

DeArmond Tool



806-381-8898

<http://www.dearmondtool.com>

P.O. Box 30684

Amarillo, Texas 79120

THIS IS A FREE CODE FILE AND INSTRUCTION SET. IT IS NOT TO BE SOLD. Enjoy.



TO CUT THE KNIGHT....

1....If you downloaded the .zip file, save the code file to a folder on your computer. Un-zip the file into that folder or some folder where you can locate the file.

2..... Presuming you use a separate computer to control your mill... Put the file on a disc, and transfer the file to the computer hooked to your mill. On that computer... put the file in the Mach3/G code directory. The hard part is over!

3..... Put a piece of material in your milling vise at least 2" square. and 1/2" thick. Make sure it is level in all directions.

4..... Put a 1/16" BALL end mill cutter in the spindle. You will need a cutting length on the end mill of at least 1/8".

5.....Start the "Mach 3" controller program and using the jog keys zero the X & Y axis. The zero point for this "G" code program is in the bottom left corner of your material when facing the mill from the front! Using the jog keys, center the cutter on the X & Y axis so that it is half "on" and half "off " the material. When done correctly, the bottom left corner of your material will be in the center of the cutting tool. ...read that last sentence again! Sorry, it just needs to be said that way!

6.....Using the jog keys, lower the "Z" axis down to the surface of the material. For the first few times, place a piece of paper under the cutter during this step....move the piece of paper around on the material surface while using the SLOW jog to lower the "Z" axis. The instant the cutter stops the paper from moving...STOP! Try this a few times for practice.

7.....Make sure the knight.tap file is the one loaded... There is a box on the Mach 3 screen that tells you. If it is NOT loaded...load the program.

8.....Here Goes! Make sure everything is clear of the cutting tool. If you are using a CL machine, the spindle will start automatically. If you are using an OL machine you will need to turn on the spindle manually.

9.....Press "Cycle Start" on the screen..... Sit back and watch!

WHAT TO EXPECT..... The first thing that will happen is the "Z" axis will raise .15" for safety clearance. Then, the "X & Y" Axis will move the material under the cutter to the starting point. The "Z" axis will drop the cutting tool into the material. From here the SPIRAL cut starts, cutting until the knight is completely carved out just like you see here. Last, the "Z" axis will raise back to it's .15" safety height and the "X & Y" axis will return to zero position.

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Phone.... 806-381-8898