

## Change Constant RPM and Surface Speed

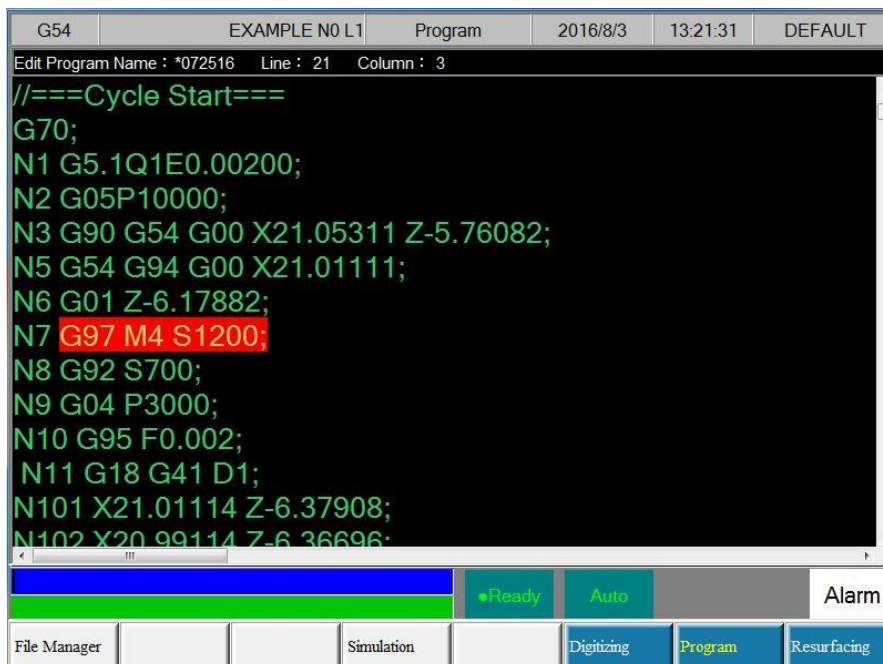
G96 and G97 are the two codes needed in order to switch between Constant Surface Speed and Constant RPM respectively. In the first example, we have the program set to constant surface speed (G96). In the second example, we edited the file so that it was changed to constant rpm (G97). After editing the program, press File Manager or Resurfacing to save the file.



The screenshot shows a CNC control interface with a black background and green text. The top status bar displays 'G54', 'EXAMPLE N0 L1', 'Program', '2016/8/3', '13:22:25', and 'DEFAULT'. Below the status bar, the text 'Edit Program Name : \*072516 Line : 21 Column : 3' is visible. The main display area contains the following code:

```
//===Cycle Start===  
G70;  
N1 G5.1Q1E0.00200;  
N2 G05P10000;  
N3 G90 G54 G00 X21.05311 Z-5.76082;  
N5 G54 G94 G00 X21.01111;  
N6 G01 Z-6.17882;  
N7 G96 M4 S1200;  
N8 G92 S700;  
N9 G04 P3000;  
N10 G95 F0.002;  
N11 G18 G41 D1;  
N101 X21.01114 Z-6.37908;  
N102 X20.99114 Z-6.36696;
```

The line 'N7 G96 M4 S1200;' is highlighted in red. Below the code area, there is a control bar with buttons for 'Ready', 'Auto', and 'Alarm'. At the bottom, there is a row of buttons: 'File Manager', 'Simulation', 'Digitizing', 'Program', and 'Resurfacing'.



The screenshot shows a CNC control interface with a black background and green text. The top status bar displays 'G54', 'EXAMPLE N0 L1', 'Program', '2016/8/3', '13:21:31', and 'DEFAULT'. Below the status bar, the text 'Edit Program Name : \*072516 Line : 21 Column : 3' is visible. The main display area contains the following code:

```
//===Cycle Start===  
G70;  
N1 G5.1Q1E0.00200;  
N2 G05P10000;  
N3 G90 G54 G00 X21.05311 Z-5.76082;  
N5 G54 G94 G00 X21.01111;  
N6 G01 Z-6.17882;  
N7 G97 M4 S1200;  
N8 G92 S700;  
N9 G04 P3000;  
N10 G95 F0.002;  
N11 G18 G41 D1;  
N101 X21.01114 Z-6.37908;  
N102 X20.99114 Z-6.36696;
```

The line 'N7 G97 M4 S1200;' is highlighted in red. Below the code area, there is a control bar with buttons for 'Ready', 'Auto', and 'Alarm'. At the bottom, there is a row of buttons: 'File Manager', 'Simulation', 'Digitizing', 'Program', and 'Resurfacing'.