

Change RPM & Feed Rate Instructions Manual

Change RPM & Feed Rate:

Method 1: Change RPM and Feed Rate by turning to knob to desired RPM and Feed Rate percentage.



Method 2: Alter RPM by manually adding desired speed into G92 **S**. In example, RPM is set to 700. Alter Feed rate by changing the value in G95 **F**. In example, Feed rate is set to 0.002.

```
G54      EXAMPLE N0 L1      Program      2016/8/3      13:19:48      DEFAULT
Edit Program Name : *072516 Line : 13 Column : 0
//===Cycle Start===
G70;
N1 G5.1Q1E0.00200;
N2 G05P10000;
N3 G90 G54 G00 X21.05311 Z-5.76082;
N5 G54 G94 G00 X21.01111;
N6 G01 Z-6.17882;
N7 G97 M4 S1200;
N8 G92 S700;
N9 G04 P3000;
N10 G95 F0.002;
N11 G18 G41 D1;
N101 X21.01114 Z-6.37908;
N102 X20.99114 Z-6.36696;
```

•Ready Auto Alarm

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