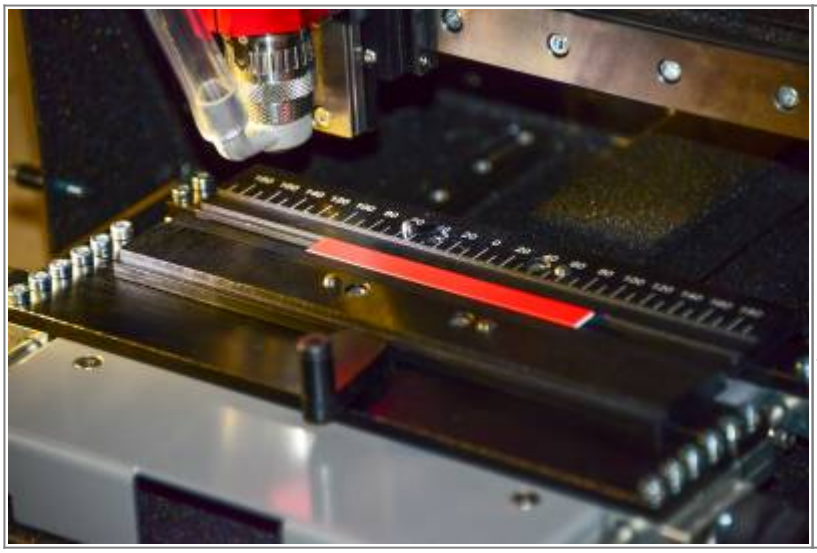
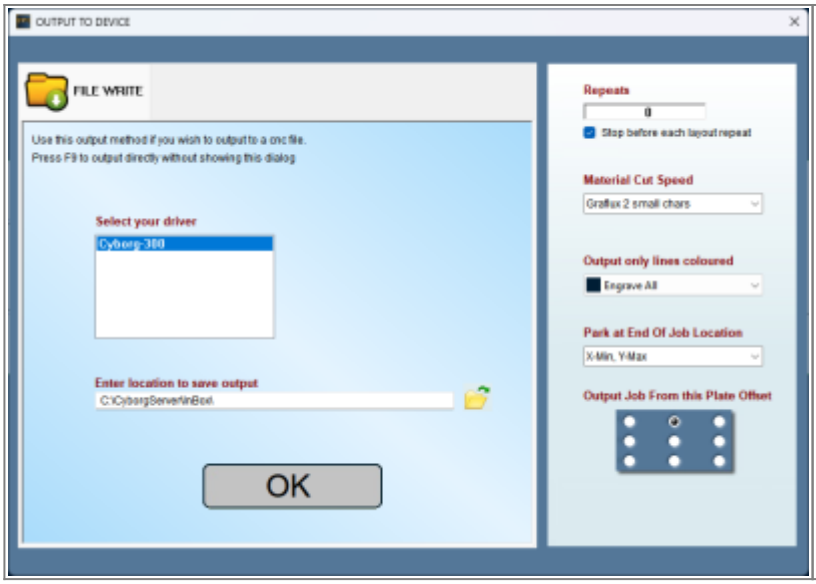
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# 6.3 Quick lock vise : a practical example.

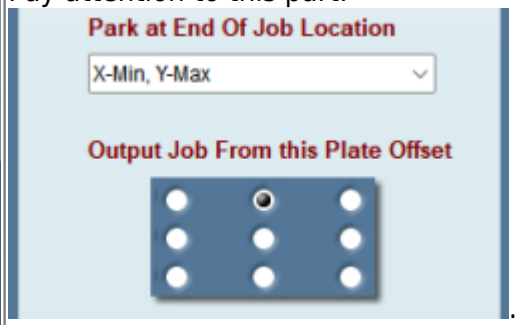
Before reading this section, make sure that you have read and understood the previous section about **defining jig home positions** .
As you know the X and Y machine home positions are hard defined in the upper left corner of the engraving table.
Before switching on the machine make sure that the knurled knobs on the X and Y stepper motors are well aligned with their respective reference plates.
In the X and the Y axis it is not possible to jog the spindle and the table beyond those positions.
In the Z-axis however it is possible to jog the Z upwards from the initial position.
When using the quick lock vise it is necessary to position the Z axis in the highest possible position.
To achieve that, after booting the machine, jog the Z-axis up to where it is (almost) fully up.
To set Z=0 in that position hit Shift and Return to home.

| | |
|---|---|
|  | In this example we are going to engrave a small Graflux 2 strip (10 mm x 100 mm).<br>Because of the small plate height we have to clamp the plate between the lower jig clamping borders which we programmed as “Home 2”.<br>the scale on the upper jig can be used as a reference to position the plate exactly in the middle. |

| | |
|---|---|
|   | Click on the “Home” icon.<br>In the little window which appears click on number 2.<br><br>The Home button now shows  .<br>At the same time the spindle will be positioned on this preprogrammed spot. |
|   | Jog the spindle and position it over the plate (not on the border of the plate).<br>Lower the spindle using the “Z down”  button till the spindle nosecone just touches the material.<br><br>There hit the “set surface”  button and click the “Enter” button in the little window which opens (the image on the left shows this little window).<br>The spindle will move up and the machine knows where the plate surface is. |




In Symmetry, after having entered the layout and text for the plate, go to “File - engrave output” and you will see the window here on the left.
Pay attention to this part:




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