

FANUC rigid tapping parameters

(Main parameters related to batch size and tapping)

Setting Item	0# Mate-MID		Setting Notes
Fast shift time constant 1	1620	X axis 120 Y axis 140 Z axis 150	Confirm the optimum setting value according to the waveform of TCMD at 100% rapid multiplication, this parameter has a great influence on the efficiency of batch punching and tapping, and each axis is optimized separately.
Fast shift time constant 2	1621	X axis 50 Y axis 50 Z axis 64	Confirm the optimum setting value according to the waveform of TCMD at 100% rapid multiplication, this parameter has a great influence on the efficiency of batch punching and tapping, and each axis is optimized separately.
Cutting time constant	1622	X axis 64 Y axis 64 Z axis 64	When machining in the normal way, if there is a demand for further precision and efficiency, the setting value can be set to a smaller value provided that the axis operates stably. When machining in normal mode, if there are further requirements for machining accuracy and efficiency, a smaller value can be set provided that the axis operation is stable, and the settings for all three axes must be consistent.
Rapid traverse/linear positioning	140141	1	Fixed setpoint
Total feedforward function in effect (including rapid)	180040	1	Fixed setpoint
Cutting/rapid feedforward switching	221444	1	Fixed setpoint
Rapid position feedforward coefficient	2092	9990 (The three axes are aligned)	Fixed setpoint
Rapid speed feedforward coefficient	2099	50 (The three axes are aligned)	Fixed setpoint

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JL Elias



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