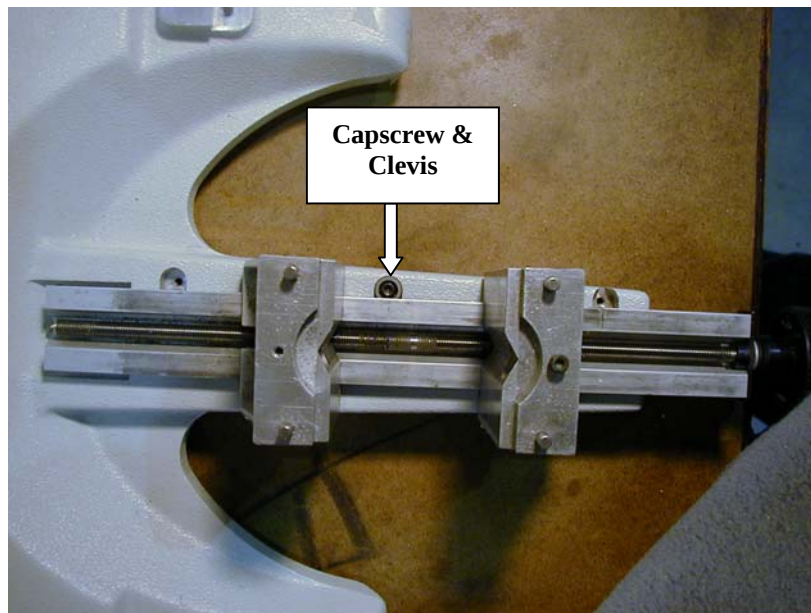




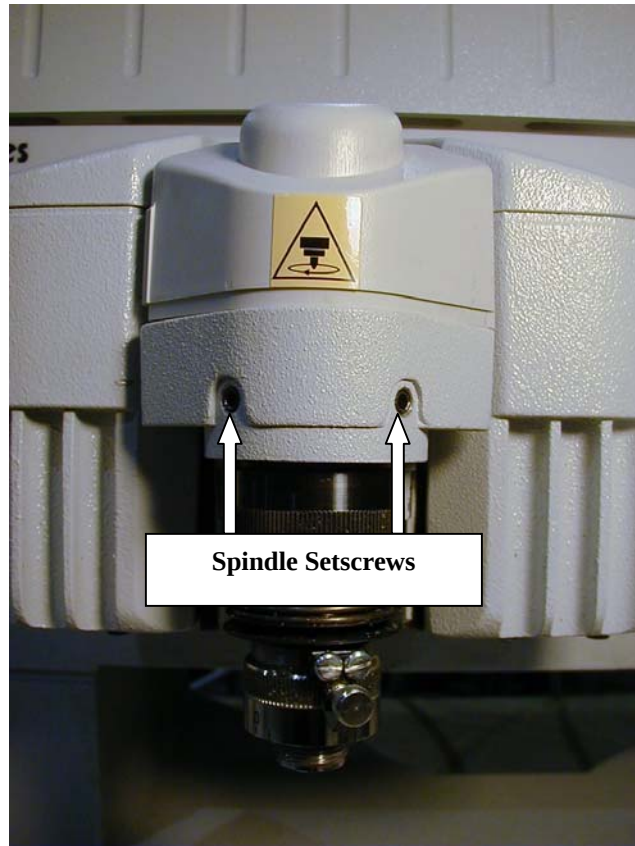
Inside Ring Engraver

QuickStart

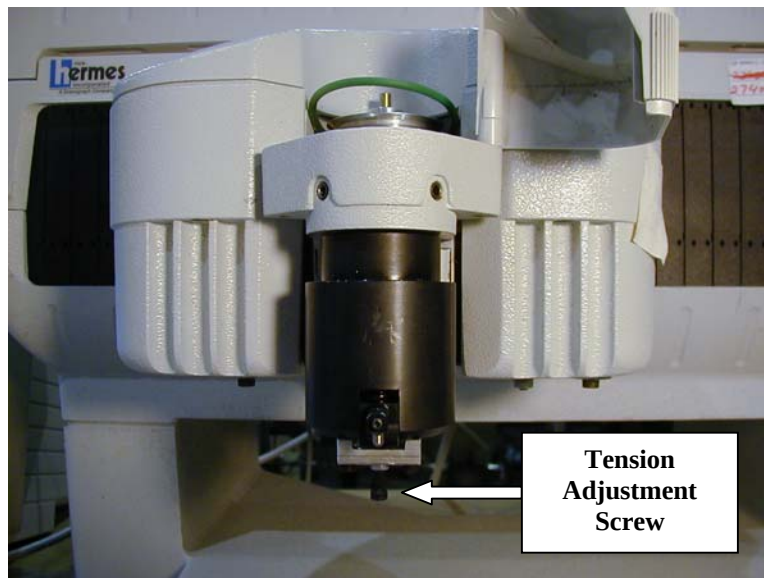
1. Remove the vise assembly by loosening (do not remove the clevis completely) the caphead screw holding the clevis. Slide the vise out of the slot and set it aside for future use.



2. Remove the spindle by loosening the setscrews locking the spindle in place. Set the spindle aside for future use. Install the Inside Ring Engraver spindle, making sure that the diamond tip is pointing straight out from the machine. Tighten the two setscrews.



3. The setscrew, with locknut, on the bottom of the spindle can be adjusted to control the amount of tension on the diamond tip.



4. Slide the assembly into the groove for the vice. Make sure that the adjustment screw is all the way against the stop. Tighten the clevis at this time.



5. Install the ring making sure that the ring is centered in the chucks.



You will notice that the chucks have a groove in the center of them to ensure you have the ring placed in the center. If you have a large width ring, unscrew the screws on the chucks and turn them around.

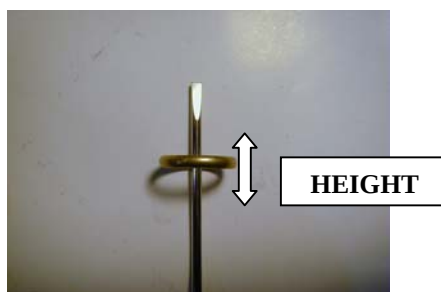


SMALL WIDTH RINGS

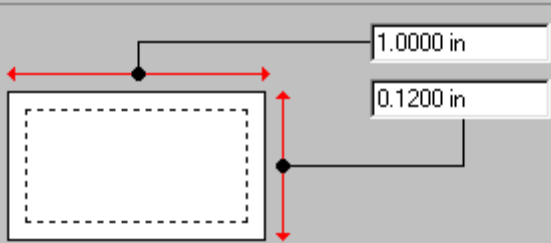


LARGE WIDTH RINGS

6. It is now time to setup a job in the software to send to the Ring Engraver. Open GravoStyle and set the material size to the size of the ring. For the practice ring you can set your width to an even number such as 1 inch and the height to the thickness on the band, for the practice ring it will be a .12 inches.



Material [X]



1.0000 in

0.1200 in

Automatic margins ☐

Margins equal to left ☒

Left 0.0020 in

Right 0.0020 in

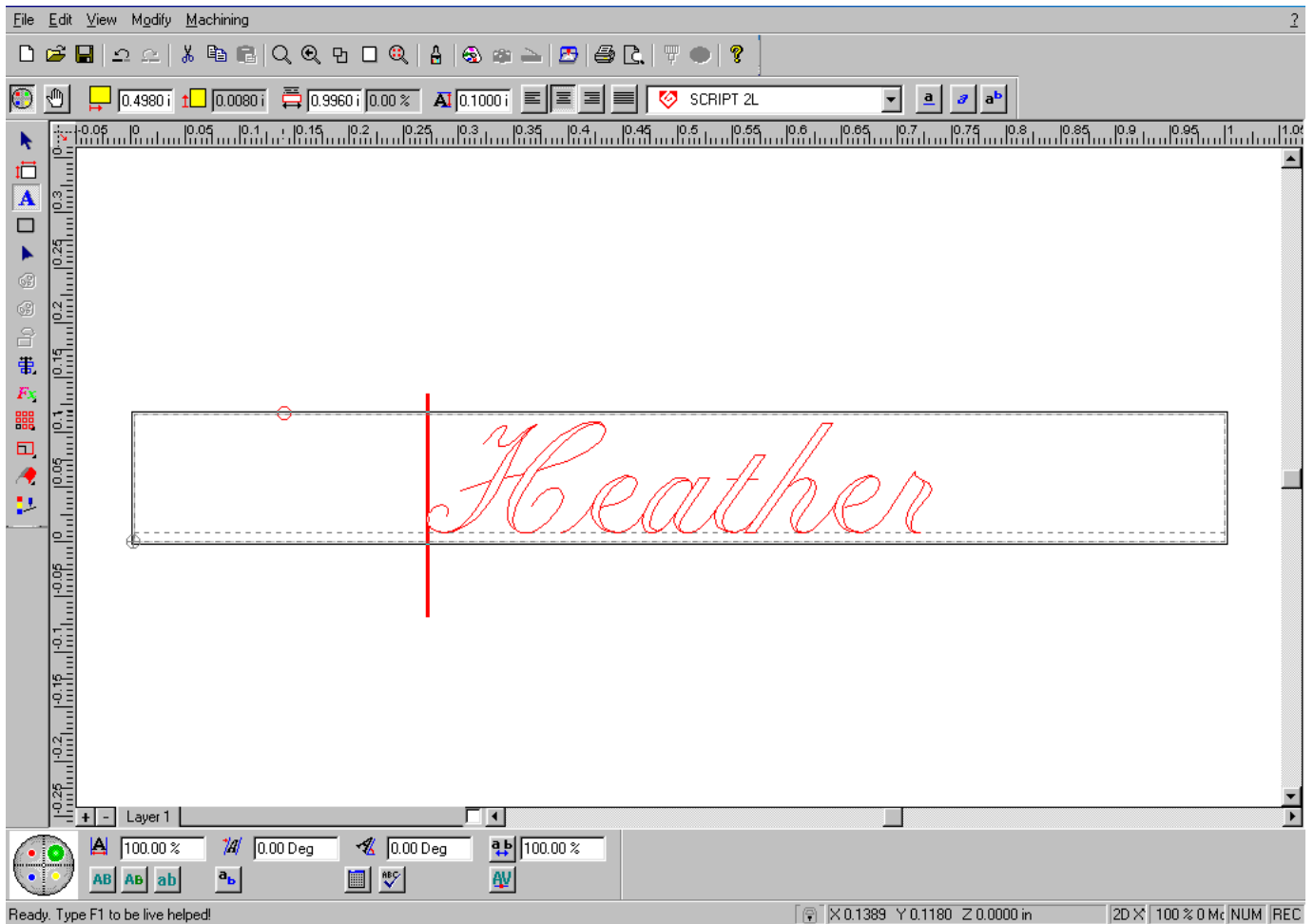
Top 0.0020 in

Bottom 0.0020 in

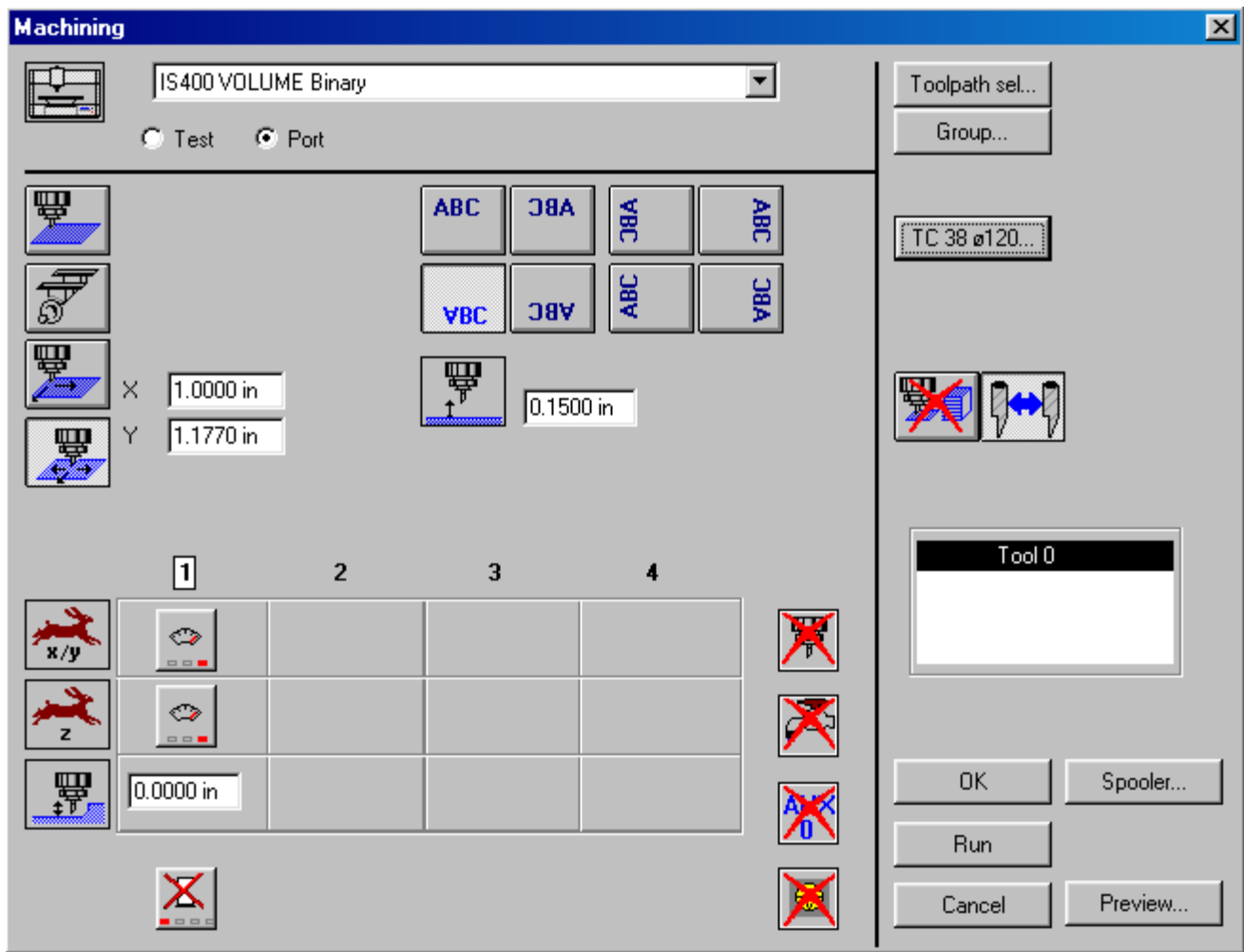
Thickness 0.1969 in

OK Cancel

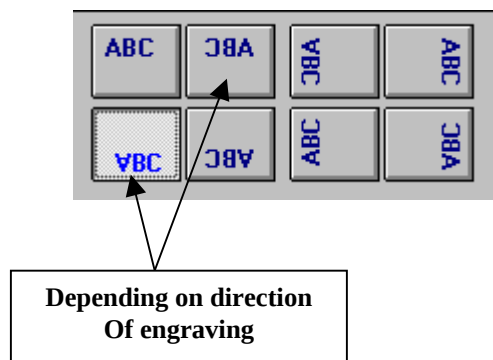
7. Insert the Text Height and the Text Style and type the name in that you want on the ring.



8. Now click on the Machine icon  to go into the Machining Page to set up how you want the job sent to the engraver. You should always use the relocateable origin from the center of the vice and enter the number on the X axis of the width of your material. The Y axis should always be 1.177, because the center of the Chuck is 1.177 inches from the center of the vise.



9. The positioning of your engraving as determined by the ABC buttons should be either of the two buttons shown below.



10. Set the rest of the Machining Page up as you normally would, remembering to turn off the Spindle Motor. The last setting you need to make is setting up the Cylindrical Axis. Click on the Button for the surface Engraving (on vice) and select the TC 38 to 120 option. This will open the Cylindrical window so you can insert the Diameter of the ring. Keep in mind that we are working on the inside Diameter of the ring. The practice ring that comes with the Ring Engraver is .82 inches in diameter.



Cylinder engraving [X]

Type of attachment	TC 38 ø120	
Maximum :	4.3307 in	
Diameter :	.82	OK
Minimum :	0.0787 in	Cancel

11. Preview your work to ensure that you are inside your material definition. If so, close the preview window and send the job to the engraver. When the job is received the engraver will go to the home position and then move to the center of the X axis. Press the Down arrow on the Hand Controller. This will bring the spindle out to the edge of the ring.



12. Move the spindle in and set you Z Ref. And you are ready to run the job.
13. If you want to position the text in a certain location on the ring there are a few things that you need to remember. Standing in front of the machine and looking down on the ring, the tip of the diamond will be pointing at the upper right corner of the piece. This is because you are engraving on the bottom of the rotation. So the best way to locate your engraving where you want it is to rotate your ring until the diamond is pointing at the edge but also in the center of where you want it to be engraved. Now rotate it back to the right half of your material width. Then press the Check Mark on the Controller to accept this location then press the Run button.