

Tools-Speeds

	V-Plunge	V-Advance	V-Withdrawal	Brake angle
1	5.00	5.00	12.00	30
2	3.00	2.00	15.00	30
3	2.00	3.00	5.00	30
4	4.00	4.00	10.00	30
5	6.00	5.00	10.00	30
6	5.00	15.00	25.00	30
7	5.00	5.00	10.00	30
8	5.00	5.00	10.00	30
9	5.00	5.00	10.00	30
10	5.00	5.00	10.00	30

Parameter-Tools-Speeds

Plunge speed

The plunge speed specifies the speed with which each tool is pushed into the workpiece. It is necessary to consider certain limit values here, depending on the material and the tool.

Advance speed

The advance speed or feed rate defines the working speed for each tool when the tool is pushed into the workpiece. This value is irrelevant for straightforward drilling applications.

However, if **WinPC-NC** is used for milling, engraving or grinding, then the maximum feed rate depends on the tool used and the material.

Withdrawal speed

The withdrawal speed is used for raising or withdrawing the tool from the workpiece.

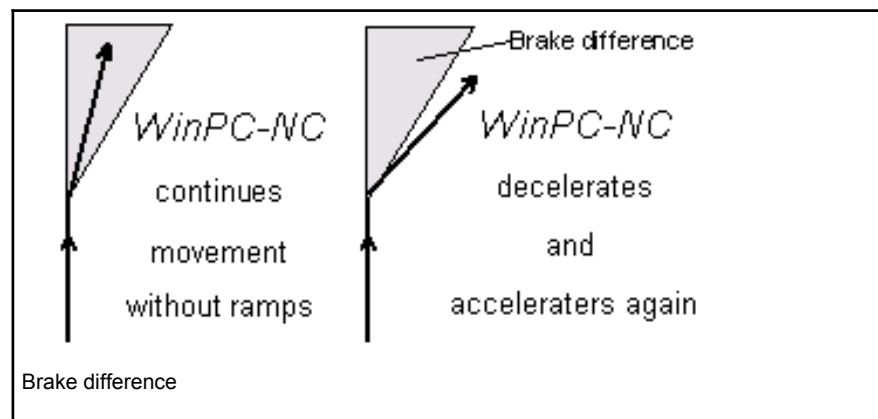
Brake angle

The brake angle specifies the maximum angle differential for subsequent movement stages in which movement takes place at full-speed. The value is entered in degrees.

Deterministic speed optimization

Between the start and finish of movements, the acceleration and braking function is only activated if the direction of the next vector deviates from the previous one by more than the defined brake angle.

An example of this deterministic speed optimization function can be seen in movement around a circle, which consists of lots of little individual vectors. The directions of two successive movements are only slightly different. As a result, the circular path can be moved in one operation at maximum speed.



Braking and acceleration always take place before and after tool movements. This parameter is irrelevant in straightforward drilling applications and is ignored.
