
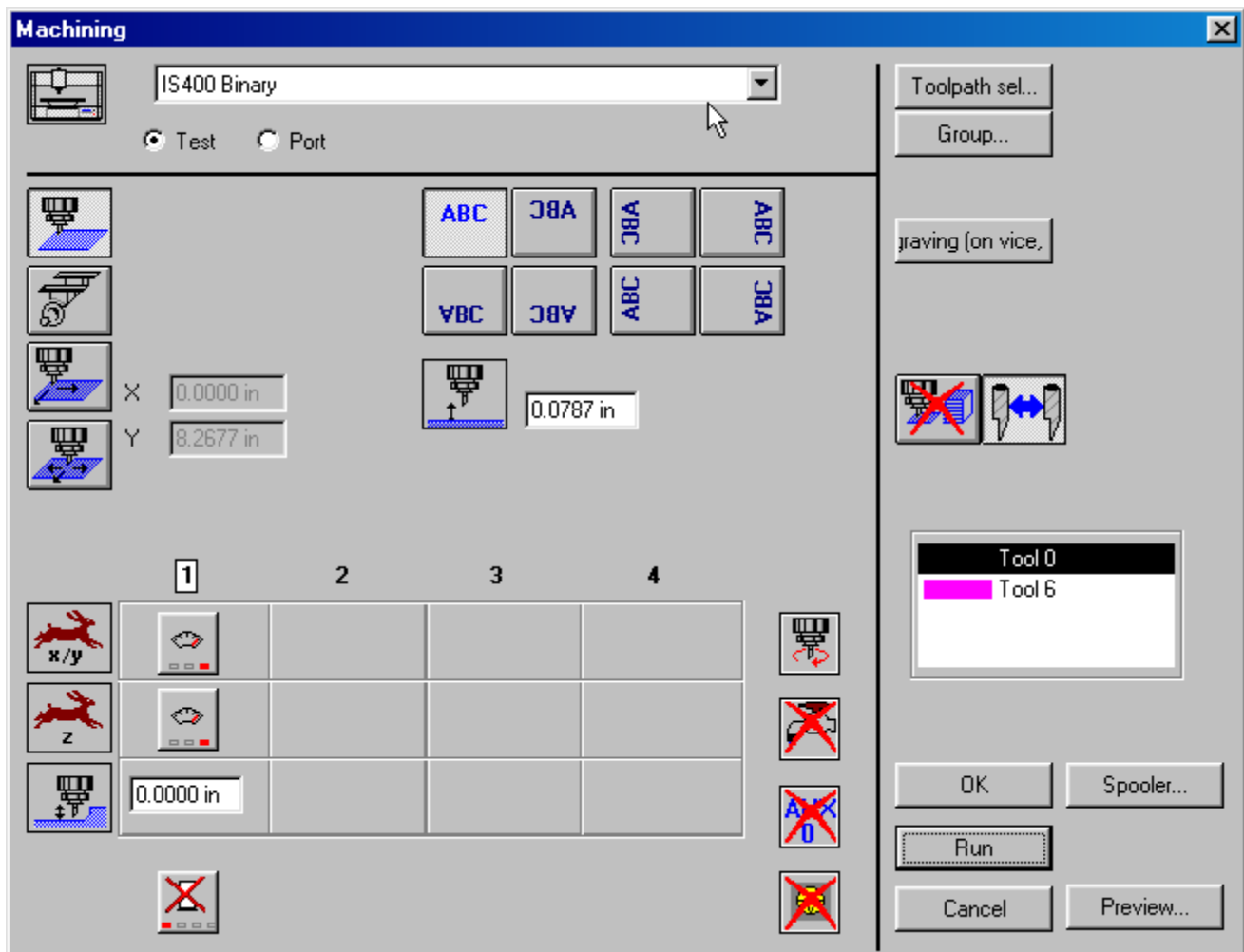




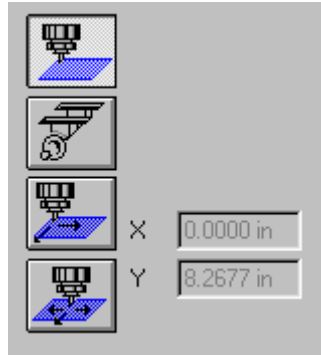
GRAVOGRAPH NEW HERMES

Machining

1. Once you have your job laid out the way you want it. It is time to send it to the engraving machine. Click on the  button and the Machining Page will come up.



2. First you will have to determine where your piece of material is located. Click on one of the four buttons so the machine will know where the piece is. The bottom two are for relocating the material. Third one down is for relocating from the upper left corner and the fourth for relocating from the center of the vise.



Material is the upper left corner of either the T-slot table or a vacuum table.



Material is located in the center of the vise or clamped in the center.



Material is relocated from the upper left. When you click on this button the windows to the right will open up and you enter the location.



Material is relocated from the center of the vise. When you click on this button the windows to the right will open up and you enter the location.




3. 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 then click on the bunny itself. This will bring up the defaults page to make changes for this job. It does not change the defaults for the program.


Current machining parameters [X]

Min. XY speed	<input type="text" value="0.1181 in"/>	/ s	Min. Z speed	<input type="text" value="0.1181 in"/>	/ s
Med. XY speed	<input type="text" value="0.3937 in"/>	/ s	Med. Z speed	<input type="text" value="0.3937 in"/>	/ s
Max. XY speed	<input type="text" value="1.3780 in"/>	/ s	Max. Z speed	<input type="text" value="1.3780 in"/>	/ s
Min. dwell	<input type="text" value="0.08"/>	sec	<input type="button" value="Default"/> <input type="button" value="OK"/> <input type="button" value="Cancel"/>		
Med. dwell	<input type="text" value="0.2"/>	sec			
Max. dwell	<input type="text" value="0.5"/>	sec			

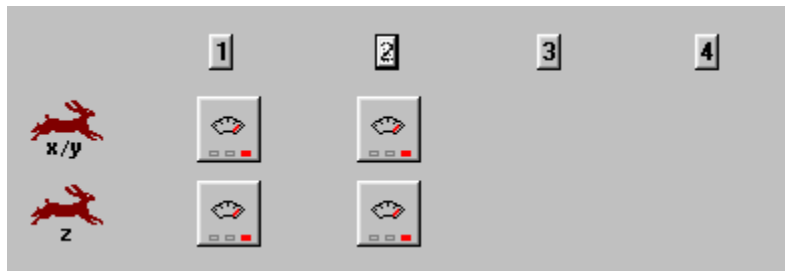



- 4. If you assigned a depth  on the first page of the Machining Tools page then automatically be brought over to this page. If not enter a depth now. This depth will be applied to the Z stroke of the machine from where you establish the Z setting. If you are using a Nose Cone to ride on the surface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

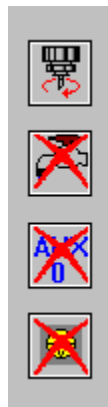


- 5. Now we need to determine Dwell.  Dwell is the amount of time that you want the cutter to stay at depth before it moves in the X&Y axis. Mostly this is used for very hard metals or if you are using a large cutter. Click on the button and it will change to the presets. Again if the presets are not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

- 6. 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.




- 7. Next determine whether or not you need to have the spindle on. Click on the  and it will 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.



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

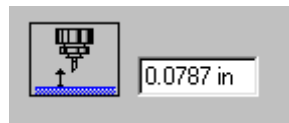


- 9. The  button is for the Tool Pause. If you assigned several tools to do the job and you want the machine to pause between tools to change the tools, click on the button and the red X will go away and the machine will pause between tools. Click on it again and the red X will appear.

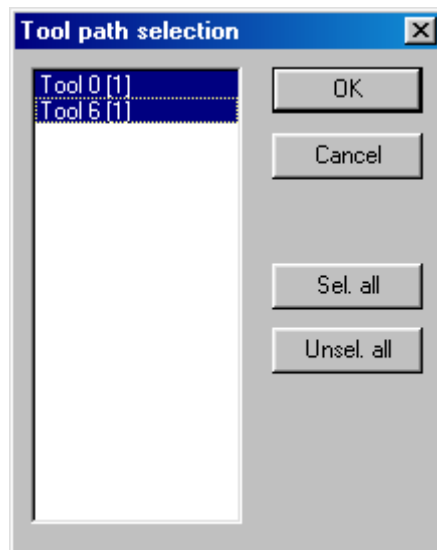
10. Now you need to determine how you want the engraving oriented on your piece, depending on how you have mounted the piece into the machine. These buttons will engrave the job just like you see the text on the buttons. But if you choose any of the buttons other than the one like you read, **ALWAYS** preview your work before you send it to the engraver. No matter which way you turn the material the top left corner, **NO MATTER WHAT**.



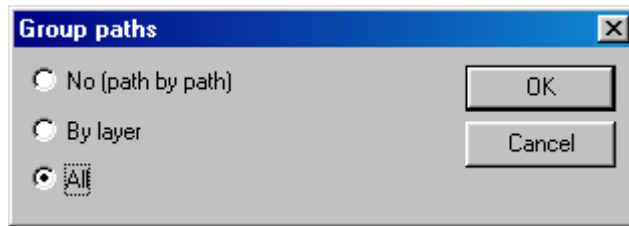
11. Now we will establish how much lift you want on the cutter between letters. This is very important if you are engraving on an uneven surface.



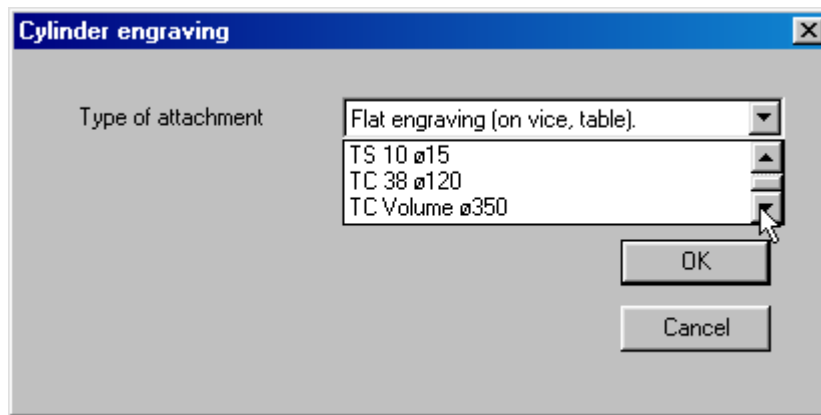
12. If you wish to have even more control of your engraving, by selecting the toolpath that you send to the engraver then click on the **Toolpath sel...** and the window will come up to allow you to select the toolpath that you wish to engrave. Click on the Unsel. All button then click on the tool that you wish to engrave and press the OK button.



13. If you wish to engrave all layers with the same toolpath, click on the **Group...** button. As you can see you can Group (collate) between paths, By layer or in most cases by All.

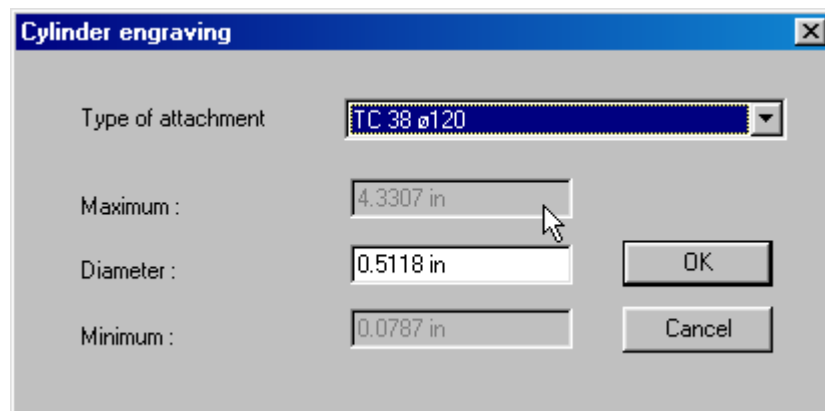





14. Next determine if you are engraving on the flat surface or a cylinder. The default setting is the flat surface, as that is what we engrave on the most. If you are engraving on a cylinder then click on the **Engraving (on vice, ...)** button. The Type Attachment Page will pop up. Click on the down arrow to open your choices.




- TS 10 Ø 15** Cylinder attachment for engraving on pens 10 to 15mm in diameter.
- TC 38 Ø 120** Cylinder attachment for engraving on cylindrical objects 38 to 120mm in diameter.
- TC Volume 350** Cylinder attachment on the IS400 Volume for cylindrical objects 350mm in diameter.

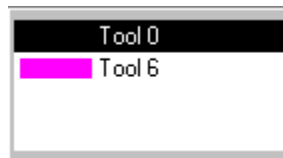
Select the cylinder attachment that you are using by clicking on it. This will bring up the page for you to insert the diameter of the object that you are engraving on. This input is very important. It is the only input that lets the machine know how far to rotate between letters.



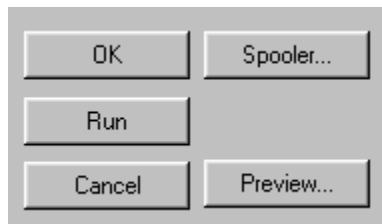
15. The  button is for the automatic material feeder. Most machines are not equipped with these devices so you should see a red X on it. This button also has another look.  This position is the Off position.  This is the On position.

16. If you wish to override the Tool Pause, if you assigned one, click on the  button. When you click on it the red X will go away. The machine will still pause but it will not prompt you for the tool change.

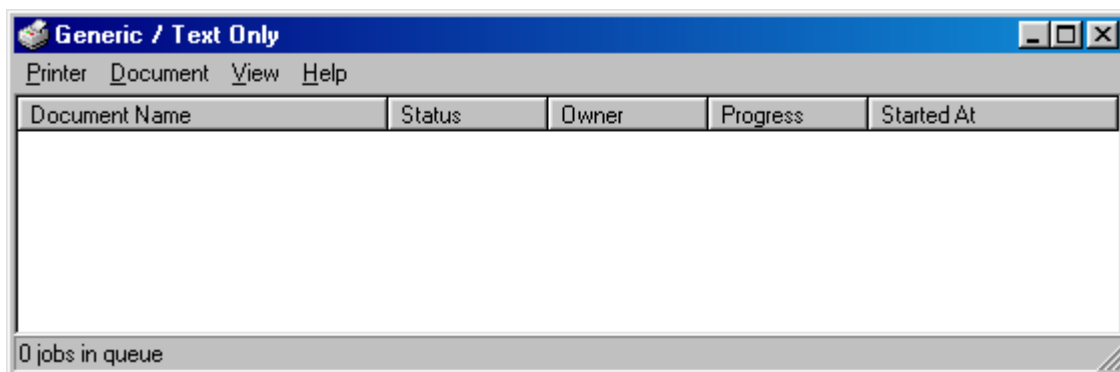
17. The next window is showing you the tools that have been assigned to this job. If you wish to make changes to the machining properties at this time, click on the tool to highlight it. Now you can change the speeds, depth and dwell. You can even remove the tool pause if you wish.



18. If you have saved your job when you finished the layout, none of the change you are making on the Machining Page will be Saved unless you click on the OK button.



Once you click on the OK button, all settings you made will be saved with the job file and will be there when you pull the job up later. Click on the Run button, it will send the job to the engraver. Cancel will Close the Machining Page. Click on the Spooler button and the windows spooler window will open up. This gives you the ability to pause the job, cancel the job and get to the properties of the printer driver.



Click on the Preview button and the engraving preview page will come up. This gives you the ability to see what your engraving is going to look like. The dots on the lines are depicting the start and finish point of each line or contour. As with the rest of the program, if you right click on a certain point it will zoom in. The red dotted line depicts the material definition. Make sure that no part of your engraving is outside your material as it will give you an overflow warning when you press the run button.

