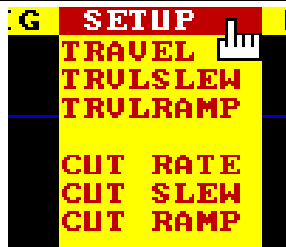


X,Y, Motion/Start, Ramp and Slew Speeds

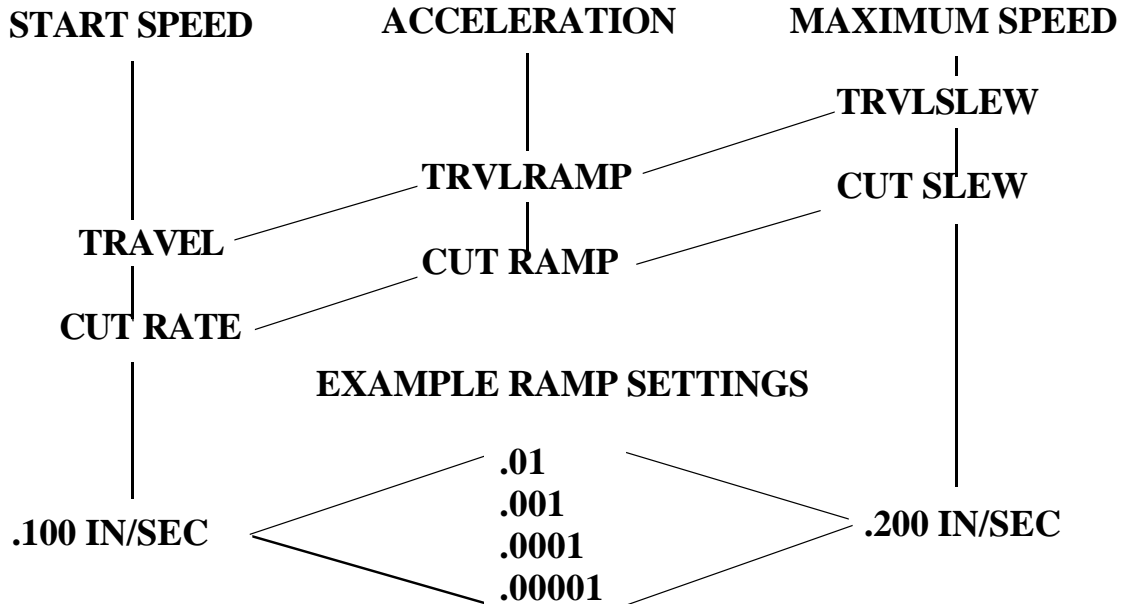
The purpose of varying the speed of the cutting head when either traveling or cutting, is to deal with the weight of the X and Y mechanics. Just as you can't move from zero to sixty miles an hour in an automobile suddenly, heavy XYZ systems need to start and stop with consideration for inertia. Thus, the concept of ramping is that of acceleration and deceleration at the beginning and end of machine moves. To accomplish this, a movement in time is expressed as a "start speed", a "ramp rate" and a "slew speed". Large machines create a greater concern for ramping than small ones. Even so, ramping can save wear and tear on

The setup menu shows a group of commands that work together in determining the speeds the machine will move in the X and Y axes.



Controls X,Y, travel.

Controls X,Y, cutting.



We recommend the start speed be one half that of the slew speed.

(continued next page)