



X-Carve Technical and Maintenance

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Hardware

Frame

- Shapoko 2 with X-Carve upgrade kit, 1000x1000mm frame.
- Guaranteed Usable area: 700x700x50mm (Slightly more with care)

Electronics

- Arduino Uno + Synthetos gShield (grblShield) V5b
- External Emergency stop(Kills power.) Plus Reset connected back to controller.
- Hard limit endstops(microswitches) on both ends of X and Y, plus top of Z
- Z Probe with 2.1mm Barrel plug connector.

Mechanical

- Nema 17 steppers. (Y and Z)
- * Smart Automation SM42HT47-1684B 1.8° 1.68A, (<http://www.smartautomation.com.cn/ProductShow.asp?ArticleID=497>)
- Nema 23 steppers (X)
- * SHINANO KENSHI NO. 03640 1.8° 2.0A (No datasheet)
- 6mm GT2 belts. **18** tooth drive wheels.
- ACME Thread Z drive.
- DeWalt D26204 Router.
- Collets for:
 - 1/8" (Dremel/XCarve bits)
 - 1/4" (Standard Router Bits)
 - 6.0mm (Cheap Metric Tooling)

Hardware changes

- Springs to counteract router weight
- Spring loaded front guard

Software

Tested

Easel

- HTML5 Web based, XCarve default
- Good test, OK for home use, limited final use due to log in and web based.

Makercam + Universal G-Code Sender.

- (Flash+web based. <http://www.makercam.com/>)
- Limited in use due to no path/tool saving, reliance on internet, problems with flash.

Autodesk Inventor

- GCode exporting tool. Works well. Complicated and expensive.

Current

Vetric V-Carve Pro + Candle

- Easy to use, works very well, allows work off site. (Makerspace ID: 86B4F-F467A-280D9-9F4C6-9C56B-4C528-BEE6F)
- Candle(Previously grblController) is friendly and easy to use. Allows custom buttons.

Log of works

- Original kit dismantling.. (Prior to Holley's arrival)
- First full build. (Started a few weeks into when Holly arrived)
- Original table. Early dust extraction.
- Final Vacuum cleaner based Cyclonic Dust extraction system.
- New custom built table
- New software(VCarve!)
- Z-Touch probe
- New computer, clean install, ready for Public. (Nearly done)
- Room sound proofing.

Things **TO DO******

- Room sound proofing. **(Critical)**
- Document running procedure. **(Critical)**
- Emergency stop needs to connect to an end stop to trigger Alarm.
- Wiring diagrams need to be drawn up.
- Dust mitigation. Guards for side wheels and edges. (Acrylic?)
- New dust shoe.
- Tooling lists need to be finished.
- New dust extractor barrel/top/baffle.
- XCarve Table lowered by 100mm
- Signage.

Upgrades

- TinyG v8 Controller. (Brought. Needs testing.)
- Nema 23 Steppers. (Obtained)
- 8mm GT2 belts.
- New dust shoe. (Needs finishing)
- SuperPID Speed controller for Spindle.

Config

Candle(grblController):

```
Z-Touch: G53G0Z-30 ;G21G91G38.2Z-50F50 ;G92Z15.61 ;G90G0Z40  
Safe Home: G21G90; G53G0Z-3X-650Y-100
```

```
Motor timeout:  
$1=255 for 'leave motors on'  
$1=254 for 'switch off after 254mS'
```

grbl internal settings:

```
$$ < $0=10  
$1=254  
$2=0  
$3=1  
$4=0  
$5=0  
$6=0  
$10=3  
$11=0.020  
$12=0.002  
$13=0  
$20=0  
$21=1  
$22=1  
$23=3  
$24=25.000  
$25=3000.000  
$26=250  
$27=2.000  
$30=1  
$31=0  
$32=0  
$100=44.440  
$101=44.440  
$102=188.976  
$110=8000.000
```

\$111=8000.000
\$112=500.000
\$120=500.000
\$121=500.000
\$122=50.000
\$130=720.000
\$131=720.000
\$132=100.000

Notes

Blah!