Set material surface



This function is used to identify and set the surface of the material.

Before using this key, you have to make sure the spring retainer ring is not locked. The explanation below is valid only if your pendant display's "Plate surface" highlights "Map".

Once the material surface is set you should not have to reset it again unless:
a) the system has been shut off; or
b) the material thickness has been changed.

Setting Surface Z=0

Press the JOG ARROWS keys  to position the cutter anywhere over the material.

Press the SURFACE  hot key.

Keypad Display:

```
X= ###.### Jog Speed"
Y= ###.### Prox Setting"
Z= ###.### "
Setting Surface "
0=Autoset, ENTER=Set"
```

Press the Z-AXIS JOG ARROWS to lower head until it is just above the surface. Note: Be sure to check the Jog Speed when lowering the Z-axis. The machine is not actually surfacing until 0 is pressed. Running into the material can break a bit while jogging. Press "0" on the numerical keypad of your pc to begin the surfacing routine.

Notes:

Once "0" is pressed the Z-axis will move down slowly until the spindle with cutter touches the material. It will then move up above the material surface. Keypad Display "Auto Setting…"

```
     "Hold 0 to move down."
```

When the tool is at the tool lift height Keypad Display "Surface Set" Surface can also be set manually by jogging the Z-axis down to the desired position then pressing ENTER . When the tool is at the tool lift height Keypad Display "Surface Set" Press the CANCEL hot key to cancel this function without changing any settings. Keypad Display "Surface NOT Set."

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