

Shopbot Cutting using Aspire/ VCarve Toolpath

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1. Shopbot Machine

- a. Put on eye and ear protection
- b. Close the doors
- c. Check to see that the machine has been warmed up
- d. Check to see bit is not loose
- e. Measure the thickness of the material that you plan to cut.
- f. Raise the Z-axis so the bit won't drag on the table (no higher than 4 inches)
- g. Use the proximity switch to set Calibrate. **(C3 keyboard command)**
- h. Calibrate Z AXIS on the table. **(C2 keyboard command)**
- i. Raise Z AXIS 4 inches using the **JZ 4** command
- j. Attach material to the table using screws
- k. Raise Z AXIS 4 inches using the **JZ 4** command
- l. Set new X and Y Origins for your design
 - i. Raise the Z-axis so the bit won't drag on the table
 - ii. Using keyboard jog to the appropriate X and Y location. **(J2 X,Y)**
 - iii. Using keyboard to zero the appropriate X and Y Location. **(Z2)**
 - iv. You set origin.
- m. Select Cut

2. Start up Aspire and VCarve software

- a. Open your file
- b. Select objects you wish to cut
- c. Select Toolpath
- d. Pin Toolpath

3. Click on material setup

- a. Check Z - zero is on the bed, NOT the board
- b. Enter the thickness of the material *
 - i. Model position material should be the same thickness as the material.
- c. Click OK.

4. Go to TOOL PATH OPERATIONS

- a. Select 2D Profile Toolpath
 - i. Under cutting depth, select the cut depth of the material (CLS tools).
 - ii. Select the proper tool -CLS down bit ¼
 - iii. Click add tabs and add tabs
 - iv. Hit CALCULATE.
- b. Preview toolpath
- c. Click on CLOSE
- d. Select SAVE TOOL PATH and save the file in a shopbot format

5. Start ShopBot Command Console

6. Conduct air cut

- a. Select FILE-LOAD
- b. Load the appropriate file
- c. We Select 1 3-D offset
- d. Press ENTER

- e. Turn on the spindle by pressing the big GREEN Button
- f. You should hear a "SOUND" of the spindle now turning
- g. Press ok
- h. After checking that everything is good; press space bar
- i. Select quit
- j. Return to origin (**J2 0,0**)

7. Perform cut

- a. Select FILE-LOAD
- b. Load the appropriate file
- c. Select **no offset** rather than 1 3-D offset
- d. Press enter
- e. Turn on the spindle by pressing the GREEN Button
- f. You should hear a "SOUND"
- g. Turn on the vacuum
- h. Press enter again to start cut

8. Cut is done

- a. Turn off vacuum (which is so loud you shouldn't forget)
- b. Use a hammer and chisel to remove tabs

9. Clean up after yourself

- a. Get a broom and sweep