

Typical settings

Table 3.3.6 Typical Settings mm/min

Switch position	Parameter		Continuous manual feedrate	
	Number	Setting	#6250 = 0	#6265 = 10
0	#6233	0	0	0
1	#6234	1	1	0.1
2	#6235	2	2	0.2
3	#6236	4	4	0.4
4	#6237	6	6	0.6
5	#6238	8	8	0.8
6	#6239	10	10	1.0
7	#6240	12	12	1.2
8	#6241	15	15	1.5
9	#6242	20	20	2.0
10	#6243	25	25	25
11	#6244	30	30	30
12	#6245	40	40	40
13	#6246	50	50	50
14	#6247	60	60	60
15	#6248	80	80	80
16	#6249	100	100	100
17	#6250	120	120	120
18	#6251	150	150	150
19	#6252	200	200	200
20	#6253	250	250	250
21	#6254	300	300	300
22	#6255	400	400	400
23	#6256	500	500	500
24	#6257	600	600	600
25	#6258	800	800	800
26	#6259	1000	1000	1000
27	#6260	1200	1200	1200
28	#6261	1500	1500	1500
29	#6262	2000	2000	2000
30	#6263	2500	2500	2500
31	#6264	3000	3000	3000

#6265

The manual feedrates set in parameters #6233 to #6264 can each be reduced to a tenth of the original setting. This applies to the settings on all switch positions lower than the value specified in this parameter #6265.

Setting: 0 - 31 (switch position)

#6266

#6267

#6268

#6269

#6266 to #6269:

Specify the spindle speed upper limit, respectively, for gears 1, 2, 3 and 4 (specifiable only in S5-digit designation).

Setting: 0 - 9999 (rpm)

#6270

Specifies the speed command output value to the spindle motor when a gear shift (GR0) input is entered (specifiable only in S5-digit designation). The setting formula is:

$$\frac{\text{Gear shift spindle motor speed}}{\text{Maximum speed of spindle motor}} \times 32767$$

(command = 10 V)

Setting range: 0 - 32767