

## Service Support Spirit

### How to set the speed of the system

→ Problem : There are two speeds in the system, automatic cutting speed and manual moving speed;

- Solution overview:
1. Automatic cutting speed;
  2. Manual moving speed;
  3. System speed parameter;

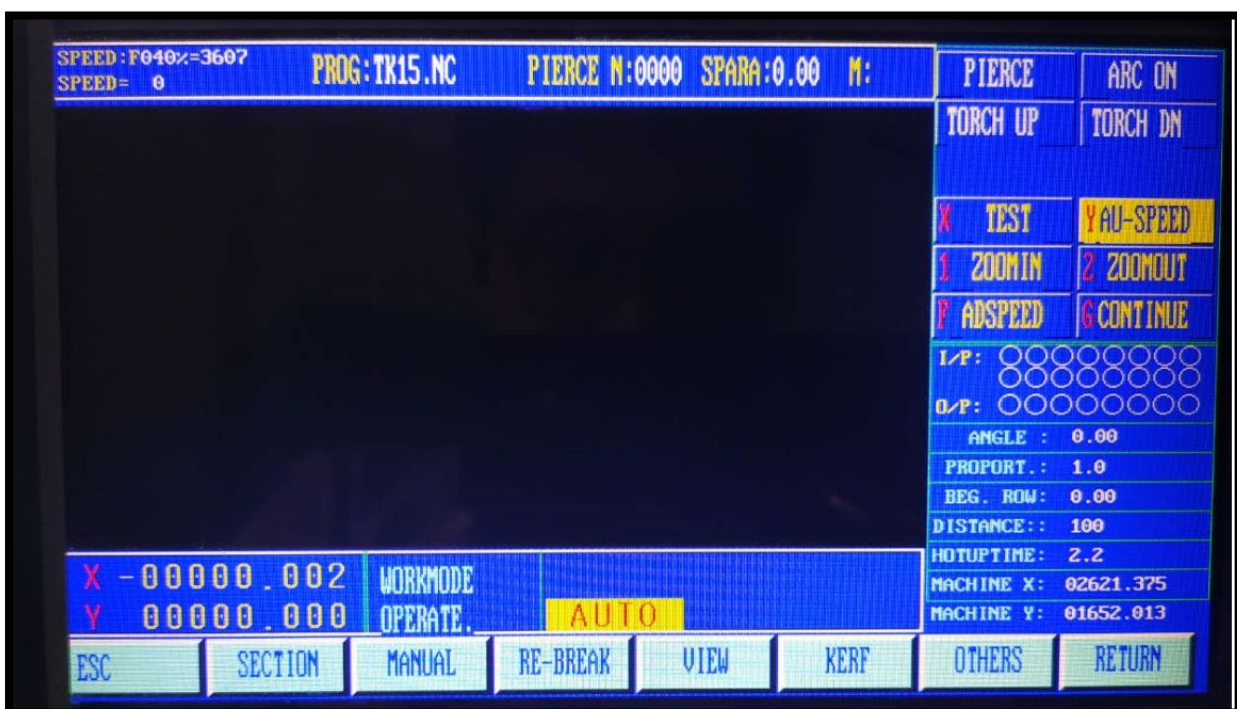
Problem analysis:

- \* 1. Automatic cutting speed;

**Solution:** Step 1- Press the **【F】** key on the system keyboard → Enter the value, This value is the automatic cutting speed;

In automatic operation, press **【F ↑】** **【F ↓】** to adjust the ratio to adjust the automatic speed.

In automatic mode: left upper corner of the screen shows  $F^*$  (automatic processing speed ratio value) = Set value processing speed.



## Service Support Spirit

✧ 2. Manual moving speed;

**Solution:** Step 1- The same method can adjust the manual speed;

In manual mode: left upper corner of the screen shows  $F * (\text{manual speed ratio value}) = \text{manual speed}$ .

Note: the speed of the display value may be metric also can be inch, depends on the parameter settings in metric/inch option (see parameters - control).

✧ 1. System speed parameter;

**Solution:** In the system main menu, Press [F4] to enter parameter setting window → Press 【F1 SPEED】 into speed interface:



**HIGH SPEED**—The top speed of running system in manual control mode and in execution of G00 command, in mm/min. or inch/min.

**MACHINING SPEEDS**—The top machining speed in flame/plasma machining operation, in mm/min. or inch/min.