PARAMETER NUMBERS AND THEIR CONTENTS (CONT'D)

#6225	

Specifies the feedrate for the rapid traverse section in circle cutting (G12, G13).

Setting: "1" = 1 mm/min.

#6226	

#6227	

#6226, #6227

Specify the maximum feedrate for F1-digit designation.

Setting: "1" = 1 mm/min.

NOTE: The maximum feedrate for F1-F4 commands is set in #6226 and that for F5-F9 commands in #6227. Any feedrates increased on manual pulse generators are bunched into these settings.

#6228	

Specifies the maximum cutting feedrate for the linear axes (X, Y, Z, U, V, W).

Setting: "1" = 1 mm/min.

#6229	

Specifies the maximum cutting feedrate for the rotary axes (A, B, C).

Setting: "1" = 1 mm/min.

NOTE: Any cutting feedrates greater than those set in #6228 and #6229 are bunched into those settings.

#6230	

When a circular path is drawn in tool radius compensation outside a corner approaching 180°, the movement follows on a very small circular arc. In this arc movement is considered to affect the workpiece surface machining, this parameter is used to set the critical arc value.

Setting: "1" = 0.001 mm (metric system)
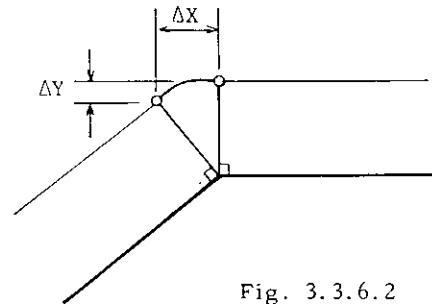"1" = 0.0001 in. (inch system)

Fig. 3.3.6.2

The corner arc setting is ignored when:

$\Delta X \leqq$ #6230

$\Delta Y \leqq$ #6230

Standard setting = 5

#6231	

Specifies the F_0 speed for rapid traverse override.

Setting: "1" = 7.5 mm/min.

#6232	

Specifies the feedrate in the skip function (G31).

Setting: "1" = 1 mm/min.

NOTE: This setting is effective when parameter #6019D4 = 1.

#6233	

#6264	

#6233 to #6264

Specify the feedrate for the respective positions on the jog feedrate select switch.

Setting: "1" = 1 mm/min.