Surfacer Instructions

This program writes GCode that will use the EBF 2 1/2 inch diameter surfacing tool to Surface a wood slab. This tools should be in tool slot 8.

Max width of slab is 55 inches

Max length of slab is 100 inches

Be sure your slab is well attached to your spoil board. It should not move, at all. Use wedges or other supports as needed so that the slab does not wobble on the table and is well supported on all corners. Supports should be attached to the spoil board to avoid slippage.

Launch the Surfacer program

Enter the slab width in inches rounded up to the next whole inch.
Note: This width is the number of inches from the leftmost edge of your slab to the rightmost edge of your slab relative to the long axis of the EBF. Be sure to take into account any curvature or edge protrusions.

Enter the slab length in inches rounded up to the next whole inch.

Click the 'Write Gcode' button.
Create a filename in the folder of your choice. **NO spaces in the file name**.
Note: Two files will be written. A .nc and a .tap file.
The .nc file is the gcode program you will run from WinCNC
The .tap file is a subroutine called by the .nc file

The files are created quite quickly.
Remember the folder where you store your program
Click the 'Exit' button to end the program

Be sure the surfacer tool is in tool slot 8

X zero and Y zero will be the **center** of the surfacer tool over the **left front corner** of your slab (or, the leftmost and frontmost X Y location relative to your slab).

The Z zero must the set to where the cutters of the surfacer tool just touch the **highest** point on your slab.

The program will start 3 inches left, and 3 inches more forward of your front left slab corner and begin cutting into your slab from that point.

Each pass is 0.050 in depth. After each pass you will be asked if you want to continue with another pass. Pressing enter will start the next pass. Halting the program (stop menu item (NOT emergency stop)) will stop the program. Issue a T0 command to remove the surfacer cutter from the spindle.

| Regular Slab | Curved Slab | Irregular Slab |
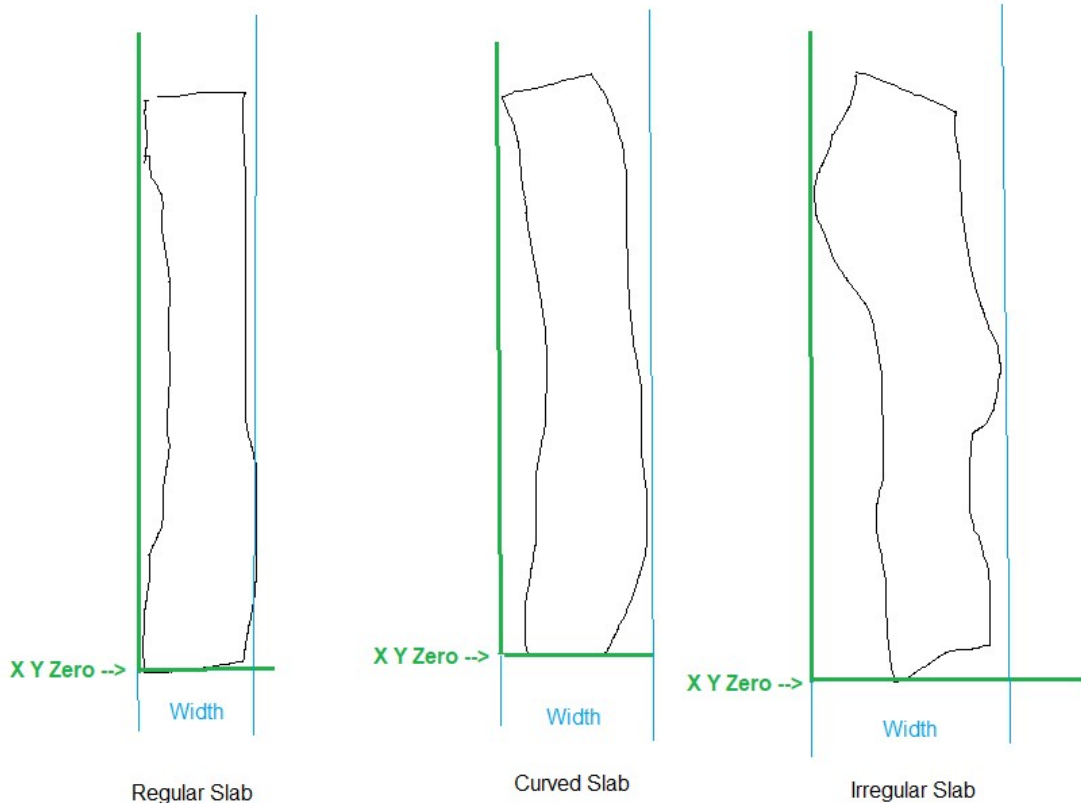
Program will run for a maximum of 20 passes (1 inch total). You may run the program again if you need further surfacing.