shopbot shortlist

shortcuts

sk = manual mode

c2 = zero plate function

jh = jog home

nudge (-)

equation one

//using givens from Onstrud bit datasheets and Partwizard Feed Rate

Speed (RPM) = (Feed Rate) / (# Cutting Edges \* Chip Load)

equation two

//solving for the Frequency to enter into the display

Speed (RPM) = (Frequency) \* (Operating Hertz)

Speed (RPM) = (# in display) \* (60Hz)

example

|  |  |  |
| --- | --- | --- |
| **Variable** | **Source** |  |
| Feed Rate | PartWizard | 160 in/min |
| Cutting Edges | Bit / Onstrud | 2 |
| Chip Load | Onstrud | .007 |
| Operating Hertz | Constant | 60 |

equation one

Speed (RPM) = (Feed Rate) / (# Cutting Edges \* Chip Load)

= 160 / (2 \* .007)

= 12 000

equation two

Speed (RPM) = (# in display) \* (60Hz)

12 000 = x (60)

200 = x