



Sherline/MASSO Controller Spindle Speed Information

Maximum RPM

1. Our headstock pulley has a high-speed groove and a high-torque/low-speed groove.
2. With the V-belt in the high speed groove on the pulley (see Figure 1), the maximum RPM is 2800.

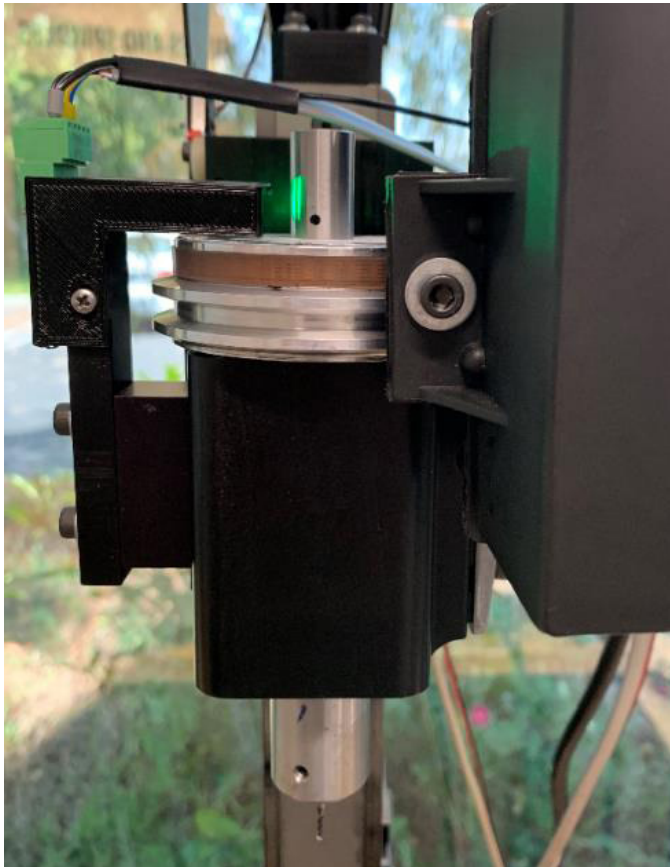


FIGURE 1—The V-belt is positioned in the high-speed, upper pulley groove.

3. With the V-belt in the high-torque/low-speed pulley groove (see Figure 2), the maximum RPM is 1380. No matter what your programmed spindle speed is or what spindle speed is entered via the MDI, the maximum RPM will not exceed 1380.

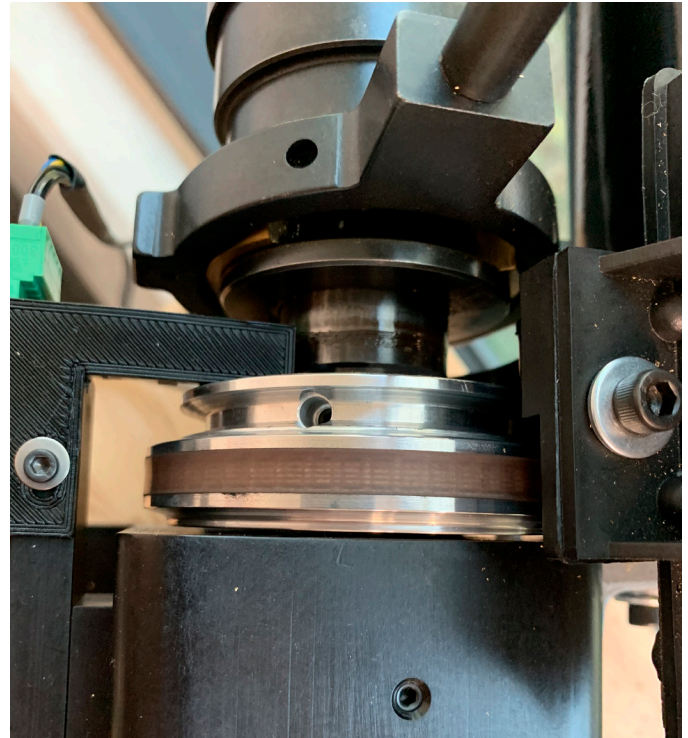


FIGURE 2—The V-belt is positioned in the high-torque, lower pulley groove.

4. If you are changing the RPM from the higher settings to a much lower setting, it will take a few seconds for the speed control to adjust to the new speed.
 - a. If this spindle speed change is done manually through the MDI page, just wait a second for the new spindle speed to change.
 - b. If the spindle speed change is done in a program, you may need to add a “G04 P” value directly after the “M03 S----” line to give the spindle time to change to the new RPM before the cutter begins to cut.

Program example:

M03 S500

G04 P3000 (this will cause a dwell time of 3 seconds).

Thank you,
Sherline Products Inc.