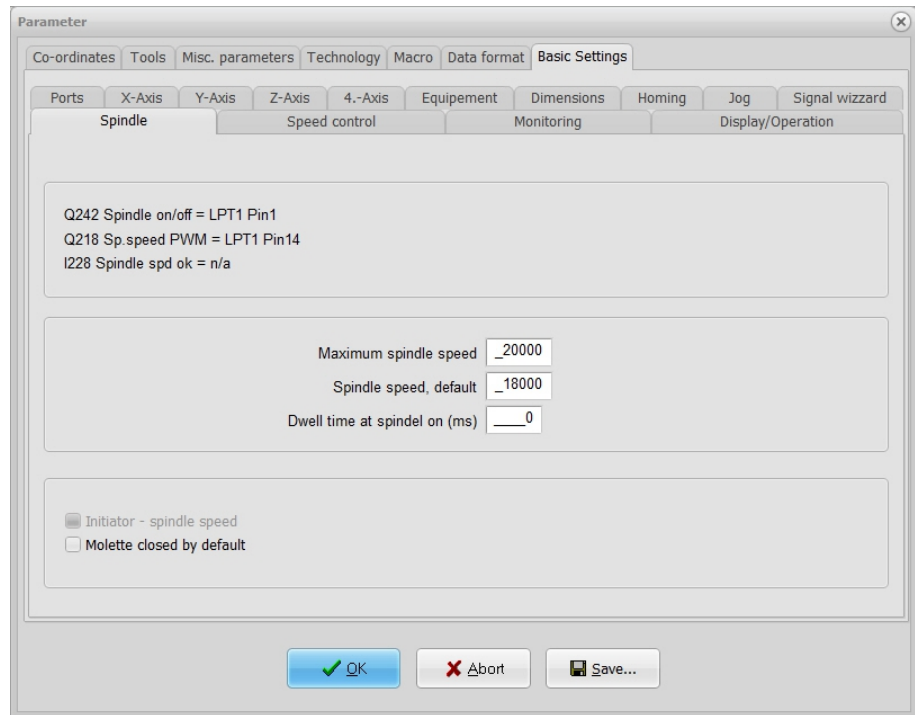


Basic settings-Spindle



Parameter-Basic settings Spindle

The upper section of the window indicates the currently assigned input and output signals. Thus it is easy to note whether the definitions have been made correctly.

WinPC-NC is able to drive the rotation speed of a drilling or milling spindle. It is possible to define a speed for each tool or the speed data is taken from the NC files.

Maximum spindle speed

*Speed control
in 256 steps*

WinPC-NC can control the speed of a drilling or milling spindle. It is possible to define a speed for each tool, or the speed data is taken from the NC files.

The maximum value defines the reference for step 255. All lower values are calculated proportionately between 0 and this value, and are output.

The spindle speed is either generated binary coded from **WinPC-NC USB** on the data bytes (pin 2-9) of the second LPT port or as PWM value on pin 14 or pin 17 of LPT1 on **ncUSB**.

Spindle speed standard

The standard spindle speed is used whenever no divergent setting as been made in the NC program or in the tool parameters. In most cases this applies to JOG move or when starting a job process.

Spindle acceleration time

Acceleration time for drilling spindle

The start delay defines a waiting time in milliseconds which always counts down when the additional Drilling spindle output signal is activated.

This ensures that the drilling spindle has enough time to accelerate before it is used for the first time-

With additional settings it can be determined whether a signal should be sent from the spindle speed control when the desired rotation speed has been reached. Many frequency converters and speed controllers provide a corresponding signal. This kind of monitoring is advisable subject to cabling and relevant pin layout.

Collet chuck closed at machine start

Using a changer or an automatic collet chuck this switch is responsible for determining the status of the chuck during switch on of the plant. Activating the chuck closes **WinPC-NC** remembers the last used tool from session to session.

Sensor – Spindle speed

Synchronisation when reaching rotational speed

With additional settings it can be determined whether a signal should be sent from the spindle speed control when the desired rotation speed has been reached. Many frequency converters and speed controllers provide a corresponding signal. This kind of monitoring is advisable subject to cabling and relevant pin layout.
