



GRAVOGRAPH NEW HERMES

IS Systems – How To Set Cutters

**If this is the 1st time engraving on your machine, or if you have new cutters or cutters sharpened see Zeroing Cutters, then proceed to Setting Engraving Depths Procedures.*

***If your cutters have been zeroed, proceed to Setting Engraving Depths Procedures.*

****Make sure you are working off of the proper "0" on the micrometer gauge. If your not sure, screw the micrometer gauge all the way up tight, turn back to 1st "0", and then turn back 3 "0's" from there. This will get at least .075 depth when needed for cutting out on the machine.*

1. **Zeroing Cutters**

A. Plastic Cutters (Fig 1)

1. Dial the micrometer gauge on the spindle to "0".
2. Screw in desired cutter (make sure cutter tip is not sticking out of the nose cone).
3. Using the arrows the on control pendent, direct spindle over flat table.
4. Press Z on the Control pendent.
5. Press the down arrow on Control pendent until nose cone touches the table (slight separation between snap ring and spindle assembly).
6. Then loosen the hex nut on the brass collar of the cutter and drop the cutter down until it hits table.
7. Tighten the hex nut on the brass the collar of cutter to hold this location (zero).
8. Repeat this process on all of the plastic cutters and place in cutter rack.(cutters should not have to be zeroed again unless you them send them in for resharpenering or order a new ones)
9. Press check on the Control pendent to raise the spindle back up.

Plastic Engraving

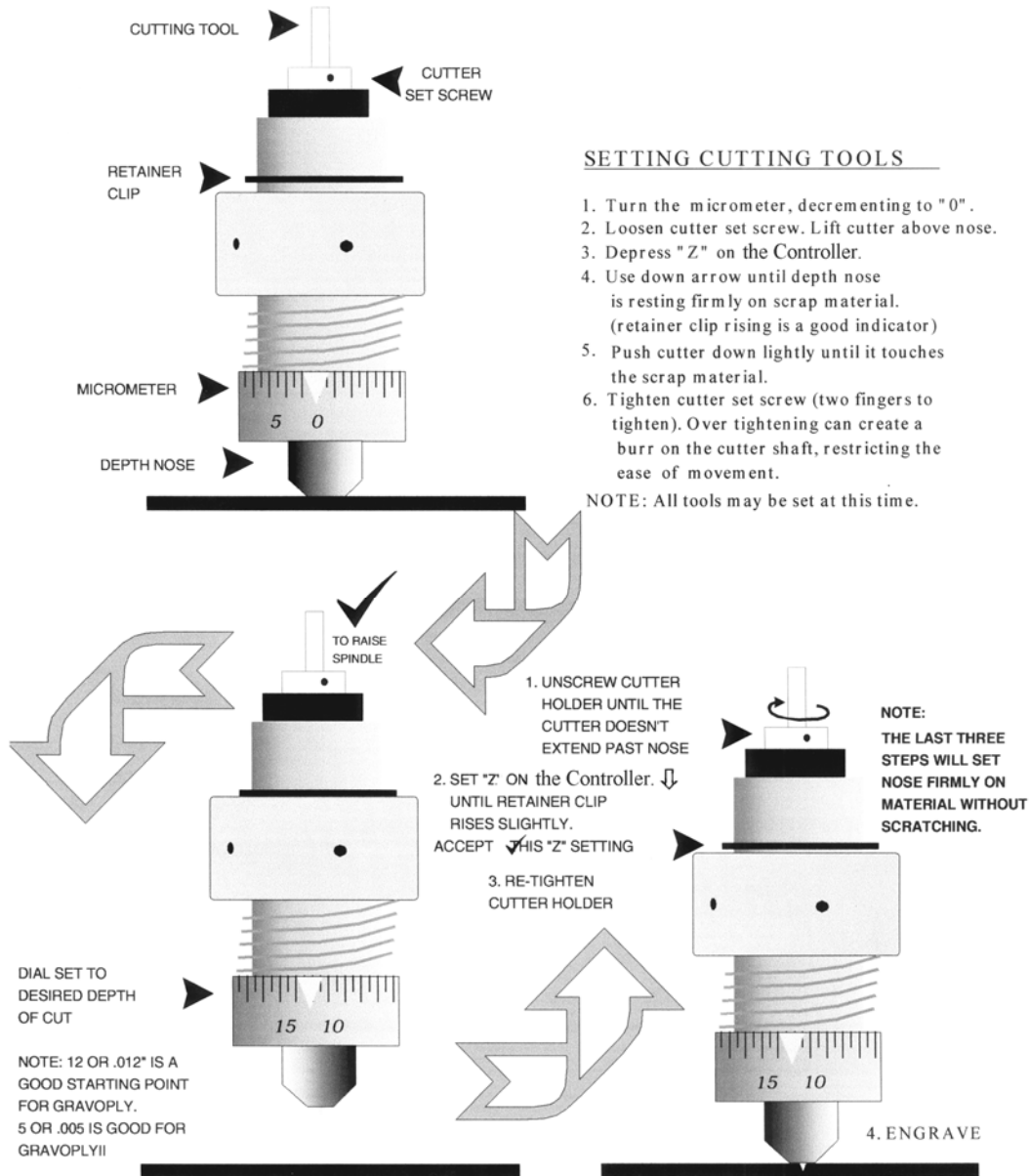


Figure 1

B. Diamond Tips

1. Screw in the diamond tip cutter.
2. When using diamond tips make sure the diamond cutter is sticking out of nose cone about 1/4 of an inch first (adjust with hex nut on brass collar).
3. Press Z on the Control pendant.

4. Press the down arrow on Control pendent & bring spindle down, touch material so that there is a slight separation between the snap ring and the spindle, then press check to raise spindle up.

C. Burnishing Tips

1. Lower spindle down to within 1/4" of material. Insert burnishing cutter, then loosen the hex nut on the brass collar and push the cutter down until it touches the material.
2. Tighten the hex nut on the brass collar.
3. Press the check on the Control pendent. When engraving add .002-.005 depth on the machining page in Gravostyle '98.

D. Aluminum, Metal, & Stainless Steel Cutters

1. Lower the spindle down to within 1/4" of the material. Insert the metal cutter, then loosen the hex nut on the brass collar and push the cutter down until it touches the material.
2. This is absolute "0". Tighten the hex nut on the brass collar.
3. Press the check on the Control pendent. When engraving add the appropriate depth on the machining page in Gravostyle '98.

2. Setting Engraving Depths

A. Plastic jobs

1. Set the depth of the cutter on micrometer.
2. Move the spindle over the material using the arrows on the Control pendent.
3. Loosen the cutter (so the cutter is not sticking out of the bottom of the nose cone),press the "Z" on the Control Pendent and lower the spindle down until the nose cone touches the material (notice slight separation in between the snap ring and the spindle), hit the "Check mark" on the Control pendent to raise the spindle up. Screw the cutter in tight.

Remember: Gravoply II, Metalex =.002 - .003 depth
Gravoply, 2Plex, Phenolic=.012 - .015 depth
Cutout 1/16th material .058+/- (1/16" is .062)
1/32" Profile Material .038+/-
Braille .022+/- Raster Drill .040+/-

B. Diamond Jobs

1. When using a diamond drag make sure the diamond is sticking out about 1/4 of an inch first.
2. Just bring the spindle down and touch the cutter tip to the material so that there is a slight separation on the snap ring, on the spindle then press check (see above-zeroing diamond tip).

C. Metal jobs-See above-zeroing cutters.

3. **Cutters**

Orange-Plastic

Green-Burnisher for brass

White-Beveler, Phenolic, or Braille, or Aluminum

Yellow-Metal

Nothing or Blue -Diamond

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