13-01 Feedrate Q+A

Understanding the concepts of feedrate programming is equally important as understanding the spindle programming. The objective of these questions is to review some basic programming issues associated with the feedrate control on CNC machines.

#	Question	Answer
1	Specify the feedrate units used in metric and English programming for both machining centers and lathes	Metric - machining centers _____ Metric - lathes _____ English - machining centers _____ English - lathes _____
2	Name at least six factors that influence the feedrate selection in the CNC program	1. 2. 3. 4. 5. 6.
3	What is feedrate override switch used for and what are its typical ranges?	

4	Define what cutting feedrate is	
5	What is the ***result*** of this program block: `G00 X150.0 F0.3`	
6	What is G09 command used for?	
7	Name two program functions that are used to allow or disallow feedrate override	
8	Describe the function of the ***Feedhold Switch***	
9	If maximum cutting feedrate for a CNC machine is 400 in/min, and the spindle speed in 2800 r/min - what is the maximum allowed feedrate per revolution? ***Include formula used for this calculation***	
10	In milling, what two G-codes determine the cutting feedrate per minute and per revolution?	