

## CONSTANT SURFACE SPEED (CNC 8025T-Series)

PARAMETER #1500-1 : constant surface speed is possible while in jog mode.

CSS: spindle speed in foot/min.

CST: spindle speed in revolution/min

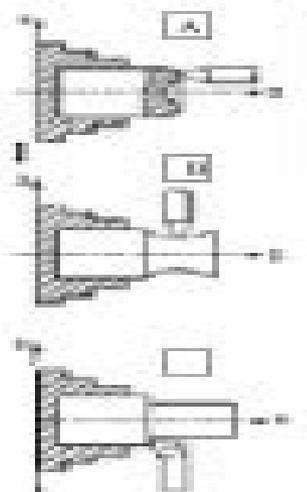
CSS S... : setting of max. spindle S value when in CSS

It is recommended that CSS and S... spindle speed be programmed in the same block. If CSS is programmed alone, the CNC assumes the last Constant Surface Speed used in that mode. If none was previously used, the CNC will issue error 18.

Under CSS, the feedrate values will be applied to the CNC in inch/revolution.

The speed of the spindle depends upon the diameter being cut.

When working with CSS, correct tool calibration is very important. If the tools are not calibrated correctly, the CSS will work in reverse. This symptom is always due to incorrect tool measurement.



### MEASUREMENT AND LOADING OF TOOL DIMENSIONS

- 1) make sure the machine is homed before you begin
- 2) press [tool measurement] in jog mode
- 3) key in tool #, 11.1 cycle is start
- 4) press the letter X (just the jog key), enter the dimensions of the part: diameter or radius depending on how the machine is working.
- 5) press ENTER.
- 6) press the letter Z (just the jog key), key in the part dimension and press ENTER. The Z is usually kept in with 0.
- 7) also make sure you are using the correct tool code, (T0 - P0).
- 8) move the X axis until the part is touched, press the letter X and [COMMAND] will appear, press [COMMAND] and the dia dimension of the part should appear on the jog screen.
- 9) do the same procedure for Z and R should appear on the jog screen.
- 10) follow the same procedure for another tool.

EXAMPLE: part dimensions is 2 inches diameter, working units are in diameter. If the area setup is as follows, the X dimension for tool B is a positive value, X2 ENTER. The X dimension for tool C is entered with a negative value, X-2 ENTER.

To use CSS, go to the jog mode. Press F2 [CSS], S should appear. Key in the proper S value and then key in M0 or M4 (make sure you're in the proper gear range: M41,M42,M43,M44). [CSS] should appear as long as the parameter is not correctly. The S value will display in Feet/min with 8025 T. Call any tool and jog the X axis to position zero. As you approach zero, the spindle speed will increase. As the tool returns from X0, the spindle speed reduces.

# Fagor Controller 8025 Operation Manual

**Wolfgang Guggemos**



## **Fagor Controller 8025 Operation Manual:**

## Reviewing **Fagor Controller 8025 Operation Manual**: Unlocking the Spellbinding Force of Linguistics

In a fast-paced world fueled by information and interconnectivity, the spellbinding force of linguistics has acquired newfound prominence. Its capacity to evoke emotions, stimulate contemplation, and stimulate metamorphosis is actually astonishing. Within the pages of "**Fagor Controller 8025 Operation Manual**," an enthralling opus penned by a very acclaimed wordsmith, readers attempt an immersive expedition to unravel the intricate significance of language and its indelible imprint on our lives. Throughout this assessment, we shall delve in to the book is central motifs, appraise its distinctive narrative style, and gauge its overarching influence on the minds of its readers.

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integriertem kabel fri 3015 günstig klassischer relief leuchtglobus zu 94 90 eur flottweg verarbeitungs technologie