
<td></td>
<td>✓</td>
</tr>
<tr>
<td><strong>Cutter data</strong></td>
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</tr>
<tr>
<td>Automatic calculation of spindle speed, cutting speed, feed per tooth, and feed per revolution</td>
<td></td>
<td>✓</td>
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<tr>
<td><strong>Constant contour speed</strong></td>
<td>✓</td>
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<td>Based on the path of the tool center point</td>
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<td>✓</td>
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<tr>
<td>Based on the tool’s cutting edge</td>
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<td>✓</td>
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<td>Creating a program with graphical support while another program is being run</td>
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<td>✓</td>
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<td><strong>3D machining</strong></td>
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<td></td>
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<tr>
<td>Motion control with smoothed jerk</td>
<td></td>
<td>✓</td>
</tr>
<tr>
<td>3D tool compensation via surface-normal vectors</td>
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<td>✓</td>
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<tr>
<td>Changing the tilt position with handwheel superimpositioning; maintaining the position of the tool point (TCPM)</td>
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<td>✓</td>
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<tr>
<td>Keeping the tool perpendicular to the contour</td>
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<td>✓</td>
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<td>Tool radius compensation normal to the tool direction</td>
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<td>Manual traverse in the active tool-axis system</td>
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<td><strong>Rotary table machining</strong></td>
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<td>Programming of contours for machining on a cylinder as if in two axes</td>
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<td>Feed rate in mm/min</td>
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<tr>
<td><strong>Contour elements</strong></td>
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<tr>
<td>Straight line</td>
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<td>✓</td>
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<tr>
<td>Chamfer</td>
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<td>✓</td>
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<td>Circular path</td>
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<td>✓</td>
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<td>Circle radius</td>
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<td>Tangentially connecting circular arc</td>
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<td>✓</td>
</tr>
<tr>
<td>Corner rounding</td>
<td></td>
<td>✓</td>
</tr>
<tr>
<td><strong>Contour approach and departure</strong></td>
<td>✓</td>
<td></td>
</tr>
<tr>
<td>Via straight line: tangential or perpendicular</td>
<td></td>
<td>✓</td>
</tr>
<tr>
<td>Via circular arc</td>
<td></td>
<td>✓</td>
</tr>
</tbody>
</table>

### Function

- **FK free contour programming**
- **Fixed cycles**
- **Program jumps**
- **Coordinate transformation**
- **G parameters Programming with variables**
- **Programming aids**
- **CAD viewer**
- **CAD Model Optimizer**
- **Teach-in**
- **Program verification graphics**
- **Display modes**
- **Programming graphics**
- **Program-run graphics**
- **Display modes**
- **Machining time**

**TNC 620**

- **FK free contour programming in HEIDENHAIN Klartext format with graphical support for workpiece drawings not dimensioned for NC**
- **Drilling, conventional and rigid tapping, rectangular and circular pockets**
- **Peck drilling, reaming, boring, counterboring, centering**
- **Milling internal and external threads**
- **Clearing level and oblique surfaces**
- **Complete machining of straight and circular slots**
- **Complete machining of rectangular and circular pockets, and rectangular and circular studs**
- **Contour slot with trochoidal milling**
- **Engraving cycle: engraving of text or numbers in a straight line or on an arc**
- **OEM cycles (special cycles developed by the machine manufacturer) can be integrated**
- **Subprograms**
- **Program section repeat**
- **Any program as a subprogram**
- **8 Shifting, rotating, mirroring, scaling (axis-specific)**
- **Tilting the working plane, PLAN function**
- **Mathematical functions: +, -, *, /, sin, cos, tan, arcos, arcsin, arc tan, a, b, r in, log, angle**
- **Logical operations (, <=, >)**
- **Calculating with parentheses**
- **Absolute value of a number; constant PI, negation, truncation of digits before or after the decimal point**
- **Functions for calculation of circles**
- **Functions for text processing**
- **Complete list of all current error messages**
- **Context-sensitive help function for error messages**
- **TNCguide: the integrated help system; user information is available directly on the TNC**
- **Graphical support for the programming of cycles**
- **Comment and structure blocks in the NC program**
- **Display of standardized CAD file formats on the TNC**
- **Optimize CAD models**
- **Application of actual positions directly in the NC program**
- **Graphical simulation of the machining sequence, even while another program is running**
- **Plan view / projection in 3 planes / 3D view, including in tilted working plane / 3D line graphics**
- **Detail zoom**
- **In the Editor operating mode the contours of entered NC blocks are rendered (2D pencil-trace graphics), even while another program is running**
- **Graphical depiction of the executed program**
- **Plan view / projection in 3 planes / 3D view**
- **Calculation of machining time in the Test Run operating mode**
- **Display of the current machining time in the Program Run operating modes**
### Software options

<table>
<thead>
<tr>
<th>Option number</th>
<th>Software option</th>
<th>With NC software</th>
<th>ID</th>
<th>Comment</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>Additional Axes 1</td>
<td>01</td>
<td>354540-01</td>
<td>Additional control loop 1</td>
<td>19</td>
</tr>
<tr>
<td>1</td>
<td>Additional Axes 2</td>
<td>01</td>
<td>353904-01</td>
<td>Additional control loop 2</td>
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<td>2</td>
<td>Additional Axes 3</td>
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<td>353905-01</td>
<td>Additional control loop 3</td>
<td>19</td>
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<tr>
<td>3</td>
<td>Additional Axes 4</td>
<td>01</td>
<td>367867-01</td>
<td>Additional control loop 4</td>
<td>19</td>
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<tr>
<td>8</td>
<td>Advanced Function Set 1</td>
<td>01</td>
<td>617920-01</td>
<td>Rotary table machining • Programming of cylindrical contours as if in two axes • Feed rate in mm/min • Coordinate transformations • Tilting the working plane, PLANE function • Interpolation • Circular in 3 axes with tilted working plane</td>
<td>50</td>
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<tr>
<td>9</td>
<td>Advanced Function Set 2</td>
<td>01</td>
<td>617921-01</td>
<td>3D machining • 3D tool compensation via surface-normal vectors • Using the electronic handwheel to change the angle of the swivel head during program run without affecting the position of the tool point (TCPM = Tool Center Point Management) • Keeping the tool perpendicular to the contour • Tool radius compensation perpendicular to the tool direction • Manual traverse in the active tool-axis system • Interpolation • Linear in more than 4 axes (export license required)</td>
<td>51</td>
</tr>
<tr>
<td>17</td>
<td>Touch Probe Functions</td>
<td>01</td>
<td>634060-01</td>
<td>Touch probe cycles • Compensation of workpiece misalignment, setting of presets • Automatic tool and workpiece measurement • Touch probe input enabled for non-HEIDENHAIN systems • Automatically enabled upon connection of an SE 661</td>
<td>74</td>
</tr>
<tr>
<td>18</td>
<td>HEIDENHAIN DNC</td>
<td>01</td>
<td>526451-01</td>
<td>Communication with external PC applications over COM component</td>
<td>77</td>
</tr>
</tbody>
</table>

### Functions

- **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

- **Preset management** ✓
  - For storing any presets

- **Datum tables** ✓
  - Multiple datum tables for storing workpiece-specific datums

- **Pallet tables**
  - Workpiece-oriented execution of pallet tables (with any number of entries for the selection of pallets, NC programs, and datums)

- **Touch probe cycles**
  - Calibrating the touch probe
  - Compensation of workpiece misalignment, manual or automatic
  - Preset setting, manual or automatic
  - Automatic tool and workpiece measurement

- **Parallel secondary axes** ✓
  - Compensation of movement in the secondary axes U, V, W through the principal axes X, Y, Z
  - Movements of parallel axes included in the position display of the associated principal axis (sum display)
  - Defining the principal and secondary axes in the NC program enables execution on different machine configurations

- **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

### Software options

<table>
<thead>
<tr>
<th>Option number</th>
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<tr>
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<td>01</td>
<td>354540-01</td>
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<td>18</td>
<td>HEIDENHAIN DNC</td>
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<td>526451-01</td>
<td>Communication with external PC applications over COM component</td>
<td>77</td>
</tr>
<tr>
<td>Option number</td>
<td>Software option</td>
<td>With NC software 817600-817601- or later</td>
<td>ID</td>
<td>Comment</td>
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<td>----</td>
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<tr>
<td>19</td>
<td>Advanced Programming Features</td>
<td>01 628252-01</td>
<td></td>
<td>FK free contour programming Fixed cycles • Peck drilling, reaming, boring, counterboring, centering • Milling internal and external threads • Cleaning level and oblique surfaces • Complete machining of straight and circular slots • Complete machining of rectangular and circular pockets • Circular and linear point patterns • Contour train, contour pocket, including contour-parallel machining • Contour slot with trochoidal milling • Special cycles developed by the machine manufacturer can be integrated</td>
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<tr>
<td>20</td>
<td>Advanced Graphic Features</td>
<td>01 628253-01</td>
<td></td>
<td>Program-verification graphics, program-run graphics • Plan view, view in three planes, 3D view</td>
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<tr>
<td>21</td>
<td>Advanced Function Set 3</td>
<td>01 628254-01</td>
<td></td>
<td>Tool compensation • Radius-compensated contour look-ahead for up to 99 blocks (LOOK AHEAD) • 3D machining • Superimposing handwheel positioning during program run</td>
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<td>22</td>
<td>Pallet Management</td>
<td>01 628255-01</td>
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<td>Pallet management</td>
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<td>24</td>
<td>Gantry Axes</td>
<td>01 634621-01</td>
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<td>Gantry axes via master-slave torque control</td>
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<td>42</td>
<td>CAD Import</td>
<td>05 526460-01</td>
<td></td>
<td>Importing of contours from 2D and 3D models (e.g., STEP, IGES, DXF)</td>
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<tr>
<td>46</td>
<td>Python OEM Process</td>
<td>01 579650-01</td>
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<td>Execution of Python applications</td>
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<td>KinematicsOpt</td>
<td>01 630916-01</td>
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<td>Touch-probe cycles for the automatic measurement of rotary axes</td>
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<td>49</td>
<td>Double-Speed Axes</td>
<td>01 632223-01</td>
<td></td>
<td>Short control-loop cycle times for direct drives</td>
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<tr>
<td>56–61</td>
<td>OPC UA NC Server 1 to 6</td>
<td>08 1291434-01 to 1291434-06</td>
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<td>Connection of an OPC UA application</td>
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<td>77</td>
<td>4 Additional Axes</td>
<td>01 634613-01</td>
<td></td>
<td>4 additional control loops</td>
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<tr>
<td>93</td>
<td>Extended Tool Management</td>
<td>02 678938-01</td>
<td></td>
<td>Expanded tool management: • Tooling list (list of all tools of the NC program) • T usage sequence (sequence of all tools inserted during the program)</td>
<td></td>
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<tr>
<td>133</td>
<td>Remote Desk. Manager</td>
<td>01 894423-01</td>
<td></td>
<td>Display and operation of external computer units (e.g., Windows PC)</td>
<td></td>
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<tr>
<td>141</td>
<td>Cross Talk Comp.</td>
<td>01 800542-01</td>
<td></td>
<td>CTC: compensation of axis couplings</td>
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<tr>
<td>142</td>
<td>Pos. Adapt. Control</td>
<td>01 800544-01</td>
<td></td>
<td>PAC: position-dependent adaptation of control parameters</td>
<td></td>
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<tr>
<td>143</td>
<td>Load Adapt. Control</td>
<td>01 800545-01</td>
<td></td>
<td>LAC: load-dependent adaptation of control parameters</td>
<td></td>
</tr>
<tr>
<td>144</td>
<td>Motion Adapt. Control</td>
<td>01 800546-01</td>
<td></td>
<td>MAC: motion-dependent adaptation of control parameters</td>
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</table>

<table>
<thead>
<tr>
<th>Option number</th>
<th>Software option</th>
<th>With NC software 817600-817601- or later</th>
<th>ID</th>
<th>Comment</th>
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<tr>
<td>145</td>
<td>Active Chatter Control</td>
<td>01 820547-01</td>
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<td>ACC: active chatter control</td>
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<tr>
<td>146</td>
<td>Machine Vibration Control</td>
<td>08 820548-01</td>
<td></td>
<td>Damping of machine oscillations to improve workpiece surfaces. The following functions are part of Machine Vibration Control (MVC): • AVD (Active Vibration Damping): Active damping of vibrations in the control loop • FSC (Frequency Shaping Control): Reduction of vibration inducement by means of frequency-based feedforward control</td>
</tr>
<tr>
<td>152</td>
<td>CAD Model Optimizer</td>
<td>17 1353918-01</td>
<td></td>
<td>Conversion and optimization of CAD models • Fixtures • Workpiece blank • Finished part</td>
</tr>
<tr>
<td>154</td>
<td>Batch Process Manager</td>
<td>05 1219521-01</td>
<td></td>
<td>Planning and executing multiple machining operations</td>
</tr>
<tr>
<td>155</td>
<td>Component Monitoring</td>
<td>08 122883-01</td>
<td></td>
<td>Monitoring for component overloading and wear</td>
</tr>
<tr>
<td>160</td>
<td>Integrated FS: Basic</td>
<td>07 1249928-01</td>
<td></td>
<td>Enables functional safety and four safe control loops</td>
</tr>
<tr>
<td>161</td>
<td>Integrated FS: Full</td>
<td>07 1249929-01</td>
<td></td>
<td>Enables functional safety and the maximum number of safe control loops</td>
</tr>
<tr>
<td>162</td>
<td>Add. FS Ctrl. Loop 1</td>
<td>07 1249930-01</td>
<td></td>
<td>Additional control loop 1</td>
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<tr>
<td>163</td>
<td>Add. FS Ctrl. Loop 2</td>
<td>07 1249931-01</td>
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<td>Additional control loop 2</td>
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<td>Add. FS Ctrl. Loop 3</td>
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<td>Additional control loop 3</td>
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<td>Add. FS Ctrl. Loop 4</td>
<td>07 1249933-01</td>
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<td>Additional control loop 4</td>
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<td>166</td>
<td>Add. FS Ctrl. Loop 5</td>
<td>07 1249934-01</td>
<td></td>
<td>Additional control loop 5</td>
</tr>
<tr>
<td>167</td>
<td>Optimized Contour Milling</td>
<td>07 1289547-01</td>
<td></td>
<td>GCM: optimize roughing processes and fully utilize milling tools with the integrated cutting data calculator</td>
</tr>
<tr>
<td>169</td>
<td>Add. FS Full</td>
<td>08 1319091-01</td>
<td></td>
<td>Enables all FS axis options or control loops. Options 160 and 162 to 166 must already be set.</td>
</tr>
</tbody>
</table>
HSCI control components

Main computers

The MC main computers feature the following:
• Intel Celeron 1047 processor (1.4 GHz, dual-core)
• Main memory: 4 GB RAM
• IP54 degree of protection (when installed)
• HSCI interface to the controller unit and to other control components

To be ordered separately and installed in the main computer by the OEM:
• CFR memory card with the NC software
• The System Identification Key (SIK) component for the enabling of control loops and software options

Special features of the MC 8410:
• 19-inch screen (portrait); resolution: 1024 x 1280 pixels
• Without feed-rate and spindle-speed potentiometers (potentiometers are integrated in the MB 721)
• Multi-touch operation and virtual ASCII keyboard
• Software support with 81760x-04 SP2 or later

Special features of the MC 8420:
• 15-inch screen (landscape), resolution: 1024 x 768 pixels
• Multi-touch operation
• Separate TE keyboard unit required
• Software support with 81760x-08 or later

The following HSCI components are necessary for operation of the TNC 620:
• MC main computer and controller unit
• PLB 62xx PLC I/O unit (system PL; integrated in UxC))
• MB 72x or MB 72x FS machine operating panel (integrated in TE 7x5) or PLB 600x FS HSCI adapter for connecting an OEM machine operating panel

Interfaces

The MC is equipped with USB 3.0 and Ethernet ports.
Connection to PROFINET DP or PROFINET IO is optionally possible via the individual additional modules or a combined PROFINET DP / PROFINET IO module.

Export version

Because the entire NC software is on the CompactFlash memory card (CFR), no export version is needed for the main computer itself. Only the easily replaceable storage medium and SIK component are available as export versions.

Gen 3 labels

The different Gen 3 labels identify how control components can be deployed.

The label expresses the fact that a component is basically ready for operation in a Gen 3 (Gbit HSCI) drive system. Whether a component is suitable for functional safety FS (integrated FS, external FS, enabling of FS) must be considered separately.

Gen 3 ready: These components can be used in systems with Gen 3 drives (UVR 3xx, UM 3xx, CC 3xx) and in systems with a 1xx inverter system (UVR 1xx, UE 2xx, UR 2xx, CC 61xx).

Gen 3 exclusive: These components can be used only in systems with Gen 3 drives (UVR 3xx, UM 3xx, CC 3xx).

Software options

Software options allow the performance of the TNC 620 to be adapted to one’s actual needs at a later time. The software options are described on page 13. They are enabled by entering keywords based on the SIK number, and are saved in the SIK component. Please provide the SIK number when ordering new options.

 Versions

The main computers are designed for direct installation in the operating panel:
• Integrated keyboard: The MC 8410 features a 19-inch multi-touch display (portrait) with TNC keyboard and ASCII keyboard integrated in the screen
• Separate keyboard: The MC 8420 features a 15-inch multi-touch display (landscape). A separate 15-inch TNC keyboard is required. Hence, the entire ASCII character set is available.

The MC 8410 main computer is supported starting with NC software 81760x-04 SP2 or later; the MC 8420 main computer is supported starting with NC software 81760x-08 or later. Earlier software versions will not run on these MC main computers.
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.

This CFR uses the fast SATA protocol (CFast). This CFR is compatible with the MCs described in the Main computers section.

### CFR CompactFlash, 30 GB
- Free PLC memory space: ≈ 4 GiB
- Free NC memory space: ≈ 7.7 GiB
- Export license required: ID 1069906-1x (NC SW 817600-xx)
- Export license not required: ID 1069906-6x (NC SW 817601-xx)

### SIK component
The SIK component contains the NC software license for enabling control loops and software options. It provides the main computer with an unambiguous ID code—the SIK number. The SIK component is ordered and shipped separately. It must be inserted into a slot provided for it in the MC main computer. The SIK component with the NC software license exists in different versions based on the enabled control loops and software options. Additional control loops can be enabled later by entering a keyword. HEIDENHAIN provides the keyword, which is based on the SIK number.

When ordering, please provide the SIK number of your control. When the keywords are entered in the control, they are saved in the SIK component, thereby enabling and activating the software options. Should servicing become necessary, the SIK component must be inserted into the replacement control in order to enable all of the required software options.

### Master keyword (general key)
For putting the TNC 620 into service, there is a master keyword that enables all software options once for 90 days. After this period, the software options can be activated only with the correct keywords. The general key is activated via a soft key.

### TNCkeygen (accessory)
TNCkeygen is a collection of PC software tools for generating enabling keys for HEIDENHAIN controls for a limited period of time.

With the OEM Key Generator, you can generate enabling keys for software options by entering the SIK number, the software option to be enabled, the enabling period, and an OEM-specific password. This activation is limited to a period of 10 to 90 days. Each software option can be enabled only once; this is performed independently of the master keyword.

The OEM daily key generator generates an enabling key for the protected OEM area, thus granting the user access on the day it is generated.

### Export license required
- (NC SW 817600-xx) ID 1069906-1x
- (NC SW 817601-xx) ID 1069906-6x

### Export license not required
- (NC SW 817600-xx) ID 1069906-1x
- (NC SW 817601-xx) ID 1069906-6x

### Enabling further control loops
Additional control loops can be enabled individually. Up to 8 control loops are possible.

### Control-loop groups

<table>
<thead>
<tr>
<th>Control-loop groups</th>
<th>Software option</th>
</tr>
</thead>
<tbody>
<tr>
<td>4 Additional Control Loops</td>
<td>77</td>
</tr>
<tr>
<td>Individual control loops</td>
<td>Option</td>
</tr>
<tr>
<td>1st additional control loop</td>
<td>0</td>
</tr>
<tr>
<td>2nd additional control loop</td>
<td>1</td>
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<tr>
<td>3rd additional control loop</td>
<td>2</td>
</tr>
<tr>
<td>4th additional control loop</td>
<td>3</td>
</tr>
</tbody>
</table>

### NC software license and enabling of control loops

<table>
<thead>
<tr>
<th>Control loops</th>
<th>Without option</th>
<th>Incl. options 19 and 20</th>
<th>Incl. options 17, 19 and 20</th>
<th>Incl. options 19, 20 and 46</th>
<th>Incl. options 8, 19 and 20</th>
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<tr>
<td>4</td>
<td>ID 526924-01</td>
<td>ID 526924-04</td>
<td>ID 526924-20</td>
<td>ID 526924-11</td>
<td>ID 526924-18</td>
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<tr>
<td></td>
<td>ID 526924-01</td>
<td>ID 526924-04</td>
<td>ID 526924-20</td>
<td>ID 526924-11</td>
<td>ID 526924-18</td>
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<td>5</td>
<td>ID 526924-02</td>
<td>ID 526924-05</td>
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<td>ID 526924-12</td>
<td>ID 526924-13</td>
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<tr>
<td></td>
<td>ID 526924-02</td>
<td>ID 526924-05</td>
<td>-</td>
<td>ID 526924-12</td>
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<td>6</td>
<td>ID 526924-03</td>
<td>ID 526924-06</td>
<td>-</td>
<td>ID 526924-19</td>
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<tr>
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<td>ID 526924-03</td>
<td>ID 526924-06</td>
<td>-</td>
<td>ID 526924-19</td>
<td>ID 526924-07</td>
</tr>
</tbody>
</table>

(italics: export version)
Keyboard

- Suitable for the MC 8420
- Supply voltage: DC 24 V/4 W
- 36 exchangeable snap-on keys with status LED, freely definable via PLC (assignment as per PLC basic program: 12 axis keys, spindle start, spindle stop, 22 further function keys)
- Further operating elements: NC start\(^1\), NC stop\(^1\), emergency stop button, control voltage on\(^1\), two holes for additional keys or keylock switches
- HSCI interface
- MB 720: 8 free PLC inputs and 8 free PLC outputs
- MB 720 FS: 4 free FS inputs and 8 free PLC outputs; additional dual-channel FS inputs for emergency stop and permissive buttons of the handwheel.

\(^1\) Illuminated keys, addressable via PLC

- MB 720: ID 764002-xx
- MB 720 FS: ID 805474-xx
- Mass: \(=\) 1.3 kg

MB 721 machine operating panel

- Same as the MB 720, except:
  - Suitable for the MC 8410
  - Changed front panel
  - 3 holes for additional buttons or keylock switches
  - Spindle-speed and feed-rate override potentiometers
  - USB port with cover cap

- MB 721: ID 116494-xx
- MB 721 FS: ID 1164975-xx
- Mass: \(=\) 1.5 kg

TE 730 keyboard

- Suitable for the MC 8420
- Axis keys
- The keys for axes IV and V are exchangeable snap-on keys
- Contouring keys
- Operating mode keys
- ASCII keyboard
- Spindle-speed and feed-rate override potentiometers
- USB interface to the MC main computer
- Touchpad

- TE 730: ID 805469-xx
- Mass: \(=\) 2.4 kg

TE 735 keyboard with an integrated machine operating panel

- Suitable for the MC 8420
- NC keyboard same as TE 730
- USB interface to the MC main computer
- Machine operating panel (same as MB 720)
- HSCI interface

- TE 735: ID 771886-xx
- TE 735 FS: ID 806400-xx
- Mass: \(=\) 3.7 kg

PL 6000 PLC input/output systems with HSCI

The PLC inputs and outputs are available via external modular PL 6000 PLC input/output systems. They consist of a basic module and one or more input/output modules. A total maximum of 1000 inputs/outputs is supported. The PL 6000 units are connected to the MC main computer via the HSCI interface. The PL 6000 units are configured with the IOconfig PC software.

Basic modules

- Basic modules with an HSCI interface exist for 4, 6, 8, and 10 modules. Fastening is performed on standard NS 35 rails (DIN 46227 or EN 50022).
- Supply voltage: DC 24 V
- Power consumption\(^1\):
  - \(\approx\) 48 W at DC 24 V NC
  - \(\approx\) 21 W at DC 24 V PLC
- Mass: \(\approx\) 0.65 kg to 1 kg (depending on the version)

\(^1\) PLB 6xxx completely filled, incl. TS, TT

System PL with EnDat support

- Required once for each control system (except with UxC)
- Connections for TS and TT touch probes
- TS and TT touch probes with EnDat interface are supported
- Without FS: 12 free inputs, 7 free outputs
  - With FS: 6 free FS inputs, 2 free FS outputs
- Functional safety (FS) is enabled via SIK options 160 to 166. Subsequent enabling of all FS control loops is via SIK option 169.
- Slots are equipped with cover strips

- PLB 6204: For 4 I/O modules ID 1129809-xx
- PLB 6206: For 6 I/O modules ID 1129812-xx
- PLB 6208: For 8 I/O modules ID 1129813-xx
- PLB 6210: For 10 I/O modules ID 1278136-xx

- PLB 6204 FS: For 4 I/O modules ID 1223032-xx
- PLB 6206 FS: For 6 I/O modules ID 1223033-xx
- PLB 6208 FS: For 8 I/O modules ID 1223034-xx
- PLB 6210 FS: For 10 I/O modules ID 1290089-xx

Note about the "Gen 3 ready" label:
The label expresses the fact that a component is basically ready for operation in a Gen 3 (Gbit HSCI) drive system. Whether a component is suitable for functional safety (FS), integrated FS, external FS, enabling of FS must be considered separately.
**Expansion PL**

For connection to the system PL to increase the number of PLC inputs/outputs:

- **PLB 6104** For 4 I/O modules ID 1129796-xx
- **PLB 6106** For 6 I/O modules ID 1129800-xx
- **PLB 6108** For 8 I/O modules ID 1129804-xx
- **PLB 6104 FS** For 4 I/O modules ID 1129796-xx
- **PLB 6106 FS** For 6 I/O modules ID 1129806-xx
- **PLB 6108 FS** For 8 I/O modules ID 1129807-xx

Up to seven PLB 6xxx units can be connected to the control.

**I/O modules**

There are I/O modules with digital and analog inputs and outputs. For partially occupied basic modules, the unused slots must be occupied by an empty housing.

- **PLD-H 16-08-00** I/O module with 16 digital inputs and 8 digital outputs ID 594243-xx
- **PLD-H 08-16-00** I/O module with 8 digital inputs and 16 digital outputs ID 650891-xx
- **PLD-H 08-04-00 FS** I/O module with 8 digital FS inputs and 4 digital FS outputs ID 589905-xx
- **PLD-H 04-08-00 FS** I/O module with 4 digital FS inputs and 8 digital FS outputs ID 727219-xx
- **PLD-H 04-04-00** HSLS FS I/O module with 4 digital FS inputs and 4 high-side/low-side FS outputs ID 746708-xx

Total current: Outputs 0 to 7: ≤ 2 A per output (≤ 8 A simultaneously)

Power output: Max. 200 W

Mass: ≤ 0.2 kg

- **PLA-H 08-04-04** Analog module for PL 6xxx with
  - 8 analog inputs, ±10 V
  - 4 analog outputs, ±10 V
  - 4 analog inputs for PT 100 thermistors

Mass: ≤ 0.2 kg

**I/O module for axis release**

Axis-release module for external safety. In combination with the PLB 620x without FS.

- **PAE-H 08-00-01** I/O module for enabling 8 axis groups ID 1203881-xx

**Accessories**

HSCI adapter for OEM machine operating panel

The PLB 600x HSCI adapter is required in order to connect an OEM-specific machine operating panel to the TNC 620.

- HSCI interface
- Connection for HR handwheel
- Inputs and outputs for keys and key illumination
- PLB 601: Terminals for 72 PLC inputs / 40 PLC outputs
- PLB 601 FS: Terminals for 36 FS inputs / 40 PLC outputs
- PLB 602 FS: Terminals for 4 FS inputs, 64 PLC inputs, and 40 PLC outputs
- Screw fastening or top-hat-rail mounting
- Configuration of the PLC inputs/outputs with the IOconfig computer software

- **PLB 6001** ID 668792-xx
- **PLB 6001 FS** ID 722083-xx
- **PLB 6002 FS** ID 1137000-xx

Mass: ≈ 1.0 kg

**IOconfig (accessory)**

PC software for configuring HSCI and PROFIBUS components

**PLB 600x (Gen3 ready)**

The PLB 600x HSCI adapter is required in order to connect an OEM-specific machine operating panel to the TNC 620.
Additional modules

Module for analog axes

Digital drive designs sometimes also require analog axes or spindles. The additional module CMA-H 04-04-00 (Controller Module Analog—HSCI) makes it possible to integrate analog drive systems in an HSCI system.

The CMA-H is integrated into the HSCI control system via a slot on the underside of the CC or UEC. Every controller unit has slots for two boards. The CMA-H does not increase the total number of available axes: every analog axis used reduces the number of available digital control loops by one. Analog control loops also need to be enabled on the SIK. The analog control-loop outputs can be accessed only via the NC, not via the PLC.

Additional module for analog axes/spindles:
- Expansion board for the CC or UEC controller units
- 4 analog outputs, ±10 V for axes/spindle
- Spring type plug-in terminals

CMA-H 04-04-00
ID 688721-xx

Fieldbus systems

An expansion board can be used to provide the TNC 620 with a PROFIBUS or PROFINET interface at any time. The modules are integrated into the control system through a slot on the MC. This makes the connection to an appropriate fieldbus system as a master possible. As of version 3.0, the interface is configured with IOconfig.

PROFIBUS DP module
- Expansion board for the MC main computer
- Connection for 9pin D-sub connector (female) to X121

PROFIBUS DP
ID 828539-xx

PROFINET IO module
- Expansion board for the MC main computer
- RJ45 connection at X621 and X622

PROFINET IO
ID 828541-xx

Combined PROFIBUS DP/PROFINET IO module
- Expansion board for the MC main computer
- RJ45 connection at X621 (PROFINET IO) and M12 connector at X121 (PROFIBUS DP)
- Additionally connectable terminating resistor for PROFIBUS DP with front LED

PROFIBUS DP and PROFINET IO
ID 1160940-xx

Electronic handwheels

The standard TNC 620 supports the use of electronic handwheels:
- HR 550 FS wireless handwheel or
- HR 510, HR 510 FS or HR 520, HR 520 FS portable handwheel or
- HR 130 panel-mounted handwheel

Several handwheels can be operated on a single TNC 620:
- One handwheel via the handwheel input of the main computer (not on main computers in the electrical cabinet)
- One handwheel each on HSCI machine operating panels or PLB 600x or PLB 600x FS HSCI adapters (for the maximum number possible, see Page 48)

The mixed operation of handwheels with and without display is not possible. Handwheels with functional safety (FS) are cross-circuit-proof due to special permissive-button logic.

HR 510 Portable electronic handwheel with:
- Keys for actual-position capture and the selection of five 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 with other symbols (see Overview for the HR 510 in Snap-on keys for the HR).

### Keys

<table>
<thead>
<tr>
<th>Keys</th>
<th>Without detent</th>
<th>With detent</th>
</tr>
</thead>
<tbody>
<tr>
<td>NC start/stop, spindle start (for basic PLC program)</td>
<td>ID 1119971-xx</td>
<td>ID 1120319-xx</td>
</tr>
<tr>
<td>FCT A, FCT B, FCT C</td>
<td>ID 1096897-xx</td>
<td>–</td>
</tr>
<tr>
<td>Spindle right/left/stop</td>
<td>ID 1184691-xx</td>
<td>–</td>
</tr>
</tbody>
</table>

HR 510 FS
- Spindle start, FCT B, NC start

Mass ≈ 0.5 kg
**HR 520**

Portable electronic handwheel with
- Display for operating mode, actual position value, programmed feed rate, spindle speed, and error messages
- Override potentiometers 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

<table>
<thead>
<tr>
<th>Without detent</th>
<th>With detent</th>
</tr>
</thead>
<tbody>
<tr>
<td>HR 520</td>
<td>ID 670302-xx</td>
</tr>
<tr>
<td>HR 520 FS</td>
<td>ID 670304-xx</td>
</tr>
</tbody>
</table>

**HR 550 FS**

Electronic handwheel with wireless transmission. Display, operating elements, and functions are like those of the HR 520
In addition:
- Functional safety (FS)
- Radio transmission range of up to 20 m (depending on environment)

<table>
<thead>
<tr>
<th>Without detent</th>
<th>With detent</th>
</tr>
</thead>
<tbody>
<tr>
<td>HR 550 FS</td>
<td>ID 1200495-xx</td>
</tr>
<tr>
<td>Replacement battery</td>
<td>For HR 550 FS</td>
</tr>
</tbody>
</table>

**HRA 551 FS**

Handwheel holder for HR 550 FS
- For docking the HR 550 FS on the machine
- Integrated battery charger for HR 550 FS
- Connections to the control and the machine
- Integrated transceiver
- HR 550 FS magnetically held to front of HRA 551 FS

<table>
<thead>
<tr>
<th>Without detent</th>
<th>With detent</th>
</tr>
</thead>
<tbody>
<tr>
<td>HRA 551 FS</td>
<td>ID 1119052-xx</td>
</tr>
<tr>
<td>Mass</td>
<td>≈ 0.7 kg</td>
</tr>
</tbody>
</table>

For more information, see the HR 550 FS Product Information document.

**Connecting cables**

<table>
<thead>
<tr>
<th>HR 510</th>
<th>HR 510 FS</th>
<th>HR 520</th>
<th>HR 520 FS</th>
<th>HR 550 FS with HRA 551 FS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Connecting cable (spiral cable) to HR (3 m)</td>
<td>–</td>
<td>–</td>
<td>✓</td>
<td>✓</td>
</tr>
<tr>
<td>Connecting cable with metal armor</td>
<td>✓</td>
<td>✓</td>
<td>–</td>
<td>–</td>
</tr>
<tr>
<td>Connecting cable without metal armor</td>
<td>–</td>
<td>–</td>
<td>✓</td>
<td>✓</td>
</tr>
<tr>
<td>HR adapter cable to MC, straight connector</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
<td>–</td>
</tr>
<tr>
<td>Extension cable to adapter cable</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
</tr>
<tr>
<td>Adapter cable for HRA to MC</td>
<td>–</td>
<td>–</td>
<td>–</td>
<td>–</td>
</tr>
<tr>
<td>Extension cable to adapter cable</td>
<td>–</td>
<td>–</td>
<td>–</td>
<td>–</td>
</tr>
<tr>
<td>Adapter connector for handwheels without functional safety</td>
<td>–</td>
<td>✓</td>
<td>✓</td>
<td>–</td>
</tr>
<tr>
<td>Adapter connector for handwheels with functional safety</td>
<td>–</td>
<td>✓</td>
<td>–</td>
<td>✓</td>
</tr>
</tbody>
</table>

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 "Accessories" under Cable overview.

**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.

<table>
<thead>
<tr>
<th>Without detent</th>
<th>With detent</th>
</tr>
</thead>
<tbody>
<tr>
<td>HR 130</td>
<td>ID 540940-03</td>
</tr>
<tr>
<td>Mass</td>
<td>≈ 0.3 kg</td>
</tr>
</tbody>
</table>
## Industrial PCs/ITC

### Additional operating station with touchscreen

The additional ITC operating stations (Industrial Thin Client) from HEIDENHAIN are convenient solutions for the additional, decentralized operation of the machine or of machine units such as tool-changing stations. The remote operation strategy, which is tailored to the TNC 620, makes it very easy to connect the ITC over a standard Ethernet connection with a cable length of up to 100 m. All ITCs fulfill IP54 when installed.

Connecting an ITC is very easy: as soon as the TNC 620 identifies an ITC, it provides it with a current operating system. After booting of the ITC, the complete content of the control’s screen is mirrored 1:1 on the ITC’s screen. As a result of this plug&play principle, no configuration by the machine manufacturer is necessary. With the standard configuration of the Ethernet interface at X116, the TNC 620 integrates the ITC into the system fully self-sufficiently.

The ITC 855 is a compact additional operating station for control systems with a 15-inch or 19-inch main screen. Along with the ASCII keyboard and touchscreen it also has the most important function keys of the TNC 620. The ITC 855 adjusts its resolution automatically to fit the size of the main screen.

<table>
<thead>
<tr>
<th>ITC 855</th>
<th>ID number</th>
<th>ID 1370459.xx</th>
</tr>
</thead>
<tbody>
<tr>
<td>Mass</td>
<td>≈ 6.4 kg</td>
<td></td>
</tr>
<tr>
<td>Installation type</td>
<td>Operating panel</td>
<td></td>
</tr>
<tr>
<td>Monitor</td>
<td>15-inch touchscreen (1024 x 768 pixels) Low-end</td>
<td></td>
</tr>
<tr>
<td>Processor</td>
<td>Intel</td>
<td></td>
</tr>
<tr>
<td>RAM</td>
<td>2 GB</td>
<td></td>
</tr>
<tr>
<td>Power consumption</td>
<td>≈ 35 W</td>
<td></td>
</tr>
</tbody>
</table>

### IPC 306 for Windows

With the IPC 306 industrial PC, you can start and remotely operate Windows-based applications via the user interface of the TNC 620. The user interface is displayed on the control screen. Option 133 is required for this.

Since Windows runs on the industrial PC, it does not influence the NC machining process. The IPC is connected to the NC main computer via Ethernet. No second screen is necessary, since the Windows applications are displayed on the screen of the TNC 620 via remote accesses.

Along with the industrial PC, a separately orderable hard disk is required for operation. Windows 8, 10 or 11 can be installed on the empty data carrier as the operating system.

<table>
<thead>
<tr>
<th>IPC 306</th>
<th>ID number</th>
<th>ID 1179966.xx</th>
</tr>
</thead>
<tbody>
<tr>
<td>Installation type</td>
<td>Electrical cabinet</td>
<td></td>
</tr>
<tr>
<td>Mass</td>
<td>≈ 4.2 kg</td>
<td></td>
</tr>
<tr>
<td>RAM</td>
<td>8 GB</td>
<td></td>
</tr>
<tr>
<td>Processor</td>
<td>Intel high performance processor</td>
<td></td>
</tr>
<tr>
<td>Power consumption</td>
<td>65 W</td>
<td></td>
</tr>
<tr>
<td>SSDR solid-state memory</td>
<td>ID 1252884-51</td>
<td></td>
</tr>
<tr>
<td>Memory space</td>
<td>≈ 240 GB</td>
<td></td>
</tr>
<tr>
<td>HDMI adapter cable for commissioning</td>
<td>ID 1333118-01</td>
<td></td>
</tr>
</tbody>
</table>
Control of auxiliary axes

The PNC 610 auxiliary axis control is designed for controlling PLC axes independently of the TNC 620. The PNC 610 does not have an NC channel and thus cannot perform interpolating NC movements. With the IPC auxiliary computer, SIK, and CFR storage medium, the PNC 610 is a separate HSCI system, which can be expanded with HEIDENHAIN inverters. In the standard version the PNC 610 already includes six PLC axis releases as well as software option 46 (Python OEM Process). The PLC basic program contains a Python interface for pallet management that is adaptable by the machine manufacturer.

The system’s design is identical to that of the TNC 620. All relevant HEIDENHAIN tools and a basic program can be used. The position information can be transmitted over PROFIBUS DP (optional), PROFINET IO (optional), or TCP/IP (integrated, system is not capable of real-time), regardless of the platform.

Auxiliary computer
The IPC auxiliary computer features the following:
- Intel mid-level processor
- RAM main memory
- HSCI interface to the CC controller unit or to the UxC and to other control components
- USB 3.0 ports

The following components must be ordered separately by the OEM and installed in the auxiliary computer:
- CFR memory card with the NC software
- System identification Key component (SIK) for enabling software options

The following HSCI components are required for operating the PNC 610:
- IPC auxiliary computer
- Controller unit
- RLB 62xx PLC I/O unit (system PL, integrated into UxC)

Interfaces
USB 3.0 and Ethernet are available on the MC. The connection to PROFINET IO or PROFIBUS DP is possible via an additional module.

Design
IPC 6490
ID number: ID 1039641-xx
Installation type: Electrical cabinet
Mass: 2.3 kg
Power consumption: 48 W
RAM: 2 GB
Processor: Intel Celeron

IPC 8420
ID number: ID 1249610-xx
Installation type: Operating panel (IP64 when installed)
Mass: 6.6 kg
Power consumption: 48 W
Monitor: 15.6-inch touchscreen (1366 x 768 pixels)
RAM: 2 GB
Processor: Intel Celeron

Export version
Because the entire NC software is saved on the CFR CompactFlash storage medium, no export version is required for the main computer itself. The NC software of the PNC 610 needs no export license.

Software options
The performance of the PNC 610 can also be adapted to the actual requirements at a later time through software options. Software options are enabled and saved in the SIK component through the entry of keywords based on the SIK number. Please provide the SIK number when ordering new options.

<table>
<thead>
<tr>
<th>Option number</th>
<th>Option ID</th>
<th>Comment</th>
</tr>
</thead>
<tbody>
<tr>
<td>18</td>
<td>HEIDENHAIN DNC</td>
<td>Communication with external PC applications over COM component</td>
</tr>
<tr>
<td>24</td>
<td>Gantry Axes</td>
<td>Gantry axes via master-slave torque control</td>
</tr>
<tr>
<td>135</td>
<td>Synchronizing</td>
<td>Advanced synchronization of axes and spindles</td>
</tr>
<tr>
<td>141</td>
<td>Cross Talk Comp.</td>
<td>CTC: compensation of axis couplings</td>
</tr>
<tr>
<td>142</td>
<td>Pos. Adapt. Control</td>
<td>PAC: position-dependent adaptation of control parameters</td>
</tr>
<tr>
<td>143</td>
<td>Load Adapt. Control</td>
<td>LAC: load-dependent adaptation of control parameters</td>
</tr>
<tr>
<td>144</td>
<td>Motion Adapt. Control</td>
<td>MAC: motion-dependent adaptation of control parameters</td>
</tr>
<tr>
<td>160</td>
<td>Integrated FS: Basic</td>
<td>Enables functional safety and four safe control loops</td>
</tr>
<tr>
<td>161</td>
<td>Integrated FS: Full</td>
<td>Enables functional safety and the maximum number of safe control loops</td>
</tr>
<tr>
<td>162</td>
<td>Add. FS Ctrl. Loop 1</td>
<td>Additional control loop 1</td>
</tr>
<tr>
<td>163</td>
<td>Add. FS Ctrl. Loop 2</td>
<td>Additional control loop 2</td>
</tr>
<tr>
<td>164</td>
<td>Add. FS Ctrl. Loop 3</td>
<td>Additional control loop 3</td>
</tr>
<tr>
<td>165</td>
<td>Add. FS Ctrl. Loop 4</td>
<td>Additional control loop 4</td>
</tr>
<tr>
<td>166</td>
<td>Add. FS Ctrl. Loop 5</td>
<td>Additional control loop 5</td>
</tr>
<tr>
<td>169</td>
<td>Add. FS Full</td>
<td>Enables all AS options or control loops. Options 160 and 162 to 166 must already be set.</td>
</tr>
</tbody>
</table>

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**Storage medium**
The storage medium is a CFR (= CompactFlash Removable) compact flash memory card. It contains the NC software and must be ordered separately from the main computer. The NC software is based on the HEIDENHAIN HEROS 5 operating system.

<table>
<thead>
<tr>
<th>CFR CompactFlash, 30 GB</th>
<th>ID 1102057-xx</th>
</tr>
</thead>
<tbody>
<tr>
<td>No export license required</td>
<td></td>
</tr>
<tr>
<td>NC software</td>
<td>817691-xx</td>
</tr>
<tr>
<td>Free PLC memory space</td>
<td>4 GB</td>
</tr>
<tr>
<td>Free NC memory space</td>
<td>77 GB</td>
</tr>
</tbody>
</table>

**SIK component**
The SIK component holds the NC software license for enabling software options. It provides the main computer with an unambiguous ID code—the SIK number. The SIK component is ordered and shipped separately. It must be inserted into a special slot in the IPC auxiliary computer. The SIK component of the PNC can enable six axes. The enabling of up to the maximum number of ten axes must be performed via the UMC compact inverter.

| SIK component for PNC 610 | ID 61763-53 |

**Snap-on keys for handwheels**
The snap-on keys make it easy to replace the key symbols. In this way, the HR handwheel can be adapted to different requirements.

**Overview for HR 520, HR 520 FS, and HR 550 FS**

<table>
<thead>
<tr>
<th>Axis keys</th>
<th>Orange</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>ID 330816-42</td>
</tr>
<tr>
<td>B</td>
<td>ID 330816-26</td>
</tr>
<tr>
<td>C</td>
<td>ID 330816-23</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Gray</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
</tr>
<tr>
<td>B</td>
</tr>
<tr>
<td>C</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Machine functions</th>
</tr>
</thead>
<tbody>
<tr>
<td>Black</td>
</tr>
<tr>
<td>ID 330816-1X</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Spindle functions</th>
</tr>
</thead>
<tbody>
<tr>
<td>Red</td>
</tr>
<tr>
<td>ID 330816-28</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Other keys</th>
</tr>
</thead>
<tbody>
<tr>
<td>Black</td>
</tr>
<tr>
<td>ID 330816-01</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Overall view</th>
</tr>
</thead>
<tbody>
<tr>
<td>Black</td>
</tr>
<tr>
<td>ID 330816-01</td>
</tr>
</tbody>
</table>

---

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---

33
Overview for HR 510 and HR 510 FS

Axis keys
- Orange: ID 1092562-02, ID 1092562-05, ID 1092562-08
- Gray: ID 1092562-04, ID 1092562-07

Other keys
- Green: ID 1092562-30
- Red: ID 1092562-28, ID 1092562-29
- Black: ID 1092562-31, ID 1092562-32
- Orange: ID 1092562-33

Machine functions
- Black: ID 1092562-44, ID 1092562-43
- Green: ID 1092562-19, ID 1092562-22
- Red: ID 1092562-41

Spindle functions
- Red: ID 1092562-18

Overview for Snap-on keys

The snap-on keys make it easy to replace the key symbols, thus allowing the keyboard to be adapted to different requirements.

Overview
- Orange: ID 679843-31, ID 679843-54
- Gray: ID 679843-32, ID 679843-55
- Black: ID 679843-33, ID 679843-56

Machine functions
- Red: ID 679843-03
- Green: ID 679843-04
- Black: ID 679843-05
- Orange: ID 679843-06
- Black: ID 679843-31
- Black: ID 679843-32
- Black: ID 679843-33
- Red: ID 679843-34

Spindle functions
- Red: ID 679843-07
- Black: ID 679843-08
- Black: ID 679843-09
- Black: ID 679843-10
- Black: ID 679843-11
- Black: ID 679843-12

Other keys
- Green: ID 1092562-09, ID 1092562-10
- Black: ID 1092562-11
- Black: ID 1092562-12
- Black: ID 1092562-13
- Black: ID 1092562-14
- Black: ID 1092562-15
- Black: ID 1092562-16
- Black: ID 1092562-17
- Black: ID 1092562-18
- Black: ID 1092562-19
- Black: ID 1092562-20
- Black: ID 1092562-21
- Black: ID 1092562-22
- Black: ID 1092562-23
- Black: ID 1092562-24
- Black: ID 1092562-25
- Black: ID 1092562-26
- Black: ID 1092562-27
- Black: ID 1092562-28
- Black: ID 1092562-29
- Black: ID 1092562-30
- Black: ID 1092562-31
- Black: ID 1092562-32
- Black: ID 1092562-33
- Black: ID 1092562-34
- Black: ID 1092562-35
- Black: ID 1092562-36
- Black: ID 1092562-37
- Black: ID 1092562-38
- Black: ID 1092562-39
- Black: ID 1092562-40
- Black: ID 1092562-41
- Black: ID 1092562-42
- Black: ID 1092562-43
- Black: ID 1092562-44
Cable overview
Control system with CC or UEC (integrated keyboard)

Spindle functions
- ID 679843:18
- ID 679843:19
- ID 679843:20
- ID 679843:21
- ID 679843:46

Other keys
- ID 679843:15
- ID 679843:17
- ID 679843:33
- ID 679843:34
- ID 679843:35
- ID 679843:36
- ID 679843:37
- ID 679843:38

Special keys
Keycaps can also be made with special key symbols for special applications. If you need keys for special applications, please consult your contact person at HEIDENHAIN.

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Control system with CC or UEC (separate keyboard)

Encoders
线路滤波器

在通向电机的电源电缆上，请参见“HEIDENHAIN Motors”手册。

对于最大长度，请参见“Gen 3 Drives”技术手册。

对电源端子，请参见“HEIDENHAIN Motors”手册。

对于最大长度，请参见“Gen 3 Drives”技术手册。

对电源端子，请参见“HEIDENHAIN Motors”手册。
Technical description
Digital control design

Uniformly digital
In the uniformly digital control design from HEIDENHAIN, all of the components are connected with each other via purely digital interfaces. A high degree of availability for the entire system, from the main computer to the encoder, is thereby achieved, with the system being diagnosable and immune to noise. The outstanding characteristics of the uniformly digital design from HEIDENHAIN guarantee very high accuracy and surface finish quality, combined with high traversing speeds.

Connection of the components:
• Control components via HSCI (HEIDENHAIN Serial Controller Interface), the HEIDENHAIN real-time protocol for Gigabit Ethernet
• Encoders via the EnDat 2.2 bi-directional interface from HEIDENHAIN
• Power modules via digital optical fiber cables

HSCI
HSCI, the HEIDENHAIN Serial Controller Interface, connects the main computer, controller(s), and other control components. The connection between two HSCI components is referred to as an HSCI segment. HSCI communication in Gen 5 control systems is based on Gigabit Ethernet hardware. All HSCI components and HSCI cables must therefore be Gigabit-capable. A special interface component developed by HEIDENHAIN makes short cycle times for data transfer possible.

Main advantages of the control design with HSCI:
• Hardware platform for a flexible and scalable control system (e.g., decentralized axis systems)
• High noise immunity due to digital communication between components
• Hardware basis for implementing functional safety
• Simple wiring (commissioning, configuration)
• Inverter connection via digital optical fiber cables
• Long line lengths in the overall system
• High number of possible control loops
• High number of PLC inputs/outputs
• Decentralized arrangement of the controller units

CC or UEC controller units, up to nine PL 6000 PLC I/O modules, and machine operating panels can be connected to the serial HSCI bus of the MC main computer. The HR handwheel is connected directly to the machine operating panel. The combination of monitor and main computer is especially advantageous if the computer is housed in the operating panel. Besides the power supply, all that is then required is an HSCI line to the controller unit in the electrical cabinet.

Maximum cable lengths for HSCI:
• For an HSCI segment: 70 m
• For up to 12 HSCI slaves: 200 m (total of all HSCI segments)
• For up to 13 HSCI slaves (maximum configuration): 180 m (total of all HSCI segments)

The order of the HSCI slaves can be freely chosen.

The maximum permissible number of individual HSCI participants is listed below:

<table>
<thead>
<tr>
<th>Gbit HSCI component</th>
<th>Maximum number in the control system</th>
</tr>
</thead>
<tbody>
<tr>
<td>MC, IPC</td>
<td>HSCI master</td>
</tr>
<tr>
<td>CC, UEC (drive-control motherboards)</td>
<td>HSCI slave</td>
</tr>
<tr>
<td>UVR</td>
<td>HSCI slave</td>
</tr>
<tr>
<td>MB, PLB 600x</td>
<td>HSCI slave</td>
</tr>
<tr>
<td>PLB 6xxx [integrated in UEC 3xx (FS)]</td>
<td>HSCI slave</td>
</tr>
<tr>
<td>PLB 6xxx FS [integrated in UEC 3xx FS]</td>
<td>HSCI slave</td>
</tr>
<tr>
<td>HR</td>
<td></td>
</tr>
<tr>
<td>PLD-H xxxxxxx FS</td>
<td>In PLB 6xxx FS</td>
</tr>
<tr>
<td>PLD-H xxxxxxx</td>
<td>In PLB 6xxx (FS)</td>
</tr>
<tr>
<td>PLA-H xxxxxxx</td>
<td>In PLB 62xx</td>
</tr>
<tr>
<td>UEC 3xx for external safety</td>
<td>HSCI slave (PAE module integrated)</td>
</tr>
</tbody>
</table>

1) For more information on the NCK software, see the Technical Manual of the respective control.
2) Total maximum of 1000 inputs/outputs and maximum of 10 PL units (PL, PLB, MB, TE)
3) Only in systems without integrated functional safety (FS)
Control systems with integrated functional safety (FS)

Basic principle
With controls with integrated functional safety (FS) from HEIDENHAIN, Safety Integrity Level 2 (SIL 2) as per the standard EN 61508 and Performance Level “d” Category 3 as per EN ISO 13849-1 can be attained. In these standards, the assessment of safety-related systems is based on, among other things, the failure probabilities of integrated components and subsystems. This modular approach aids the manufacturers of safety-related machines in implementing their systems, since they can then build upon prequalified subsystems. This design is taken into account for the TNC 620 control, as well as for safety-related position encoders. Two redundant, mutually independent safety channels form the basis of the controls with functional safety (FS). All safety-relevant signals are captured, processed, and output via two channels. Errors are detected through a reciprocal data comparison of the two channels’ states. Consequently, the occurrence of a single error in the control does not cause a loss in safety functionality.

Design
The safety-related controls from HEIDENHAIN have a dual-channel design with mutual monitoring. The SPLC (safety-related PLC program) and SKERN (safety kernel software) software processes are the basis of the two redundant systems. The two software processes run on the MC main computer (CPU) and CC controller unit components. The dual-channel configuration through MC and CC is continued in the PLB 6xxx FS I/O systems and MB machine operating panel with FS. This means that all safety-relevant signals (e.g., permissive buttons, door contacts, emergency stop buttons) are captured via two channels, and are evaluated independently of each other by the MC and CC. The MC and CC use separate channels to also address the power modules, and to stop the motors in the event of an error.

Components
In systems with functional safety, certain hardware components assume safety-relevant tasks. In systems with FS, only safety-relevant components are permitted to be used that, including their variant from HEIDENHAIN, are approved for this. Control components with functional safety FS can be recognized by the addition of “FS” after the type designation (e.g., TE 361FS).

For a current list of the components approved for functional safety (FS), refer to Functional safety (FS) supplement to the Technical Manual (ID 1177599).

MB and TE
An MB machine operating panel with functional safety is indispensable for systems with FS. Only on such a machine operating panel do all keys have a dual-channel design. Axes can be moved without additional permissive keys.

PLB
In systems with functional safety (FS), a combination of hardware (FS and standard) is possible, but a PLB 62xx FS is mandatory.

HR
In systems with functional safety (FS), FS handwheels are required because they are the only ones equipped with the required cross-circuit-proof permissive buttons.

Safety functions
Safety functions integrated into hardware and software:
- Safe stop reactions (SS0, SS1, and SS2)
- Safe torque off (STO)
- Safe operating stop (SOS)
- Safety limited speed (SLS)
- Safety limited position (SLP)
- Safe brake control (SBC)
- Safe operating modes
  - Operating mode 1: Automated or production mode
  - Operating mode 2: Set-up mode
  - Operating mode 3: Manual intervention
  - Operating mode 4: Advanced manual intervention, process monitoring

Please note: Full functionality is not yet available for all machine types with functional safety (FS). Before planning a machine with functional safety (FS), please determine whether the current scope of features is sufficient for your machine design.

Activation of functional safety (FS)
The following requirements are absolutely necessary:
- At least one PLB 62xx FS must be present in the system
- Safety-relevant control components in FS design (e.g., MB 72x FS, TE 735 FS, HR 550 FS)
- Safety-related SPLC program
- Configuration of safe machine parameters
- Wiring of the machine for systems with functional safety (FS)

Functional safety (FS) can be scaled via software options 160 to 166 and 169 (see Page 13). Only the number of safe drive systems actually needed must be enabled.

For every active drive that is assigned to a safe axis group, a safe control loop must be enabled. The control will otherwise display an error message.

For more information
For details, see the Functional Safety FS Technical Manual. Your contact person at HEIDENHAIN will be glad to answer any questions concerning controls with functional safety (FS).
Control systems with external safety

Basic principle

In control systems without integrated functional safety (FS), no integrated safety functions, such as safe operating modes, safe speed monitoring, or safe operating stop, are available. Such functions must be implemented entirely with the help of external safety components.

Control systems without integrated functional safety (FS) solely support the realization of the safety functions STO (safe torque off: dual-channel interruption of the motor power supply) and SBC (safe brake control: dual-channel triggering of the motor holding brakes). The dual-channel redundancy of the functions must be realized by the OEM through appropriate wiring.

Design

In control systems with external safety, a special PL module for the dual-channel triggering of STO and SBC is absolutely necessary. This module is the PAE-H 08-00-01, with which up to eight axis groups can be individually controlled.

Operating system

HEROS 5

The TNC 620 and PNC 610 work with the real-time capable HEROS 5 operating system (HEIDENHAIN Realtime Operating System). This future-oriented operating system contains the following powerful functions as part of its standard repertoire:

Network
- Network: management of network settings
- Remote Desktop Manager: management of remote applications
- Printer: management of printers
- Shares: management of network shares
- VNC: virtual network computing server

Safety
- Portscan (OEM): port scanner
- Firewall: protection against undesired network access
- SELinux: protection against unauthorized changes to system files
- Sandbox: running applications in separated environments

System
- Backup/Restore: function for backing-up and restoring the software on the control
- HELogging: evaluation and creation of log files
- Per12: system monitor
- User administration: define users with different roles and access permissions

Tools
- Web browser: Firefox®
- Document Viewer: display PDF, TXT, XLSX and JPEG files
- File Manager: file explorer for managing files and memory media
- Gnumeric: spreadsheet calculations
- Leafpad: text editor for creating notes
- Ristretto: display of image files
- Orage Calendar: simple calendar function
- Screenshot: creation of screendumps
- Totem: media player for playing audio and video files

User administration

The improper operation of a control often leads to unplanned machine downtime and costly scrap. The user administration feature can significantly improve process reliability through the systematic avoidance of improper operation. Through the configurable linkage of rights with user roles, access can be tailored to the activities of the respective user.

- Logging on to the control with a user account
- User-specific HOME folder for simplified data management
- Role-based access to the control and network data

* Firefox is a registered trademark of the Mozilla Foundation
Axes

**Linear axes**
Depending on its configuration, the TNC 620 can control linear axes with any axis designation (X, Y, Z, U, V, W, ...).

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

Feed rate override: 0% to 150%

**Traverse range**
The machine manufacturer defines the traverse range. The user can additionally limit the range of traverse in order to limit the working space. Three different traverse ranges can be defined (selection via PLC).

**Rotary axes**
The TNC 620 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 Feed rate in degrees per minute [°/min]

**Traverse range**
The machine manufacturer defines the traverse range. The user can additionally limit the range of traverse in order to limit the working space. Various traverse ranges can be defined via parameter sets for each axis (selection via PLC).

**Cylinder Surface Interpolation (software option 8)**
A contour defined in the working plane is machined on a cylindrical surface.

**Tilting the Working Plane (software option 8)**
The TNC 620 has special coordinate transformation cycles for controlling swivel heads and tilting tables. The tool lengths and the offset of the tilting axes are compensated for by the TNC.

The TNC can manage more than one machine configuration (e.g., different swivel heads).

**5-Axis Machining (software option 9)**
Tool Center Point Management (TCPM)
The offset of the tilting axes is compensated for in a manner such that the position of the tool tip relative to the contour is maintained. Even during machining, handwheel positioning commands can be superimposed such that the tool tip remains on the programmed contour.

**Synchronized Axes (software option 24)**
Synchronized axes move in synchronism and are programmed with the same axis designation.

With HEIDENHAIN controls, parallel axis systems (gantry axes) such as on portal type machines or tilting tables can be moved synchronously to each other through high-accuracy and dynamic position control.

In the case of gantry axes, multiple gantry slave axes can be assigned to a single master axis. They may also be distributed to multiple controller units.

**Torque Control (software option 24)**
Torque control is used on machines with mechanically coupled motors, for which

- a defined distribution of drive torque is desired,
- or parts of the controlled system show a backlash effect that can be eliminated by "tensioning" the motors (e.g. toothed racks).

For torque control, the master and slave must be on the same controller motherboard. Depending on the controller unit being used, up to five slave axes can thereby be configured for each master.
Batch Process Manager provides functions for the planning and execution of multiple production jobs on the TNC. It makes it possible to easily edit pallets and to alter the sequence of pending jobs. Batch Process Manager also performs a duration calculation for all planned jobs or NC programs. It informs the user as to whether, for example, all NC programs can be executed without error or whether all required tools are available with sufficient tool life. Batch Process Manager thereby ensures the smooth execution of the planned jobs. Batch Process Manager requires software option 22 (Pallet Management) to be enabled.

PLC axes

Axes can be defined as PLC axes. Programming is performed through M functions or OEM cycles. The PLC axes are positioned independently of the NC axes and are therefore designated as asynchronous axes.

Overview

The TNC 620 contouring control operates in conjunction with the HEIDENHAIN inverter systems with field-oriented control. As an alternative, an analog nominal speed value can be output.

Controller unit

With the CC controller units and the UxC inverters, a fundamental PWM frequency can be set for each output. In this case, every output can have its own fundamental PWM frequency (e.g., with the CC 306: X551 = 4 kHz, X552 = 5 kHz, etc.). Possible fundamental frequencies are 3.33 kHz, 4 kHz, or 5 kHz. With software option 49 (Double Speed), this frequency can be increased to up to 16 kHz for fast-turning spindles (e.g., HF spindles).

Maximum spindle speed

The maximum spindle speed is calculated as follows:

\[ n_{\text{max}} = \frac{f_{\text{PWM}} \times 60000}{NPP} \text{ rpm} \]

- \( f_{\text{PWM}} \): PWM frequency in Hz
- \( NPP \): Number of pole pairs

Operating mode switchover

For controlling the spindle, different parameter sets can be saved for closed-loop control (e.g., for wye or delta connections). You can switch between the parameter sets in the PLC.

Position-controlled spindle

The position of the spindle is monitored by the control.

Encoder

HEIDENHAIN rotary encoder with sinusoidal voltage signals (1 Vpp) or EnDat interface.

Tapping

There are special cycles for tapping with or without a floating tap holder. For tapping without a floating tap holder, the spindle must be operated under position control.

Spindle orientation

With a position-controlled spindle, the spindle can be positioned exactly to 0.1°.

Spindle override

0% to 150%

Gear stages

A specific nominal speed can be defined for each gear stage. The gear code is output via 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 their measuring standard a grating consisting of alternating lines and spaces. Relative movement between the scanning head and the scale causes the output of sinusoidal scanning signals. The measured value is calculated by counting the signals.

Reference mark
After the machine has been switched on, the relationship between the measured value and the machine position must be established by traversing the reference marks. For encoders with distance-coded reference marks, the maximum travel until automatic reference mark storage 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 \(\sim 1 \text{ VPP}\) 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. For cyclical closed-loop operation, position information from incremental signals can be used, or from serial absolute signals (EnDat 2.2) with very short cycles.

EnDat interface
The TNC 620 features the serial EnDat 2.2 interface (includes EnDat 2.1) for the connection of absolute encoders.

Note: The EnDat interface on HEIDENHAIN encoders differs in its pin layout from the interface on Siemens motors with integrated absolute ECN/EQN rotary encoders. Special adapter cables are available.

Encoder inputs
Incremental and absolute linear, angle, or rotary encoders from HEIDENHAIN can be connected to the encoder inputs of the controller unit (only purely serial encoders with EnDat 2.2 can be connected to mini-I/O connectors).

<table>
<thead>
<tr>
<th>Channel inputs</th>
<th>Signal level/Interface</th>
<th>Input frequency</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Incremental signals</td>
<td>(\sim 1 \text{ VPP}) EnDat 2.1</td>
<td>33 kHz/360 kHz</td>
<td>350 kHz</td>
</tr>
<tr>
<td>Absolute position values</td>
<td>EnDat 2.1 EnDat 2.2</td>
<td>–</td>
<td>–</td>
</tr>
</tbody>
</table>

Digital servo control

Integrated inverter
HEIDENHAIN synchronous or asynchronous motors are connected to the TNC 620.

Axis feedback control
The TNC 620 can be operated with feedforward control or servo lag.

Operation with feedforward control
Feedforward means that a given velocity and acceleration are adapted to the machine. Together with the values calculated from the servo lag, this given velocity and acceleration becomes the nominal value. A much lower servo lag thereby manifests itself.

Operation with servo lag
The term “servo lag” denotes the distance between the momentary nominal position and the actual position of the axis. The velocity is calculated as follows:

\[
v = k_v \cdot s_a, \quad v = \text{Velocity}, \quad k_v = \text{Position loop gain}, \quad s_a = \text{Servo lag}
\]

Compensation of torque ripples
The torque of synchronous, torque, and linear motors is subject to periodic oscillations, one cause of which can be permanent magnets. The amplitude of this torque ripple depends on the motor design and, under certain circumstances, can have an effect on the workpiece surface. During initial configuration of the axes with TNCopt, this “torque ripple” can be compensated for by means of the Torque Ripple Compensation (TRC) function of the CC or UEC.
Control-loop cycle times

The cycle time for **path interpolation** is defined as the time interval during which interpolation points on the path are calculated. The cycle time for **fine interpolation** is defined as the time interval during which interpolation points are calculated that lie within the interpolation points calculated for path interpolation. The **cycle time for the position controller** is defined as the time interval during which the actual position value is compared to the calculated nominal position value. The **cycle time for the speed controller** is the time interval in which the actual speed value is compared to the calculated nominal speed value. The **cycle time for the current controller** is defined as the time interval during which the actual value of the electrical current is compared to the calculated nominal value of the electrical current.

<table>
<thead>
<tr>
<th>CC/UEC/UMC</th>
<th>Path interpolation</th>
<th>See values on Page 6</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Fine interpolation</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Position controller</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Speed controller</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Current controller</td>
<td></td>
</tr>
</tbody>
</table>

Axis clamping

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

Double-Speed Control Loops (software option 49)

Double-speed control loops permit higher PWM frequencies and shorter cycle times for the speed controller. This enables improved current control for spindles and higher controller performance for linear and torque motors.

Crossover Position Filter (CPF)

To increase the stability of the position control loop in systems with resonances, the position signal from the position encoder, which is filtered through a low-pass filter, is combined with the position signal from the motor speed encoder, which is filtered through a high-pass filter. This signal combination is made available to the position controller as the actual position value. The possible position controller gain ($k_v$ factor) is increased significantly by this. The filter separation frequency is set specifically for each axis via machine parameters. The CPF can be used only in dual-encoder systems, i.e., on motors with a speed encoder and position encoder.

Fast contour milling

**Short block processing time**

The TNC 620 provides the following important features for fast contour machining.

- The block processing time of the MC is less than 1.5 ms. This means that during the execution of long programs from the hard drive, the TNC 620 can even mill contours approximated in 0.2 mm line segments at a feed rate of greater than 8 m/min.

**Look-ahead**

The TNC 620 calculates the geometry ahead of time in order to adjust the feed rate (max. 5000 blocks). In this way, directional changes are detected in time to accelerate or decelerate the appropriate NC axes.

**Jerk**

The derivative of acceleration is referred to as jerk. A linear change in acceleration causes a jerk step. Such motion sequences may cause the machine to oscillate.

**Jerk limiting**

To prevent machine oscillations, the jerk is limited in order to attain optimum path control.

**Smoothed jerk**

The jerk is smoothed by nominal position value filters. The TNC 620 therefore mills smooth surfaces at the highest possible feed rate and yet keeps the contour accurate. The permitted tolerance is programmed by the user via a cycle. Special filters for HSC machining (HSC filters) can suppress machine-specific natural frequencies. The desired accuracy along with very high surface quality is attained.
The Advanced Dynamic Prediction (ADP) function enhances the look-ahead of the permissible maximum feed rate profile, thereby enabling optimized motion control for clean surface finishes and perfect contours. The strengths of ADP are evident, for example, during bidirectional finish milling through symmetrical feed behavior on the forward and reverse paths as well as through particularly smooth feed rate curves on parallel milling paths. NC programs that are generated on CAM systems have a negative effect on the machining process due to various factors such as short, step-like contours; coarse chord tolerances; and heavily rounded end-point coordinates. Through an improved response to such factors and the exact adherence to dynamic machine parameters, ADP not only improves the surface quality of the workpiece but also optimizes the machining time.

During heavy machining (roughing at high cutting power), strong milling forces arise. Depending on the tool spindle speed, the resonances in the machine tool, and the chip volume (metal-removal rate during milling), the phenomenon known as “chatter” may occur. Chatter subjects the machine to heavy strain and causes ugly marks on the workpiece surface. The tool, too, undergoes heavy and irregular wear due to chatter, even breaking in extreme cases. To reduce chatter tendencies, HEIDENHAIN offers an effective option with its Active Chatter Control (ACC) solution. This option is particularly advantageous during heavy machining. ACC enables substantially higher cutting performance: depending on the machine model, the metal removal rate can be increased by 25% or more. Thus, you can reduce the load on your machine while simultaneously increasing the life of your tools.

With Optimized Contour Milling (OCM), you can machine pockets and islands of any shape while reducing tool wear thanks to highly efficient trochoidal milling. You simply program the contour as usual directly in KlarText or make use of the convenient CAD Import function. The control then automatically calculates the complex movements required for trochoidal milling. Advantages of OCM over conventional machining:

- Reduced thermal load on the tool
- Superior chip removal
- Uniform cutting conditions
- Higher possible cutting parameters
- Higher removal rates
- No need for adjustments by the machine manufacturer
- Cutting data calculator for the automatic calculation of cutting values
Dynamic Precision

Overview

The umbrella term Dynamic Precision encompasses a number of HEIDENHAIN milling solutions that significantly improve the dynamic accuracy of a machine tool. The dynamic accuracy of machine tools can be seen in the errors at the tool center point (TCP). The size of these errors depends on the magnitudes of the motion (e.g., speed and acceleration, as well as jerk) and result from the vibrations of the machine components, among other things. Taken together, all of these errors are partially to blame for dimensional errors and faults on the surfaces of workpieces. They therefore have a decisive impact on quality and, in the event of quality-related scrap, on productivity as well.

The functions of the Machine Vibration Control (MVC) software option and the expanded functions of the Motion Adaptive Control (MAC) software option characterize the second generation of Dynamic Precision.

Because the stiffness of machine tools is limited for reasons of design and economy, problems such as compliance and vibration within the machine design are very difficult to avoid. Dynamic Precision counteracts these problems with intelligent control technology to enable designers to further improve the quality and dynamic performance of machine tools. As a result, production time and cost are reduced.

The software options that make up Dynamic Precision Generation 2 can be deployed by the machine manufacturer both alone or in combination:

- **CTC**: compensates for acceleration-dependent position errors at the tool center point, thereby increasing accuracy in acceleration phases
- **MVC**: damps machine oscillations to improve workpiece surface quality through the following functions:
  - **AVD** (Active Vibration Damping)
  - **FSC** (Frequency Shaping Control)
- **PAC**: position-dependent adaptation of control parameters
- **LAC**: load-dependent adaptation of control parameters
- **MAC**: motion-dependent adaptation of control parameters

With LAC (software option 143), you can dynamically adjust controller parameters based on the load or friction.

The dynamic behavior of machines with rotary tables can vary depending on the mass moment of inertia of the fixed workpiece. The Load Adaptive Control (LAC) software option allows the control to automatically determine the current mass moment of inertia of the workpiece and the current frictional forces.

In order to optimize changed control behavior at differing loads, various controller parameters (e.g., loop gains, and feedforward controls for acceleration, holding torque, static friction, and friction at high shaft speeds) can be adapted to the currently active load.

Along with the load-based modification of machine parameters through the LAC software option, the Motion Adaptive Control (MAC) software option allows machine parameters to be changed based on their initial values, such as speed, servo lag, or acceleration. Through this motion-dependent adaptation of the control parameters, a speed-dependent adaptation of the $k_v$ factor can be implemented for drive systems whose stability changes due to the different traversing speeds.

The software option MAC was enhanced with the adaptive gear-error compensation of Dynamic Precision Generation 2. Surface quality problems often do not arise from machine resonances but rather from transmission errors in mechanical components of the feed drive systems. Transmission elements in the machine tool’s power train, such as a rack and pinion, often cause unwanted shading on the workpiece surface. This results in cost-intensive rework, particularly in tool and mold making. The active gear-error compensation minimizes these periodic interferences.

CTC (software option 141) enables the compensation of dynamic position errors potentially arising from acceleration forces.

To increase productivity, machine tool users ask for ever higher feed rates and acceleration values, while at the same time needing to maintain the highest possible surface quality and accuracy, placing very special requirements on path control.

Highly dynamic acceleration processes introduce forces to the structure of a machine tool. They can deform parts of the machine and thereby lead to deviations at the tool center point (TCP). Besides deformation in axis direction, the dynamic acceleration of an axis due to mechanical axis coupling can also result in deformation of axes that are perpendicular to the direction of acceleration. The resulting position error at the TCP in the direction of the accelerated axis and lateral axes is proportional to the amount of acceleration.

If the dynamic position errors relative to the axis acceleration are known, then these acceleration-dependent errors can be compensated for by the Cross Talk Compensation (CTC) software option in order to avoid negative effects on the surface quality and accuracy of the workpiece. Often, the resulting error at the TCP depends not only on the acceleration but also on the position of the axes in the working space. This can also be compensated for by CTC.

Load Adaptive Control (LAC, software option 143)

Motion Adaptive Control (MAC, software option 144)

Cross Talk Compensation (CTC, software option 141)
Machine Vibration Control (MVC, software option 146)

The high dynamics of modern machine tools lead to deformations in the machine base, frame, and drive train during acceleration and deceleration of the feed motors. This results in vibrations, such as machine setup vibrations, that may reduce the attainable accuracy and surface quality of the workpieces. With Machine Vibration Control (MVC, software option 146), two functions that effectively suppress low-frequency vibrations are available.

Active Vibration Damping (AVD)

The Active Vibration Damping (AVD) controller function increases dynamic rigidity and damps the especially critical low-frequency oscillations. At the same time, it optimizes the control behavior of the affected axis so that high-accuracy workpieces with excellent surface quality can also be produced at high feed rates.

Frequency Shaping Control (FSC)

The Frequency Shaping Control (FSC) function suppresses the inducement of low-frequency oscillations through a specific feedforward control. This can be used to increase dynamic limit values (e.g. jerk), and therefore make reduced machining times possible.

The combination of the two functions (AVD and FSC) optimizes the dynamics, surface quality, and productivity.

Position Adaptive Control (PAC, software option 142)

Position Adaptive Control (PAC, software option 142) permits the dynamic, position-dependent adaption of controller parameters based on the spatial position of the tool.

The specifics of a machine’s kinematics cause a unique position of the axes’ center of gravity in the working space. This results in a variable dynamic behavior of the machine, which can negatively influence the control’s stability depending on the axis positions.

To take full advantage of the machine’s dynamic performance, the Position Adaptive Control (PAC) software option enables changes to machine parameters based on position, thus permitting assignment of the respective optimal loop gain to defined interpolation points. Additional position-dependent filter parameters can be defined in order to further increase control loop stability.

Monitoring functions

| Description | During operation the control monitors the following details, among others:
| Amplitude of encoder signals |
| Edge separation of encoder signals |
| Absolute position for encoders with distance-coded reference marks |
| Current position (servo lag monitoring) |
| Actual path traversed (movement monitoring) |
| Position deviation at standstill |
| Nominal speed value |
| Checksum of safety-related functions |
| Supply voltage |
| Voltage of the buffer battery |
| Operating temperature of MVC and CPU |
| Run time of PLC program |
| Motor current / motor temperature |
| Temperature of power module |
| DC-link voltage |
| Difference between position and speed encoder (PosDiff) |
| Serial connection of all devices in the HSCI chain |
| Quality of optical connections between CC and UM |
| Voltages of the main power supply |
| Utilization of the 24 V supply |

With EnDat 2.2 encoders:
| CRC checksum of the position value |
| EnDat alarm Error1 = EnDat status alarm register (0xEE) |
| EnDat alarm Error2 |
| Edge speed of 5 µs |
| Transmission of the absolute position value on the time grid |

In the event of hazardous errors, an EMERGENCY STOP message is sent to the external electronics via the control-ready output, and the axes are brought to a stop. The correct connection of the TNC 620 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.

*) No safety functions
Context-sensitive help

A context-sensitive help function is available to the user via the HELP key or ERR key. In the event of an error message, the control displays the cause of the error and the possibilities for fixing it. The machine manufacturer can also implement this user support for PLC error messages.

CAD Model Optimizer (software option 152)

The CAD Model Optimizer software option gives the operator the power to simplify and heal 3D models. The operator loads the output model into the CAD viewer. The 3D mesh function simplifies the model and autonomously corrects errors such as small holes in the solid model or self-intersecting lines on a surface. The result is a valid STL file that can be used for various functions of the control.

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

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

Visualization options range from a pure depiction of the transformation chain and a wire model all the way to the complete machine model.

Component Monitoring (software option 155)

The overloading of machine components is often the cause of expensive machine damage and unplanned production downtime. Component monitoring keeps the user informed about the current load on the spindle bearings and reacts upon exceedance of the specified limit values (e.g., with an NC stop). The MONITORING HEATMAP function allows you to color, with the status of a monitoring task from within the NC program, the concurrent material removal simulation. That way the workpiece shows you where a component was subject to a strong load.

During their lifecycle, the machine components which are subject to loads (e.g., guides, ball screws, etc.) become worn and thus the quality of the axis movements deteriorates. This, in turn, affects production quality. With Component Monitoring (option 155) and a cycle, the control is able to measure the current condition of the machine. As a result, any deviations from the machine’s shipping condition due to wear and aging can be measured. The machine manufacturer can read and evaluate the data, and react using predictive maintenance, thereby avoiding unplanned machine downtimes.

Error compensation

Overview
The TNC 620 automatically compensates for mechanical errors of the machine.

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

Nonlinear error
The TNC 620 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 during direction changes can be compensated for in length measurements by the spindle and rotary encoder. This backlash is outside the controlled system.

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

Reversal spikes
In circular movements, reversal spikes can occur at quadrant transitions due to mechanical influences. The TNC 620 can compensate for these reversal spikes.

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 620 can compensate for this problematic behavior.

Sliding friction
Sliding friction is compensated for by the speed controller of the TNC 620.

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

The temperature is measured via thermistors connected to the analog inputs of the TNC 620. The PLC evaluates the temperature information and passes a compensation value to the NC.
Using the KinematicsOpt function, machine manufacturers or users can check the accuracy of rotary or swivel axes, and compensate for possible displacements of the center of rotation of these axes. The deviations are automatically transferred to the kinematics description and can be taken into account in the kinematics calculation.

In order to measure the rotary axes, you must attach a calibration sphere (e.g., KKH 100 or KKH 250 from HEIDENHAIN) at any position on the machine table. A HEIDENHAIN touch probe uses a special cycle to probe this calibration sphere, and measures the rotary axes of the machine fully automatically. But first you define the resolution of the measurement and define for each rotary axis the range that you want to measure. The measuring process is the same, regardless of whether the rotary axis is a rotary table, tilting table, or a swivel head.

HEIDENHAIN offers calibration spheres as accessories for the measurement of rotary axes with KinematicsOpt:

- **KKH 80**
  - Height: 80 mm
  - ID 655475-03

- **KKH 250**
  - Height: 250 mm
  - ID 655475-01

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**Initial setup and diagnostic aids**

**Overview**

The TNC 620 provides comprehensive internal aids for diagnostics and initial setup. It also includes highly effective PC software for diagnostics, optimization, and remote control.

**ConfigDesign**

PC software for configuring the machine parameters
- Stand-alone machine-parameter editor for the control; all support information, additional data, and input limits are shown for the parameters
- 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)

**TNCdiag**

The HEIDENHAIN TNCdiag application evaluates the status and diagnostic information of HEIDENHAIN components (with an emphasis on the drive systems) and graphically images the data:
- Status and diagnostic information about the HEIDENHAIN components (drive electronics, encoders, input/output devices, etc.) connected to the control
- History of the recorded data

TNCdiag comes in a PC version for the analysis of servicing files and in a control version for the display of live data.

**Oscilloscope**

The TNC 620 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
- Servo lag of the position controller
- Nominal and actual values for speed, acceleration and jerk
- Content of PLC operands
- Encoder signal (0° – A) and (90° – B)
- Difference between position and speed encoder
- Nominal velocity value
- Integral-action component of the nominal current value
- Torque-determining nominal current 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)
- Timer (T)
- Counter (C)
- IPOLogik (X)
TNCopt
(accessory)
PC software for initial setup of digital control loops.
Functions (among others):
• (Automatic) initial setup of the control loops (current, speed, position)
• (Automatic) optimization of various feedforward controls
  – Reversal peaks
  – Friction parameters, acceleration feedforward control
• (Automatic) system identification
• Circular form test, contour test
• Working space scan, 3D workspace inspector

Online Monitor (OLM)
The online monitor is a component of the TNC 620 and is called with a code number. It supports initial setup and diagnosis of control components through the following:
• 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 of control-internal debug outputs

TNCscope
(accessory)
PC software for transferring the oscilloscope files to a PC. With TNCscope you can record and save up to 32 channels simultaneously.

Note: The trace files are saved in the TNCscope data format.

API DATA
With the API DATA function, the control displays the states or contents of the symbolic API markers and API double words.

Table function
The current conditions of the markers, words, inputs, outputs, counters, and timers are displayed in tables. The conditions can be changed through the keyboard.

Trace function
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.

Log
For the purpose 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.

RemoteAccess
(accessory)
PC software for remote diagnostics, monitoring and operation. RemoteAccess grants quick and easy access to HEIDENHAIN controls that are installed within the same local network (intranet).

RemoteAccess offers the following functions:
• Display of the control’s user interface on the PC
• Operating the control directly through the live view as well as with the integrated keyboard
• HEIDENHAIN PC tools are integrated automatically
• Can be enhanced with OEM-specific applications

Single station license (ID 1339577-01)
Network license (14 stations) (ID 1339577-02)
Network license (20 stations) (ID 1339577-03)

Enhancement: Secure Remote Access (SRA)
The Secure Remote Access enhancement permits setting up an encrypted remote connection to a HEIDENHAIN control via the Internet. Once the SRA connection has been set up, RemoteAccess behaves like a local network connection.

Possible applications when using SRA:
• User support
• Online seminars
• Diagnostics and service
• Other OEM services

Secure Remote Access enhancement (ID 1356741-01)

Bus diagnosis
In Diagnosis mode, the structure of the connected bus systems as well as the details of the connected components can be shown in an intuitive manner.

TNCTest
Acceptance tests on machine tools with external or integrated functional safety (FSI) must be conducted reproducibly and verifiably.
The TNCTest and TestDesign program package 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, and perform automatic configuration, as well as record data and evaluate the data semiautomatically. A tester must evaluate manually whether a test case passed or failed.

TNCanalyzer
The TNCanalyzer application from HEIDENHAIN provides for simple and intuitive evaluation of servicing and log files:
• Loading of servicing and log 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 inputs/outputs

PLC I/Os are available via the external PL 6000 and UxC. The PLC I/Os and the PROFINET I/O or PROFIBUS DP-capable I/O system must be configured with the IOconfig PC software.

PLC programming

<table>
<thead>
<tr>
<th>Format</th>
<th>Statement list</th>
</tr>
</thead>
<tbody>
<tr>
<td>Memory</td>
<td>4 GB</td>
</tr>
<tr>
<td>Cycle time</td>
<td>9 ms to 30 ms (adjustable)</td>
</tr>
</tbody>
</table>

Command set

- Bit, byte, and word commands
- Logical operations
- Arithmetic commands
- Comparisons
- Bracketed terms
- Jump commands
- Subprograms
- Stack operations
- Submit programs
- Timers
- Counters
- Comments
- PLC modules
- Strings

Encryption of PLC data

The encrypted PLC partition (PLCE:) provides the machine manufacturer with a tool for preventing third parties from viewing or changing files. The files on the PLCE partition can be read only by the control itself or by using the correct OEM keyword. This ensures that proprietary know-how and special customer-specific solutions cannot be copied or changed.

The machine manufacturer can also determine the size of the encrypted partition. This is not determined until the machine manufacturer creates the PLCE partition. Another advantage is that, in spite of the encryption, the data can be backed up from the control to a separate data medium (USB drive or network, e.g., through TNC/Remo) and later restored. You need not enter the password, but the data cannot be read until the keyword is supplied.

PLC window

The TNC 620 can display PLC error messages in the dialog line during operation.

Small PLC window

The TNC 620 can show additional PLC messages and bar graphs in the 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 also be positioned via the PLC. PLC positioning of the NC axes cannot be superimposed on NC positioning.

PLC axes

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

PLCdesign (accessory)

PC software for PLC program development. The PLC program PLCdesign can be used for easy creation of PLC programs. Extensive examples of PLC programs are included.

Functions:
- User-friendly text editor
- Menu-guided operation
- Programming of symbolic operands
- Modular programming techniques
- "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

Small PLC window
The Python OEM Process software option gives the machine manufacturer a powerful tool for using a high-level, object-oriented programming language in the control (PLC). Python is an easy-to-learn script language supporting all necessary high-level language elements.

Python OEM Process can be employed universally for machine functions, complex calculations, and the display of 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 can also be executed without enabling Python OEM Process (software option 46). Reserved for this function are 10 MB of dedicated memory. For more information, refer to the Python in HEIDENHAIN Controls Technical Manual.

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**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:

- **Axes**
  - Control of analog axes
  - Axes with clamping mode, central drive, and the Hirth grid
  - Synchronized axes
  - 3D head with C-axis mode
  - Reference run, reference end position
  - Axis lubrication

- **Spindles**
  - Control and orientation of the spindles
  - Spindle clamping
  - Alternative double-spindle operation
  - Parallel spindle operation
  - Conventional 2-stage gear system
  - Wye/delta connection switchover (static, dynamic)

- **Tool changers**
  - Manual tool changer
  - Tool changer with pick-up system
  - Tool changer with dual gripper
  - Tool changer with positively driven gripper
  - Rotating tool magazine with closed-loop axis
  - Rotating tool magazine with controlled axis
  - Servicing functions for the tool changer
  - Python tool management

- **Pallet changers**
  - Translational pallet changer
  - Rotatory pallet changer
  - Servicing functions for the pallet changer

- **Safety functions**
  - Emergency stop test (EN 13849-1)
  - Brake test (EN 13849-1)
  - Repeated switch-on test for a wireless handwheel

- **General functions**
  - Feed rate control
  - Control of the coolant system (internal, external, air)
  - Temperature compensation
  - Activate tool-specific torque monitoring
  - Hydraulic control
  - Chip conveyor
  - Indexing fixture
  - Touch probes
  - PLC support for handwheels
  - Control of doors
  - Handling of M functions
  - PLC log
  - Display and management of PLC error messages
  - Diagnosis screen (Python)
  - Python example applications
  - Status display in the small PLC window
Interfacing to the machine

OEM cycles (software option 19)
The machine manufacturer 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. Complete tool management with tool life monitoring and replacement tool monitoring is carried out by the TNC 620.

Tool measurement (software option 17)
With the TT tool touch probe systems (accessory), tools can be measured and inspected. Standard cycles for automatic tool measurement are available in the control. The control calculates the probing feed rate and the optimal spindle speed. The measured data are stored in a tool table.

Touch-probe configuration (software option 17)
All touch-probe data can be configured conveniently through the touch-probe table. All HEIDENHAIN touch probe systems are preconfigured and can be selected through a drop-down menu.

Pallet management (software option 22)
Pallet insertions can be controlled via PLC axes. The user defines the pallet sequence, pallet presets, and workpiece presets in the pallet tables. The pallet tables are freely configurable; any information can be stored in the tables and called via the PLC. Pallet table execution can be workpiece- or tool-oriented.

Data transfer and communication

Data interfaces

Overview
The TNC 620 is connected to PCs, networks, and other data storage devices via data interfaces.

Ethernet
Using the Ethernet data interface, you can network the TNC 620 based on the TCP/IP protocol. For connection to the data network, the control features a 1000BASE-T (twisted pair Ethernet) connection.

Maximum transmission distance:
Unshielded: 100 m
Shielded: 400 m

Network connection
• NFS file server
• Windows networks (SMB)

Data transfer speed
Approx. 400 to 800 Mbit/s (depending on the file type and network utilization)

Protocols
The TNC 620 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. A block check character (BCC) is used for data backup. This method improves data security.

OPC UA NC Server
Connection of an OPC UA application

USB
The TNC 620 features USB ports for connecting standard USB devices such as a mouse, disk drive, etc. The MCs have four USB 3.0 ports. One of them leads to the TE, where a cover cap protects it from contamination. More USB 2.0 ports are in the integrated USB hub on the rear of the BF. The USB ports are rated for a maximum of 0.5 A.

USB cables
Cable length up to 5 m ID 354770-xx
Cable length 6 m to 30 m with integrated amplifier; limited to USB 1.1. ID 624775-xx
Connected Machining

Overview

Connected Machining makes uniformly digital job management possible in networked manufacturing. You also profit from:

- Easy data usage
- Time-saving procedures
- Transparent processes

Remote Desktop Manager (software option 133)

Remote control and display of external computers over an Ethernet connection (e.g., Windows PC). The information is displayed on the control’s screen. Remote Desktop Manager allows you to access important applications, such as CAD/CAM applications or job management, from the control.

HEIDENHAIN DNC (software option 18)

The development environments on Windows operating systems are particularly well suited as flexible platforms for application development in order to cope 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 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 order management software

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.

For more information, refer to the HEIDENHAIN DNC brochure.
The Open Platform Communications Unified Architecture (OPC UA) standard has emerged in recent years as a well-established interface for secure and reliable data exchange in industrial environments. The HEIDENHAIN OPC UA NC Server software option makes this forward-looking interface available on the TNC 620. OPC UA features cross-operating system capability: along with the widespread Windows systems, OPC UA also allows Linux-based systems or Apple computers with macOS®, for example, to be connected to the HEIDENHAIN control.

Numerous developer toolkits are available for OPC UA. RemoTools SDK is not needed. Thanks to the standardized protocol, the freedom to choose the toolkit, and the application-oriented HEIDENHAIN information model, highly individualized applications and standard software can be developed with significantly reduced time to market.

The HEIDENHAIN OPC UA NC Server supports the following OPC UA services:
• Reading and writing variables
• Interface for accessing tool data of the TNC 620
• Subscribing to value changes
• Executing methods
• Subscribing to events

With Sign&Encrypt, HEIDENHAIN ensures that even the standard solution provides state-of-the-art IT security:
• SecurityMode: Sign&Encrypt
• Cryptographic algorithm: Basic256Sha256 (recommended by the OPC Foundation) – X.509 Certificates
• User authentication through X.509 certificates

* Apple and macOS are trademarks of Apple Inc.

Mounting information
Clearances and mounting

Proper minimum clearance
When installing the control components and power modules, take note of the minimum spacing, space needed for servicing, and the appropriate length and location of the connecting cables as detailed in the Technical Manual of the TNC 620.

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):
• Display unit (when properly installed)
• Keyboard unit (when properly installed)
• Machine operating panel (when properly installed)
• Handwheel

All electric and electronic control components must be installed in an environment (e.g., electrical cabinet, housing) with an IP54 rating (dust and splash-proof protection) in order to fulfill the requirements of pollution degree 2. All components of the OEM operating panel must also have an IP64 rating, just like the HEIDENHAIN operating panel components.

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

Intended place of operation
The units comply with EN 50370-1 and EN 61800-3, and are intended for use in industrially zoned areas.

Likely sources of interference
Interference is produced by capacitive and inductive coupling into electrical conductors or into device connections. This is caused, for example, by:
• Strong magnetic fields from transformers or electric motors
• Relays, contactors, and solenoid valves
• High-frequency equipment, pulse equipment, and switch-mode power supplies
• Power lines and leads to the above equipment

Protective measures
• Ensure that the MC, CC, and signal lines are at least 20 cm away from interfering devices
• Minimum distance of 10 cm between MC, CC, and signal lines to cables carrying interfering signals (in metal cable ducts, a grounded separation wall suffices for decoupling)
• Shielding by means of closed, grounded metal enclosures (e.g., an electrical cabinet)
• Use equipotential bonding lines in accordance with the grounding diagram (comply with the Technical Manual of your control)
• Use only genuine HEIDENHAIN cables and connecting elements

Installation elevation
The maximum elevation for installation of HEIDENHAIN control components (MC, CC, PLB, MB, TE, BF, IPC, etc.) is 3000 m above sea level.
Key dimensions
Main computer

IPC 306

MC 8410

* = Front panel opening
= Mounting surface
= Space for air circulation

Dimensions in mm:
- Tolerance: ISO 8015
- ± 0.2 mm
Operating panel, monitor, and keyboard
TE 730

- Front panel opening
- Mounting surface

TE 735, TE 735 FS

- Front panel opening
- Mounting surface
PLC inputs and outputs
Electronic handwheels

**HR 510, HR 510 FS**

- Dimensions: [diagram]
- Holder for HR 520, HR 520 FS

**HR 520, HR 520 FS**

- Dimensions: [diagram]

**HR 550 FS**

- Dimensions: [diagram]
Adapter cable for handwheels (straight)

![Diagram of adapter cable for handwheels (straight)]

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

Adapter cable for handwheels (angled)

![Diagram of adapter cable for handwheels (angled)]

Adapter cable for HR/HRA to MC (straight connector)

Adapter cable for HR/HRA to MC (angled connector)
Interface accessories

Line-drop compensator for encoders with EnDat interface

USB extension cable with hubs

KTY adapter connector

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General information

Documentation

Technical documentation
- Technical Manuals (PDF format on HESIS-Web including Filebase)
  - TNC 620 ID 1098989
  - PNC 610 ID 1191125
  - Inverter Systems for Gen 3 Drives ID 1252690
  - Functional Safety (FS) ID 749383
  - Functional Safety (FS) Supplement to the Technical Manual ID 1177959
  - Python in HEIDENHAIN Controls ID 757887
  - OPC UA NC Server ID 1305985

User documentation
- User's Manuals
  - TNC 620
    - Klartext Programming ID 1096883-xx
    - Setup, Testing, and Running NC Programs ID 1263172-xx
    - Programming of Machining Cycles ID 1303427-xx
    - Programming of Measuring Cycles for Workpieces and Tools ID 1363431-xx
    - ISO Programming ID 1096887-xx
  - General:
    - TNCremo Integrated help
    - TNCremoPlus Integrated help
    - PLCdesign Integrated help
    - CycleDesign Integrated help
    - IDconfig Integrated help
    - KinematicsDesign Integrated help

Other documentation
- Brochures
  - TNC 620 ID 896140-xx
  - Touch Probes ID 1113984-xx
  - Inverter Systems for Gen 3 Drives ID 1305180-xx
  - Motors ID 208893-xx
  - RemoTools SDX virtualTNC ID 629698-xx
  - Programming Station for TNC Controls ID 926930-xx
  - Options and Accessories for TNC Controls ID 927222-xx

- Booklets
  - HR 550 FS ID 636227-xx
  - OPC UA NC Server ID 135797-xx

- DVDs
  - Touch Probes ID 344583-xx
  - Programming station: TNC 320, TNC 620 (Demo Version) ID 741708-xx

Safety parameters
- For HEIDENHAIN products (such as control components, encoders, or motors), the safety characteristics (such as failure rates or statements on fault exclusion) are available on product-specific request from your HEIDENHAIN contact person.

Basic circuit diagram
- More information on basic circuit diagrams can be requested from your HEIDENHAIN contact person.

Service and training

Technical support
HEIDENHAIN offers technical support to the machine manufacturer in order to optimize the interfacing of the control to the machine, including on-site support.

Exchange control
In the event of a malfunction, HEIDENHAIN guarantees the timely shipment of an exchange control (usually within 24 hours in Europe).

Helpline
Our customer service technicians are available for questions regarding adaption or in the event of malfunctions:
- NC support (+49 8669 31-3101, E-mail: service.nc-support@heidenhain.de)
- Functional safety (FS) (+49 8669 31-3102, E-mail: service.plc@heidenhain.de)
- NC/Cycle programming and kinematics (+49 8669 31-3103, E-mail: service.nc-pgm@heidenhain.de)
- Encoders and machine calibration (+49 8669 31-3104, E-mail: service.ms-support@heidenhain.de)
- Application programming (+49 8669 31-3106, E-mail: service.app@heidenhain.de)
- If you have questions about repairs, spare parts, or exchange units, please contact our Service department:
  - Customer service, Germany (+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
HEIDENHAIN provides technical customer training in the following subjects:
- NC programming
- PLC programming
- TNC optimization
- TNC servicing
- Encoder servicing
- Special training for specific customers

For more information on dates or registration:
- Technical training courses in Germany (+49 8669 31-3049, Technical training)
- Technical training courses outside of Germany (www.heidenhain.com Service & Support)
Other HEIDENHAIN controls

Examples

TNC 640

- Contouring control for milling machines, milling-turning machines, and machining centers
- Axes: up to 24 control loops, of which up to 4 can be configured as spindles
- For operation with HEIDENHAIN inverter systems and ideally with HEIDENHAIN motors
- Uniformly digital with HSCI interface and EnDat interface
- Version with touchscreen for multi-touch operation
- Solid state disk (SSDR)
- Programming in HEIDENHAIN Klartext or G-code (ISO)
- Comprehensive cycle package for milling and turning operations
- Constant surface speed for turning operations
- Tool radius compensation
- Touch probe cycles
- Free contour programming (FK)
- Short block processing time (< 0.5 ms)

MANUALplus 620

- Compact contouring control for CNC and cycle lathes
- Axes: max. 10 control loops, of which up to 6 can be configured as spindles
- Suitable for horizontal and vertical lathes as well as vertical boring and turning mills
- Up to 3 principal axes (X, Z, and Y), B axis, closed-loop spindle and counter spindle, C1/C2 axis, and driven tools
- Up to 3 programmable auxiliary axes (U, V, W) for control of steady rest, tailstock, and counter spindle
- The position of a parallel secondary axis can be shown combined with its principal axis
- Compact design: screen and main computer in one unit
- For operation with HEIDENHAIN inverter systems and ideally with HEIDENHAIN motors
- Uniformly digital with HSCI interface and EnDat interface
- Intuitive multi-touch operational design
- Leading-edge functions combined with the familiarity of HEIDENHAIN Klartext: graphical programming allows beginners and experts alike to rapidly program complex workpieces
- Graphically supported alignment of workholding equipment
- Integrated process monitoring
- New, intuitive machine setup with smart probing functions
- Easy operating solutions for everyday production tasks, including complete integration of program testing with high-resolution simulation of the machining process in the Editor operating mode
- Graphical programming
- Short block processing time (< 0.5 ms)