

# ServoWorks™ CNC Product Comparison Guide

Features	ServoWorks MC-Quad	ServoWorks S-100M	ServoWorks S-120M	ServoWorks S-140M	ServoWorks S-160M	ServoWorks S-100T
Target machines	General 4-axis CNC machines without a spindle control	Mills and machining centers	Mills and machining centers	Mills and machining centers	Mills and machining centers	Lathes
Number of coordinated CNC axes	4	3	4	5	7	2
Spindle axis		✓	✓	✓	✓	✓
Number of PLC axes or synchronous control axes	0	0	3	2	8	0
Total axes	4	4	8	8	16	3
C axis control		✓	✓	✓	✓	✓
Spindle gear change						✓
Canned cycles and advanced machining functions	None, but can be customized	Complete drilling and boring canned cycles, including rigid tapping	Complete drilling and boring canned cycles, including rigid tapping	Complete drilling and boring canned cycles, including rigid tapping	Complete drilling and boring canned cycles, including rigid tapping	Drilling, profiling, grooving, chamfering, indexing, boring, multi-pass threading, live tool features
Optional dual-axis synchronization control	✓		✓	✓	✓	
Optional macro functions	✓	✓	✓	✓	✓	✓
Optional 3-D DLACC (look-ahead)	✓	✓	✓	✓	✓	
Includes Ladder-Works PLC	✓	✓	✓	✓	✓	✓
Includes Ladder-Works Console	✓	✓	✓	✓	✓	

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Customized axis naming		✓	✓	✓	✓	
800 configurable alarm messages programmable through PLC	✓	✓	✓	✓	✓	✓
Linear scale feedback control	✓	✓	✓	✓	✓	✓
Tool compensation	✓	✓	✓	✓	✓	✓
Workpiece coordinates	✓	✓	✓	✓	✓	✓
Linear interpolation	✓	✓	✓	✓	✓	✓
Circular interpolation	✓	✓	✓	✓	✓	✓
Helical interpolation	✓	✓	✓	✓	✓	
Exponential interpolation	✓	✓	✓	✓	✓	
Cylindrical interpolation						✓
Polar coordinate interpolation						✓
Manual feedrate override	0–254%	0–254%	0–254%	0–254%	0–254%	0–230%
Per minute & per revolution feed		✓	✓	✓	✓	✓
Constant surface speed control						✓
Servo platforms available	VersioBus II, RTEK, EtherCAT, SSCNET, MECHATROLINK II & III	VersioBus II, RTEK, EtherCAT, SSCNET, MECHATROLINK II & III	VersioBus II, RTEK, EtherCAT, SSCNET, MECHATROLINK II & III	VersioBus II, RTEK, EtherCAT, SSCNET, MECHATROLINK II & III	VersioBus II, RTEK, EtherCAT, SSCNET, MECHATROLINK II & III	VersioBus II, RTEK, EtherCAT, SSCNET, MECHATROLINK II & III
Individual axis machine lock	✓	✓	✓	✓	✓	✓
Individual axis & individual direction interlock	✓					✓
Includes ServoWorks MotionLite	✓	✓	✓	✓	✓	
Customizable for special CNC requirements	✓	✓	✓	✓	✓	✓

Consult the [ServoWorks CNC Product Parts List](#) or your Soft Servo Systems sales representative regarding standard and optional features for these products.



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