



TECHNICAL SUPPORT SERVICE

Step-By-Step Guide to the Rotation S machine

Flat Plate mode

1. Make sure you have the correct jig in the vice and also that the material is in securely.
2. Set the cutter or diamond into the spindle prior to sending the job.
3. Decide what profile to use. Do you need the spindle on or off? To change this press menu, then set on Profiles. To access the profile you want to use press menu when the curser is flashing on it. Check to make sure the values within this profile are correct.
4. On the front of the handset it should read which profile you are using, for example. Drag, Nosecone
5. Send the job over to the machine, it should read "Ready to engrave press {run} to start or {menu} to set Z.
6. Press menu and set your height, Auto Hi and Auto Lo automatically brings the cutter/diamond to the surface and adds preload set in the profile *(see point 3). Manual allows the user to bring the z down to the surface allowing the user to add preload manually.
7. Once the height is set, the job can now be run.

Rotary Mode

1. Prior to putting the machine into Rotary mode, press the home button, this will send the machine head to the top left corner.
2. Undo the holding screw on the gas strut and push the whole vice system down to the very bottom position on the runners. Loosen the handle under the vice and spin the table around until the rotary vice is on top and tighten the handle.
3. On the handset press Set twice this will move the spindle head to the centre of your vice.

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4. Put your material (e.g. Tankard, Cup, Glass) into the vice and make sure the surface you are engraving is level to the spindle head, if not adjust accordingly.
5. Make sure the centre of the spindle is centre to the material, or to the position you want it to start, if it is not undo the holding clamps and move material to the correct position.
6. Decide on what profile to use, a spinning diamond should be used for Glass engraving.
7. Check the diameter of the material and enter it into the machine, to do this press set, then menu. This allows you to enter the diameter and also the surface you want to engrave, e.g. outer, inner, outer reverse, inner reverse. Press set once you have confirmed the correct values.
8. Send the job over to the machine, it should read "Ready to engrave press {run} to start or {menu} to set Z.
9. Press menu and set your height, Auto Hi and Auto Lo automatically brings the cutter/diamond to the surface and adds preload set in the profile* (see point 3). Manual allows the user to bring the z down to the surface allowing the user to add preload manually.
10. Once the height is set, the job can now be run.

Ring Mode

1. Whilst in Rotary mode, put the ring chuck onto the machine.
2. Place your ring in to the chuck and align the ring chuck so it is directly underneath the tip of the ring diamond.
3. Press menu and move the curser to Jog, press set and move the curser to Jog Z, use the arrows to jog the Z axis down so it is just above the ring (about 0.2mm) and press set. Press esc twice to return to the "Ready to receive job".
4. Press set and then Menu, now set the diameter of your ring, and change the surface to inner and press set.

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5. Send the job, the z-axis will now lift and the handset will read "Ready to engrave press {run} to start or {menu} to set Z.
 6. Press menu, the ring will move to the position in which the engrave will move.
 7. Press set on manual, the spindle will move out, down and then into the ring, now use your down arrow to set your z height and press set.
 8. The spindle will move out of the ring and back to the limit switch.
 9. Press Run to start and the ring should now be engraved.
- * Do not use auto hi or low when using the feather touch cutter knob always use manual setting.

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