FANUC rigid tapping parameters

(Main parameters related to batch size and tapping)

Setting Items	66 Mate-MD		Setting Notes
Fost shift time constant 1	1620	X axis 120 Y axis 145 Z axis 155	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 topping, and each axis is optimized separately.
First shift time constant 2	1621	X sets 56 Y axis 56 Z axis 64	Confirm the optimum setting value eccording to the servetorm of TCMD at 100% rapid multiplication, this parameter has a great influence on the officiency of batch punching and tapping, and each axis is optimised separately.
Cutting time constant	1622	X nois 64 Y nois 64 Z axis 64	When machining in the normal way, if from its a demand for further precision and efficiency, the setting value can be set to a smaller value provided that the axes operate 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	140191	11	Fixed setsoint
Total feedforward function in effect (Including regist)	190093	1	Fixed selpoint
Cutting/topid feedforward switching	221484	-	Fixed setpoint
Rapid position feedforward coefficient	2092	9000 (The free axes are aligned)	Fixed setpoint.
Rapid speed feedbreard (Coefficient	2000	50 (The three axes are aligned)	Fixed solpoint

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