



## Table Milling Procedure

- Set RPM to 1700
- Set feed to 200 IPM (refer to Max Speed on controller)
- Set blade diameter to match the planing wheel diameter (top right of Home screen)
- Measure your table width and length, add 2 inches to both (example:136"X, 82"Y, record these values for later)
- Set blade width to match planing wheel width/thickness (example: 1.6")
- Use planing wheel to touch the low spot on the table
- Record your Z height (the value to the right of the letter Z)
- Raise the head up in Z and then all the way to the left (-X) 0 in X
- Center your planing wheel with the front of the table (approx. 6.8 in Y)
- Safely lower to your previously recorded Z height by clicking on the Z Absolute numbers and then input your recorded Z height (from low spot)
- Slowly move toward the table (+X) stopping approximately .5" short of table
- Position the square water manifold in front of the wheel and the blue water nozzle on the rear of the wheel
- Position the water valve at 45 degrees to split the water supply between the front and back of the planing wheel
- From the home screen click F3 and then F4
- Fill in ALL values
- Table L x W recorded earlier
- Make your Step slightly smaller than your wheel thickness (example: 1.4")
- Water opening must be set to Yes
- Verify potentiometer speeds are safe for starting
- Click Start
- Monitor the planing wheel audibly also watching motor amperage to regulate potentiometers based on material hardness)