

%
O02020 (Spindle Warm up)
(This program should be run prior to)
(machine use if machine has been idle)
(for more than 4 days.)
(Cycle time: 20-minutes.)
(This program can be used for all)
(spindle types and may be used daily)
(for spindle warm up prior to high)
(speed spindle use. Adjust spindle)
(speed override depending on maximum)
(spindle speed of machine: Set)
(override at 50% for 5,000 rpm)
(machines, set at 100% for 7,500)
(& 10,000 rpm machines, and set at)
(150% for 15,000 rpm machines.)
(9-21-99)
S500 M03
G04 P200.
S1000 M03
G04 P200.
S2500 M03
G04 P200.
S5000 M03
G04 P200.
S7500 M03
G04 P200.
S10000 M03
G04 P200.
M30
%