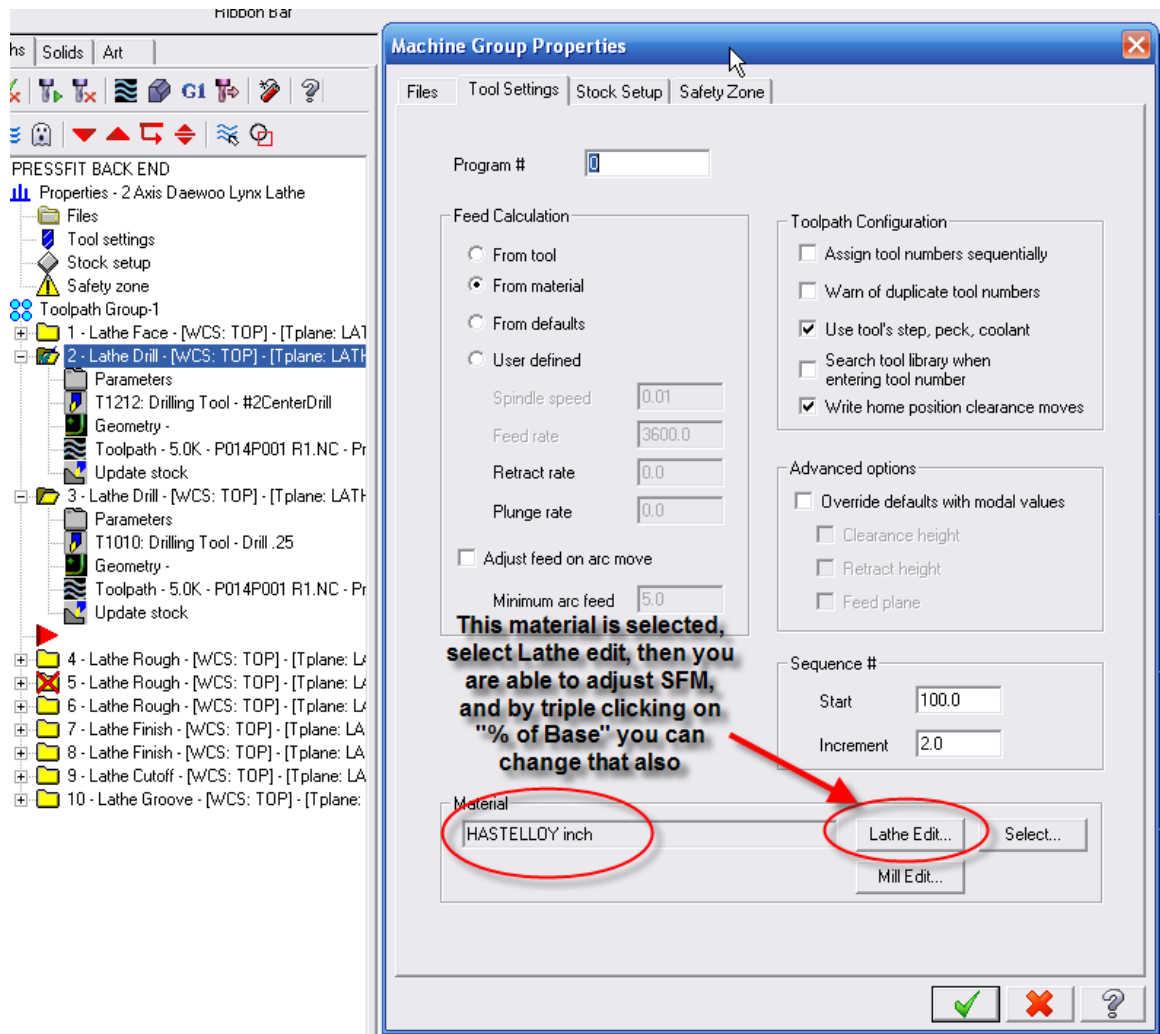


Question/Issue

Material update

Answer/Solution

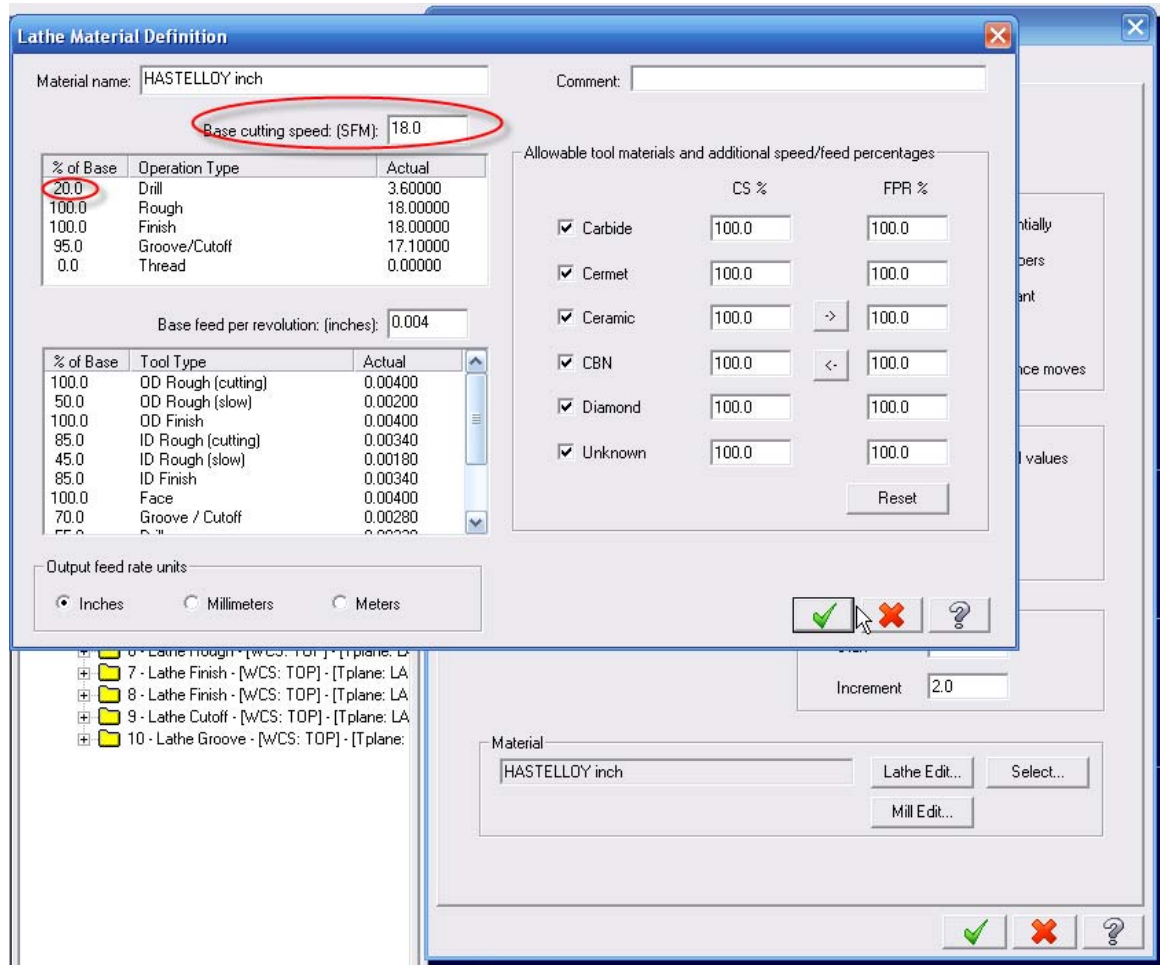
Notice boxes and notes below.



You can edit the "Base Cutting Speed"

Plus by triple clicking on the value under "% of Base" you may edit that also.

Before



After

Machine Group Properties

Lathe Material Definition

Material name: Comment:

Base cutting speed: (SFM):

% of Base	Operation Type	Actual
100.0	Drill	90.00000
100.0	Rough	90.00000
100.0	Finish	90.00000
95.0	Groove/Cutoff	85.50000
0.0	Thread	0.00000

Base feed per revolution: (inches):

% of Base	Tool Type	Actual
100.0	OD Rough (cutting)	0.00400
50.0	OD Rough (slow)	0.00200
100.0	OD Finish	0.00400
85.0	ID Rough (cutting)	0.00340
45.0	ID Rough (slow)	0.00180
85.0	ID Finish	0.00340
100.0	Face	0.00400
70.0	Groove / Cutoff	0.00280

Allowable tool materials and additional speed/feed percentages

	CS %	FPR %
<input checked="" type="checkbox"/> Carbide	<input type="text" value="100.0"/>	<input type="text" value="100.0"/>
<input checked="" type="checkbox"/> Cermet	<input type="text" value="100.0"/>	<input type="text" value="100.0"/>
<input checked="" type="checkbox"/> Ceramic	<input type="text" value="100.0"/> <input type="button" value=">"/>	<input type="text" value="100.0"/>
<input checked="" type="checkbox"/> CBN	<input type="text" value="100.0"/> <input type="button" value="<"/>	<input type="text" value="100.0"/>
<input checked="" type="checkbox"/> Diamond	<input type="text" value="100.0"/>	<input type="text" value="100.0"/>
<input checked="" type="checkbox"/> Unknown	<input type="text" value="100.0"/>	<input type="text" value="100.0"/>

Output feed rate units:
 Inches Millimeters Meters

6 - Lathe Rough - [WCS: TOP] - [Tplane: LA]
7 - Lathe Finish - [WCS: TOP] - [Tplane: LA]
8 - Lathe Finish - [WCS: TOP] - [Tplane: LA]
9 - Lathe Cutoff - [WCS: TOP] - [Tplane: LA]

Material