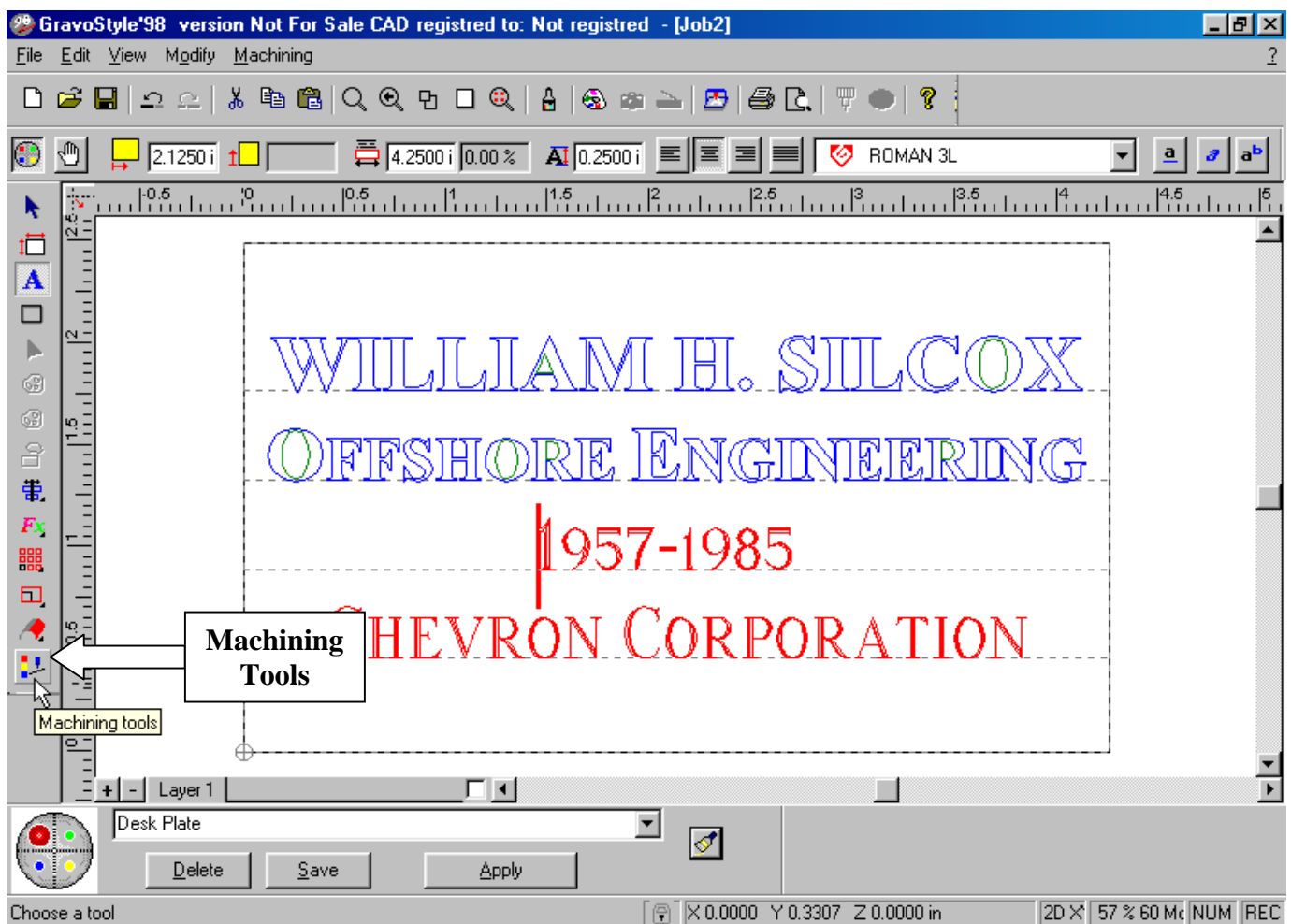




GRAVOGRAPH NEW HERMES

Machining Tools

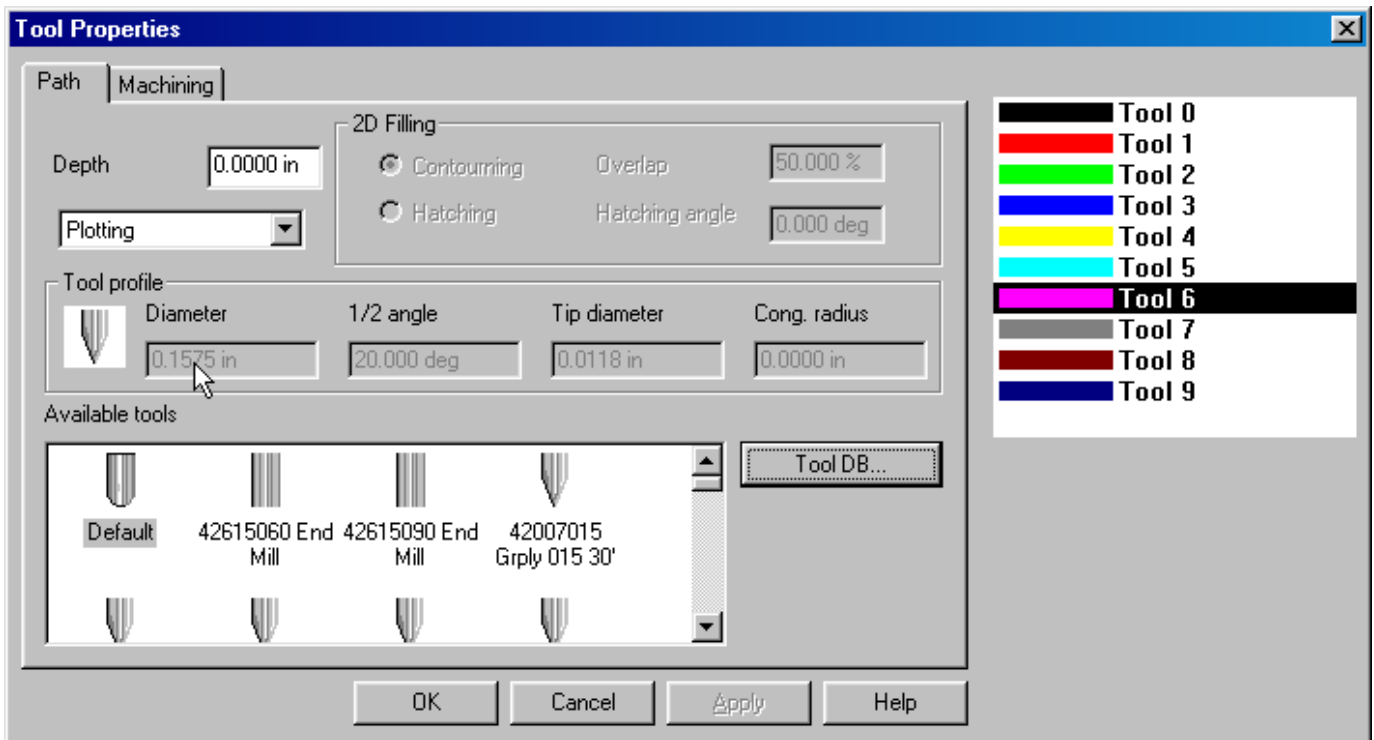
1. If you ever have a job that requires you to use more than one tool to complete the job, you do not need to send the job to the engraver one piece at a time. Just assign different tools to the items and send the job all at once. You can also have the engraver pause and prompt you for the tool change. The default tool is always Tool 0. Select the text or item that you want to use a different tool for then click on the Machining Tools button on the left side of the screen.



- When you click on the Machining Tools button the window will open. Select the tool or color that you want to use and double left click on it. If you click to the side of your work you will see that the item that you have selected will be that color the you chose.

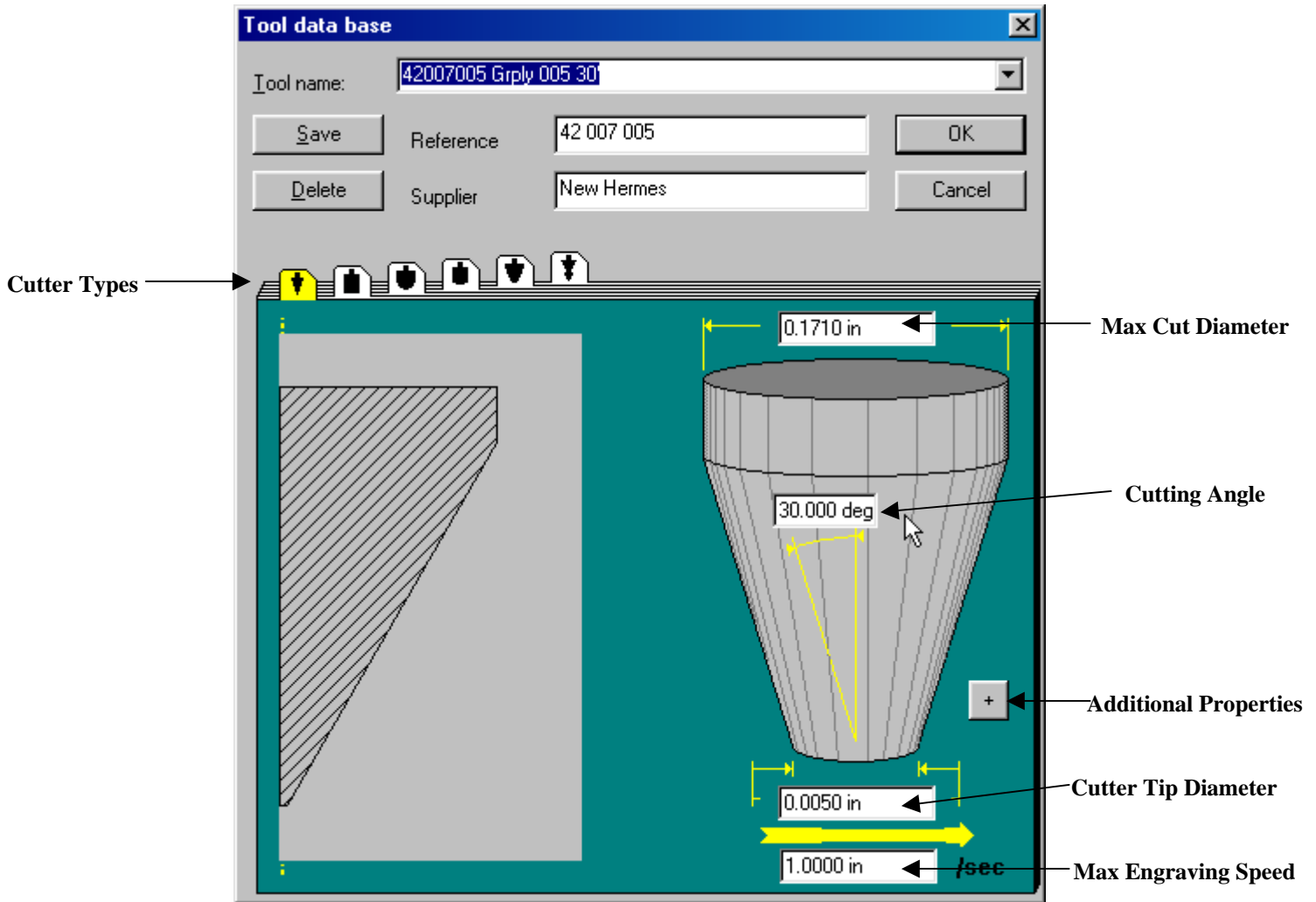


- Select the text or item again and you will see the tool highlighted on the Machining Tools page again. Now we are going to go into the Properties of that tool that you selected. Click on the Properties button. This will take you into the Tool Properties page.




- Select the tool that your going to use from the DB window then enter the depth of the cut you want to make. If the tool that you want to use is not in the DB you can design your own by clicking on the Tool DB button.

- Clicking on the DB button will take you into the Tool DB where you have the ability to design special tools or enter tools that were purchased from outside vendors. Once you design the tool and name it, remember to save it so that tool will be in your database for the future use. You can also enter the part number and suppliers name for future reference.



- Once you have entered the information click the Save button to save it in the Data Base click the OK button to assign the new tool to the job.

7. If you wish to assign more properties to your tool, (i.e. max cutting depth), then click on the  and it will bring up the Machining Features page.

Machining features

Depth

Max: 39.3701 in

Min: 0.0000 in

Cutting: 0.1250 in

Pass radius

Max: 39.3701 in

Min: 0.0004 in

Engraving speed

Nominal: 1.0000 in /min

Off-load: 5.0000 in /min

Max: 1.0000 in /min

Min: 1.0000 in /min

Lowering: 0.5000 in /min

Attack: 0.5000 in /min

Cutting: 0.0007 in /min

Flying angle: 90.000 deg

Vol. of chips: 0.1063 in³/sec

Nb teeth: 1

Feed/tooth: 0.0039 in

Spindle speed

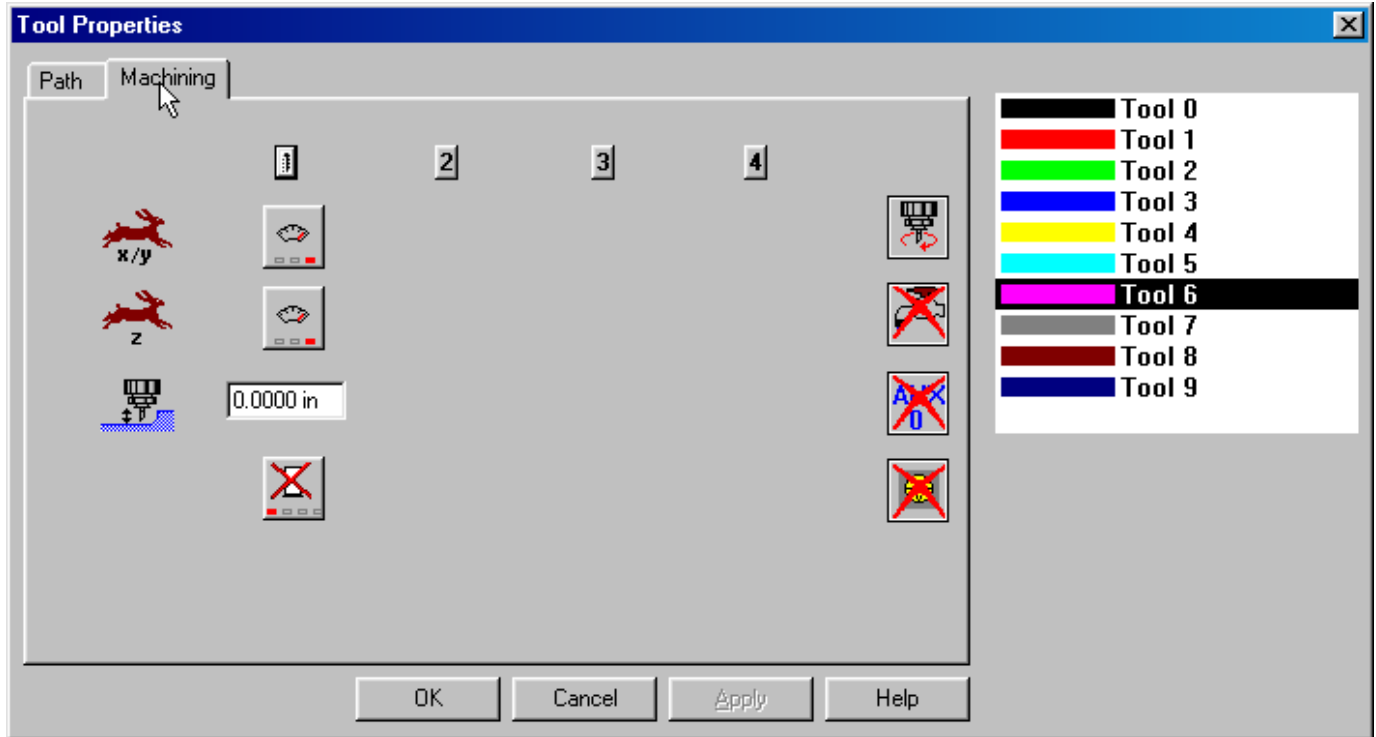
Nominal: 10000 RPM


Max: 2000 RPM

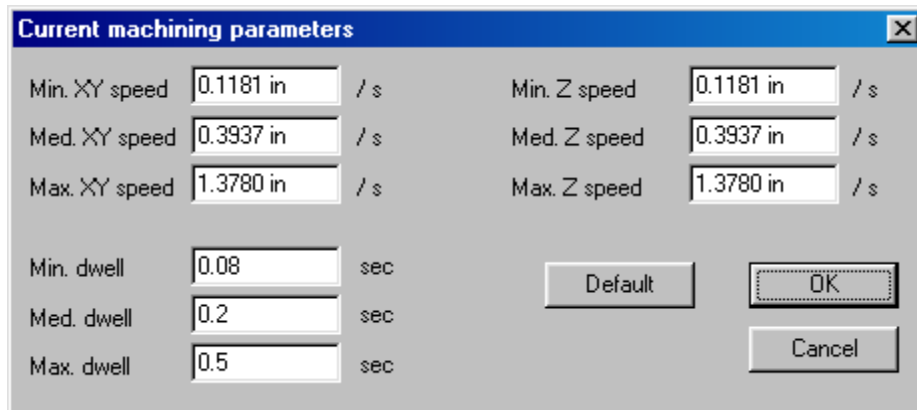
Min: 2000 RPM

Turret/Corrector... OK Cancel


- Now that we have the tool assigned we need to assign the Machining Properties. Click on the Machining Tab at the top of the page. This will open the page to assign speeds, passes, dwell, spindle on or off and pauses if you want them.




- Click on the  buttons beside the bunny rabbits to select the three preset values for both the X&Y and the Z. If this job requires a different value than the presets, click on the bunny itself. This will bring up the defaults page where you can make changes for this job. It does not change the defaults for the program.



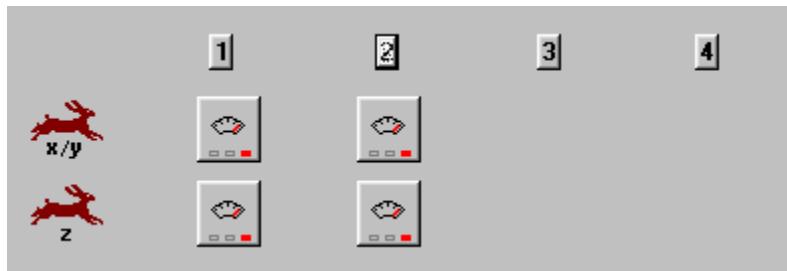



10. If you assigned a depth  on the first page of the Machining Tools page then it will automatically be brought over to this page. If not enter a depth now. This depth will be applied to the Z stroke of the machine from where you establish the Z setting. If you are using a Nose Cone to ride on the surface of the material then no depth is needed.



11. Now we need to determine Dwell.  Dwell is the amount of time that you want the cutter to stay at a depth before it moves in the X&Y axis. Mostly this is used for very hard metals or if you are using a large cutter. Click on the button and it will change to the presets. Again if the presets are not what you want, click on the bunny.

12. If your job will require multiple passes then you need only click on the number of passes that you want and it will open those passes up. Setup the values you wish for each pass.




13. Now we need to determine whether or not you need to have the spindle on. Click on the  and it turn the spindle Off. You will see a red X over the spindle. Click once more and the red X will go away and the spindle will be On.



14. The next two buttons will not be used unless you have an oiler or auxiliary equipment that you automatically turned on when the spindle is turned on.



15. The next button  is for the Tool Pause. If you assigned several tools to do the job and you want the machine to pause between tools to change the tools, click on the button and the red X will go away and the machine will pause between tools. Click on it again and the red X will appear.