

NOTES:

- If F0 is programmed, it is regarded as a data error. (alarm code "030")
- Do not program F commands with minus numerals, otherwise correct operation is not guaranteed.

EXAMPLE

F-250 ; ..... wrong

### 2.4.3 FEEDRATE 1/10

The feedrate programmed by F commands can be converted to 1/10-th value with a parameter setting as follows.

- When parameter #6020 D0 or D1 is set to "1," the feedrates range becomes as shown below.

Table 2.15

		Format	Feedrate (Feed/min) range
Metric output	Metric input	F41	F1.0 - F8100.0 mm/min
	Inch input	F32	F0.01 - F313.00 in. /min
Inch output	Metric input	F51	F1.0 - F20574.0 mm/min
	Inch input	F32	F0.01 - F810.00 in. /min

- When parameter #6020 D0 or D1 is set to "0," the feedrate range returns to normal.

### 2.4.4 F 1-DIGIT PROGRAMMING<sup>†</sup>

- (1) Specification of a value 1 to 9 that follows F selects the corresponding preset feedrate.
- (2) Set the feedrate of each of F1 to F9 to the setting number shown in Table 2.16(a).
- (3) By operating the manual pulse generator when F1-DIGIT switch is on, the feedrate of F1-digit command currently specified may be increased or decreased. Set the increment or decrement value per pulse (F1-digit multiply) to the parameters listed in Table 2.16(b).

As a result of this operation, the contents of the setting number of the F1-digit feedrate are changed.

#### (4) Upper Limit of Feedrate

Set the maximum feedrate of F1-digit designation to the following parameter. If a value greater than the usual maximum cutting rate (the contents of #6228) is set, it is governed by the contents of #6228.

Table 2.16(a)

F command	Setting No. for F1-digit speed
F1	#6561
F2	#6562
F3	#6563
F4	#6564
F5	#6565
F6	#6566
F7	#6567
F8	#6568
F9	#6569

Setting "1" = 0.1 mm/min

Table 2.16(b)

F command	Parameter No. for F1-digit multiply
F1	#6141
F2	#6142
F3	#6143
F4	#6144
F5	#6145
F6	#6146
F7	#6147
F8	#6148
F9	#6149

Setting "1" = 0.1 mm/min/pulse

Table 2.16(c)

Parameter No.	Meaning
#6226	Max speed of F1 to F4
#6227	Max speed of F5 to F9

NOTES:

- When this feature is installed, the specifying 1 to 9 mm/min by the usual F function is not allowed. Specifying 10 mm/min or more is allowed usually.
- If F0 is specified, error "030" will be caused.
- When DRY RUN switch is on, the rate of dry run is assumed.
- For F1-digit specification, the feedrate override feature is invalid.
- The feedrate stored in memory is retained after the power is turned off.