

Planeing the Wasteboard

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Planeing the Wasteboard

1) Position the wasteboard hard into the corner and location blocks

2) Turn on the vacuum pump!

3) **Remove location blocks!!!**

For a new board both sides need to be dressed to remove wax coating and level the board. 1.5 to 2 months under heavy use. 1mm deep initially on first side on a fresh board .5mm deep on second side on a fresh board. From this point the board should need not flipped until a new board is used. .2mm deep there after on the same side

Planning the Wasteboard

4) Key in F28 on A2MC Console

- Set waste board **No**

Wasteboard must be set AFTER the planing table or machine bed damage may result!

- Plane table yes
- Tool Diameter 45
- Overlap 50%
- Length (X Axis) 2420mm
- Width (Y Axis) 1230mm
- Z depth .5 mm
- Feed rate 12000mm
- Spindle RPM 10000
- Set origin NO
- Plane table Yes

Set the Wasteboard

When planing is complete replace location blocks.

Now you need to set the waste board (ie zero the Z Axis)

5) Key in F28 on A2MC Console

- Set waste board Yes

Jog tool down to complete a manual tip off (as per [manual tip off](#)) and press OK when you are have just touched.

LINKS[CNC Router Operations](#)[Other Operations - Staff Only](#)[Multicam CNC Induction](#)