



Machining Small Objects

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When machining blanks that are not large enough to use vacuum, clamps should be used. There is a set of clamps. The set consists of clamping bars, adjustable height blocks, T slot nuts, studs and nuts. (17mm) If the part is to be completely cut out, a spoil board is needed. The spoil board's size need to be larger than the footprint of the blank, and small enough to work within the T slot rails. Place the blank onto the small spoil board and position at least three clamps. There are breaks in the T slots on the machine bed for the slot nuts to be inserted and slid into position.

Defining the new Zero height.

A change in spoil board requires a recalibration of the zero height. Use FUNCTION 28 to set the height of the spoil board. **MAKE SURE THE TOOL HAS BEEN QUALIFIED BEFORE PERFORMING A FUNCTION 28.** Bring the tool down to touch off the height of the spoil board.