

Speed rpm during gear change

Model KL1640 set speed from 30 to 75 rpm during gear change. This model has only low gear (cnc10t.m41) and high gear (cnc10t.43) 2 speed gear range.

Model KL-21 set speed 30 rpm during gear change (low gear - med gear and high gear).

Model KL-30 set speed 20 rpm during gear change. low gear (cnc10t.m41), med gear (cnc10t.m42) and high gear (cnc10t.m43).

How to change speed rpm during gear change

F7 -Utility > F5 File Opt > Use arrow key high light [C : drive], press enter >> High light [Cnc10t] press enter >> use arrow key high light [cnc10t.m41] and press F4 [Edit]. You will see edit the file cnc10t.m41, use arrow key to move down at [b] = 30rpm, and you can change [b] how many rpm depending on what type of machine (look above). After that, hold key [ALT] and press key [F] , and then press [S] Save ,and press[X] exit .

Do the same at file cnc10t.m42 and cnc10t.m43.