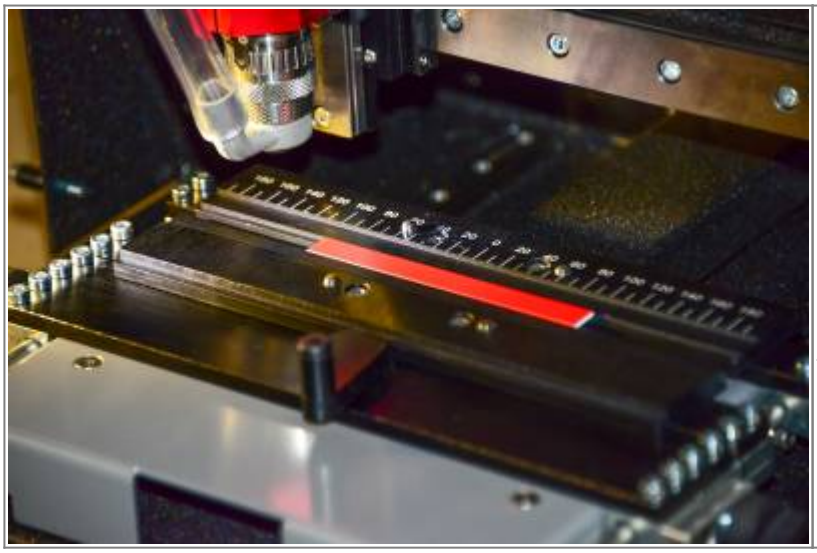
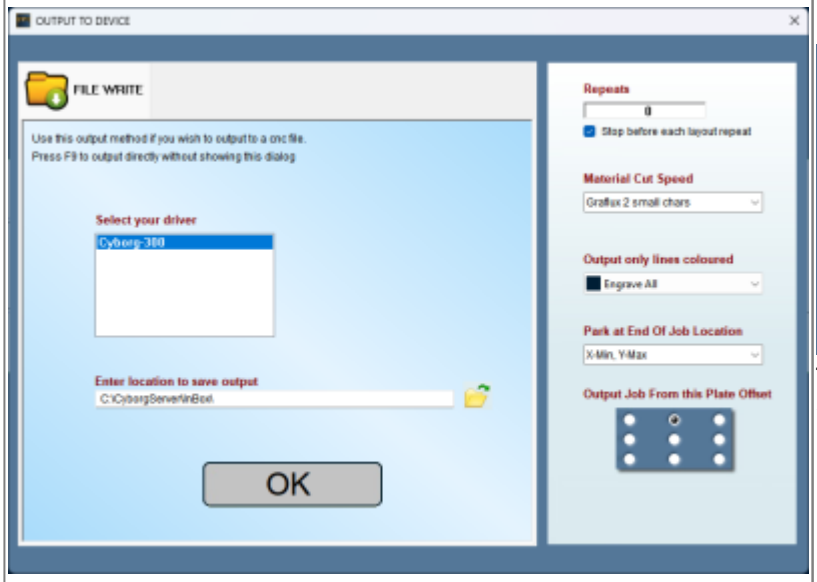
3fILE

6.3 Quick lock vise : a practical example.

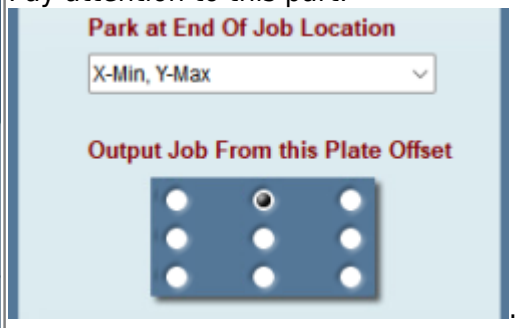
Before reading this section, make sure that you have read and understood the previous section about **defining jig home positions** .
As you know the X and Y machine home positions are hard defined in the upper left corner of the engraving table.
Before switching on the machine make sure that the knurled 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). Because of the small plate height we have to clamp the plate between the lower jig clamping borders which we programmed as “Home 2”. 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. In the little window which appears click on number 2. The Home button now shows . 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). Lower the spindle using the “Z down”  button till the spindle nosecone just touches the material. 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). 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:



The **Park at end of job location** lets you specify where the spindle has to park after finishing the job.
If you would select the default option (Home (0.0, 0.0)) then the spindle would be parked over Home2, which is not convenient to open the vise and remove the plate.
Better is to have the spindle move away from the vise at the end of the job.

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