

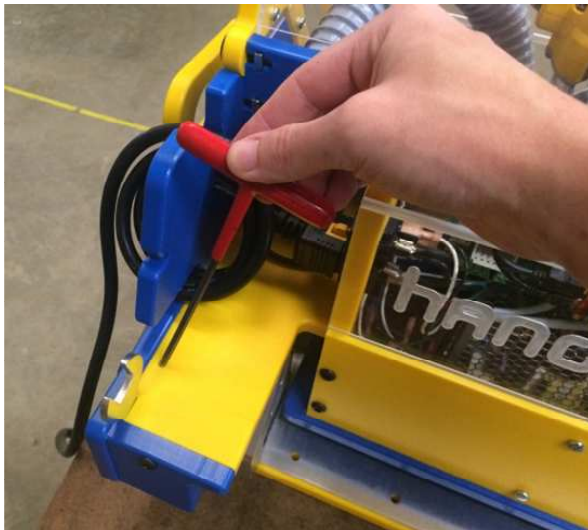


Installing Accessory Motor Cable

- 1 For safety, switch off the power to your Handibot before touching any electronics.



- 2 Grab your trusty 4mm wrench from the back of the tool.



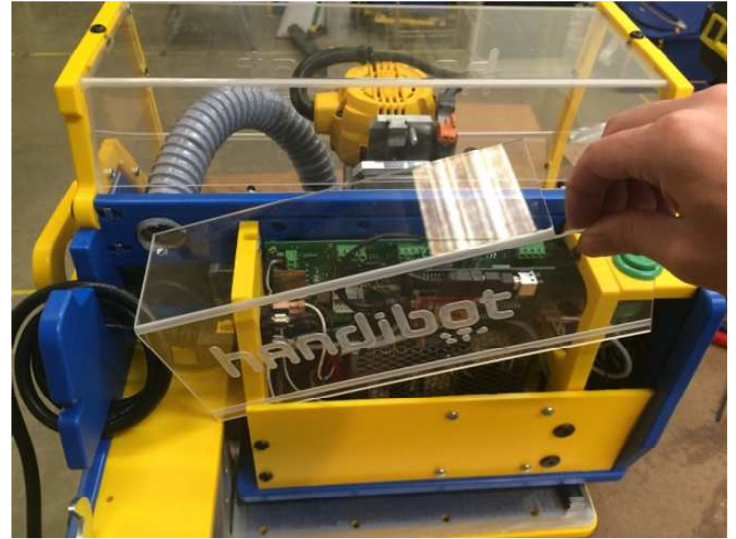
- 3 Remove the button head screw from the left, top side of the clear electronics enclosure.



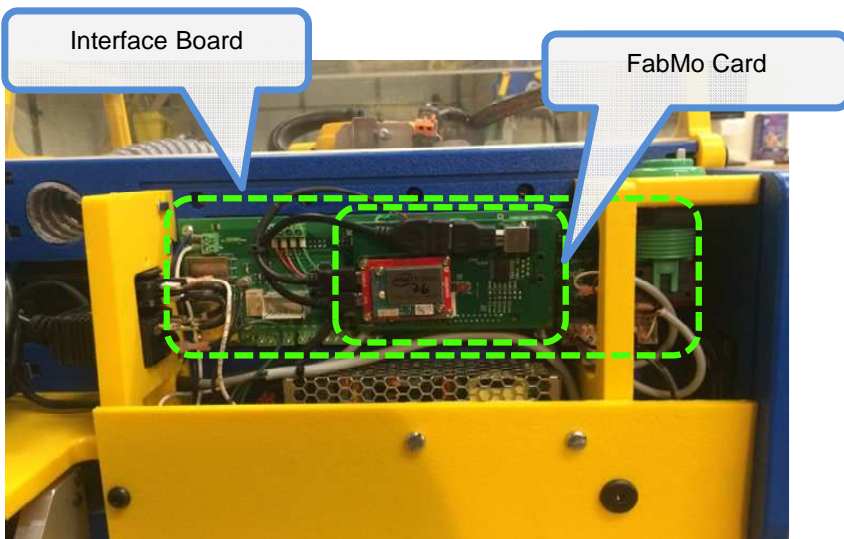
- 4 Slide the electronics enclosure to the left.



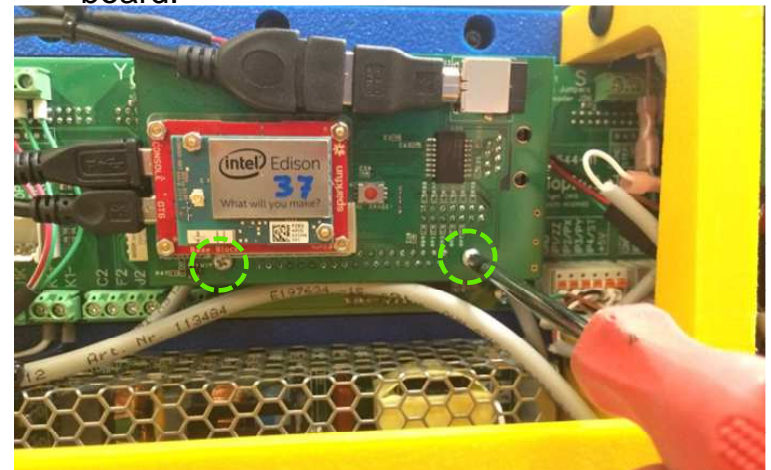
- 5 Pull the electronics enclosure away from the tool.



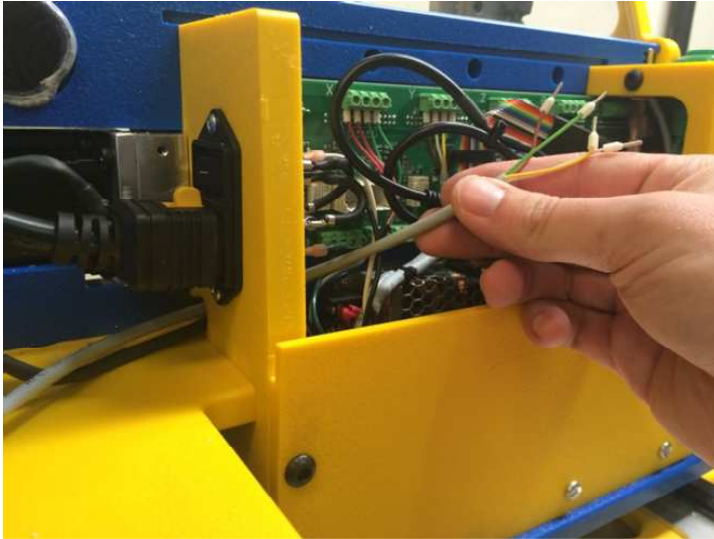
- 6 You now have access to the FabMo Control Card and Interface Board of your Handibot.



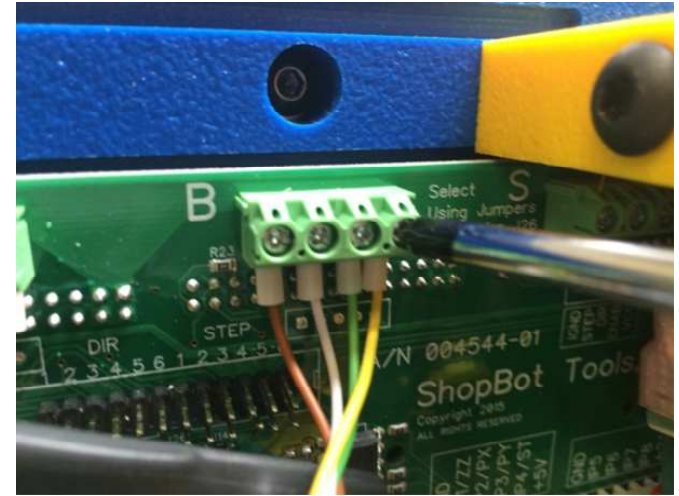
- 7 Older control cards will be held in place by two screws. Remove the two phillips head screws holding the FabMo control card in place. Gently pull the FabMo card off of the interface board.



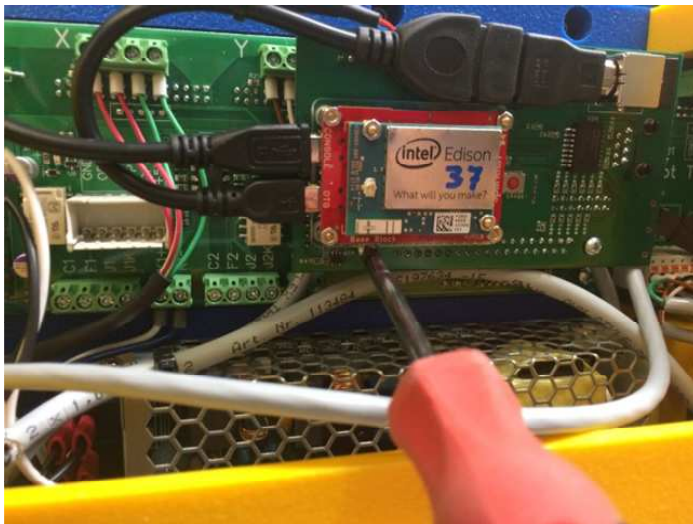
- 8** Pass the accessory motor cable through the hole in the left side of the electronics enclosure.



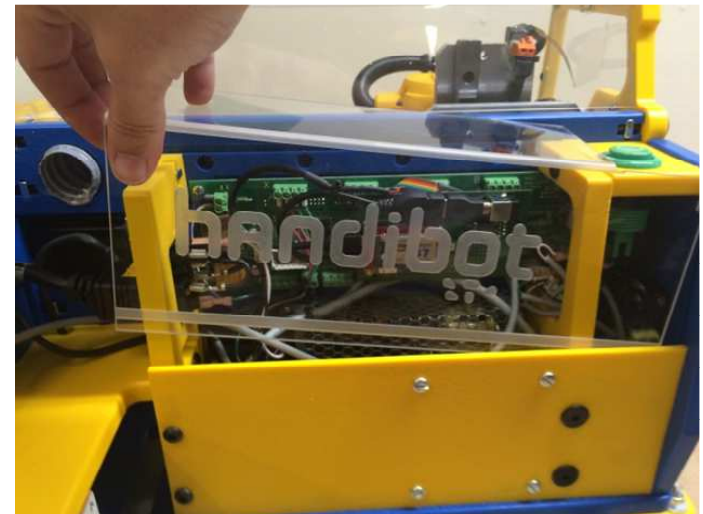
- 9** Screw the wires into the terminal block labeled "B". From left to right: Brown, White, Green and Yellow. Make sure that the wires are snug and do not pull out.



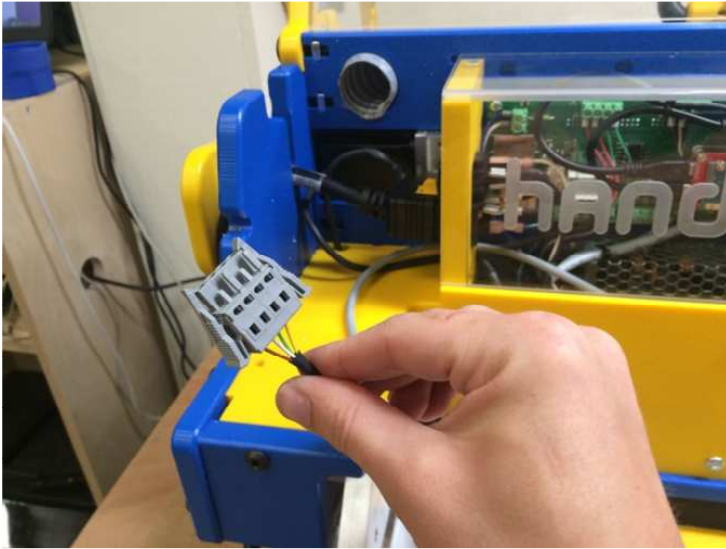
- 10** Re-attach the FabMo card with the two phillips head screws.



- 11** Replace electronics cover.



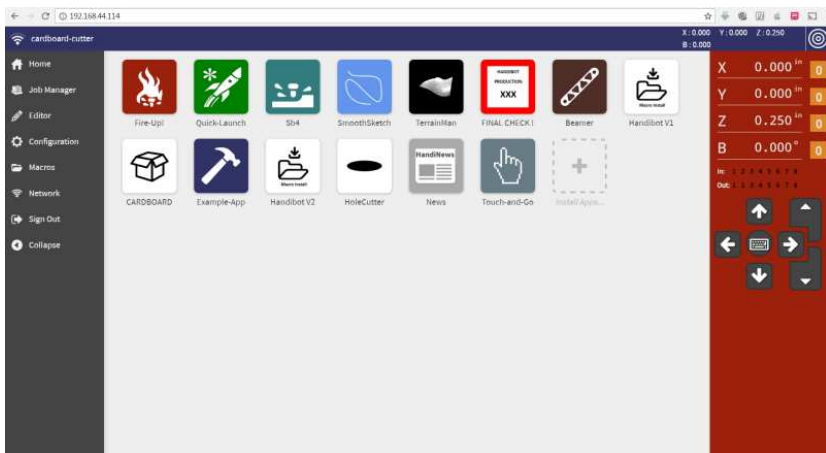
- 12 Plug grey WAGO connector into your accessory motor.



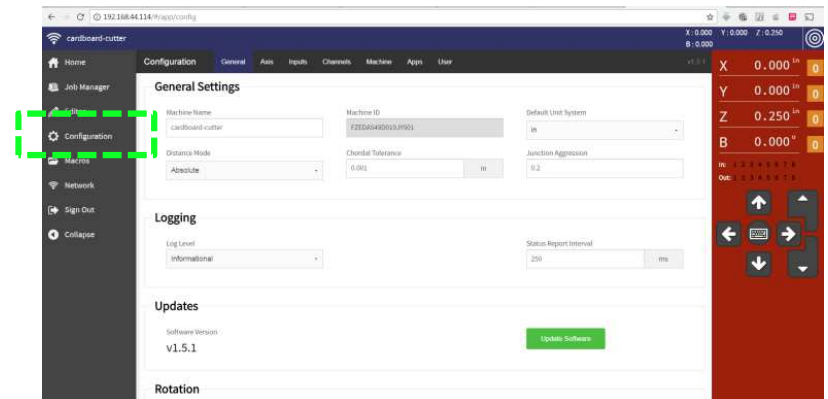
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Setting up a rotary axis in FabMo

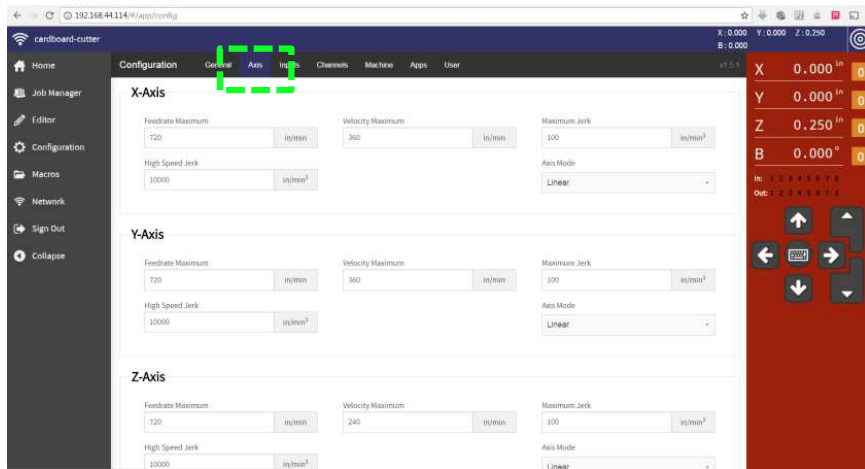
- 14 To use a rotary or any other 4th axis accessory with the handibot—you'll need to activate your auxiliary axis in FabMo.



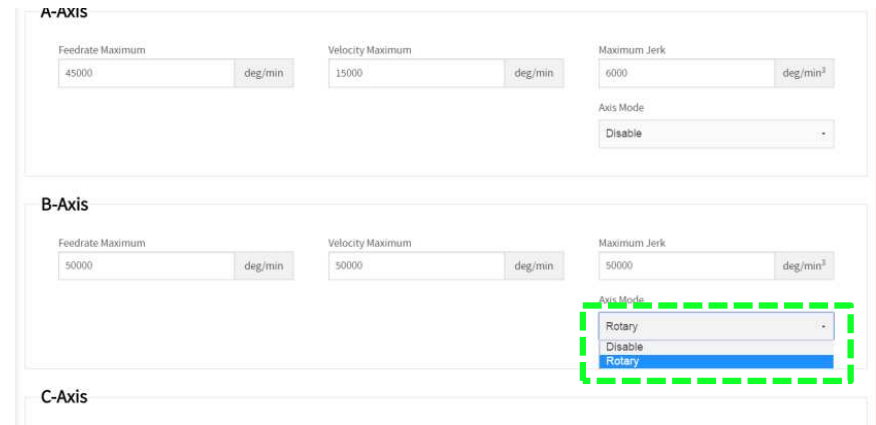
- 15 First, open the “Configuration” menu for your tool.



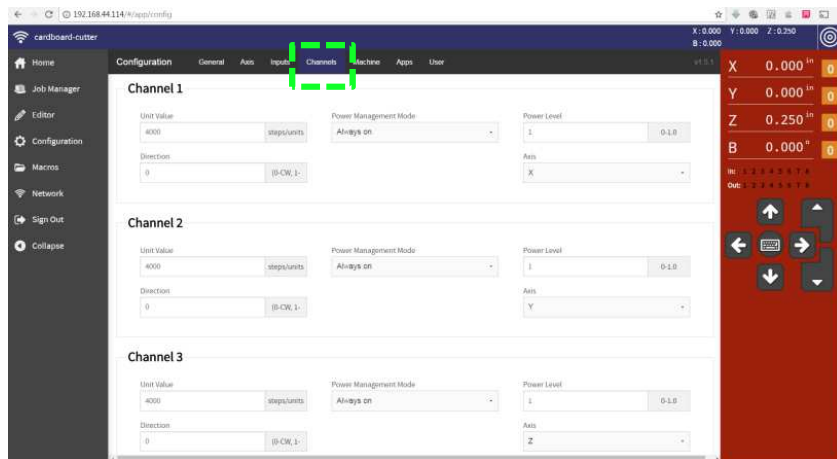
- 16** Switch over to the “Axis” tab. This tab lists the move speeds and type of each axis.



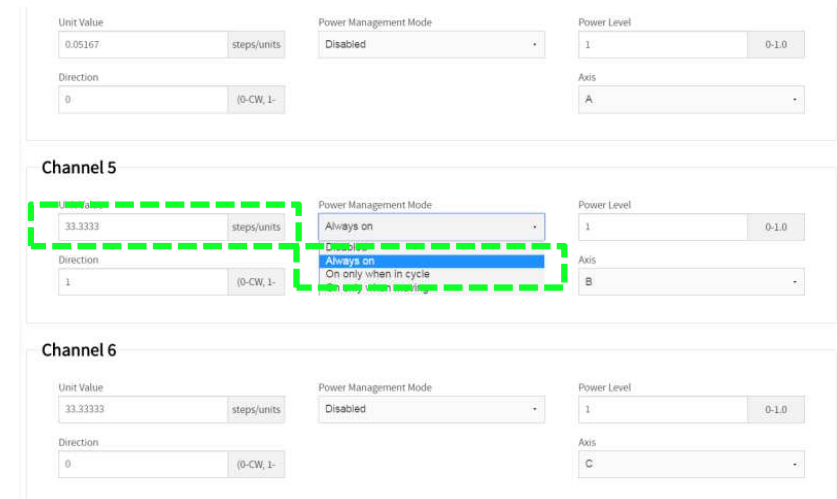
- 17** Scroll down to the B-Axis settings. In the “Axis Mode” pulldown—set the axis to “Rotary” mode.



- 18** Now, switch over to the “Channels” tab. This tab displays the controls for each of your tool’s motor driver channels.

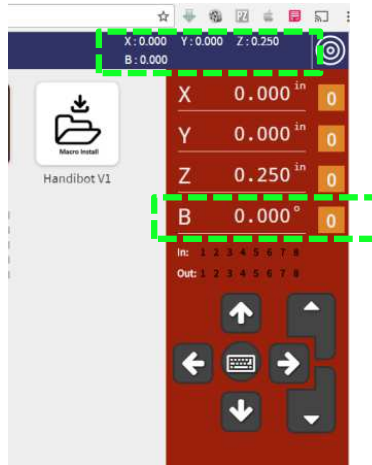


- 19** Scroll down to the listing for channel 5. Set the unit value of this channel to 33.3333—and the power management to “Always On”



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The positional readouts on your tool should now show a B axis location in degrees.



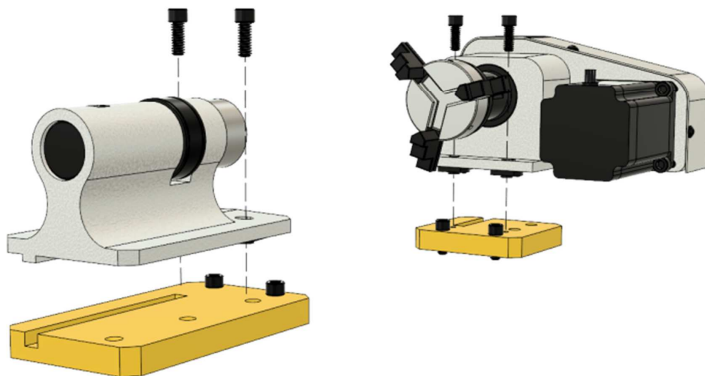
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Attaching the Rotary Axis to Your Handibot

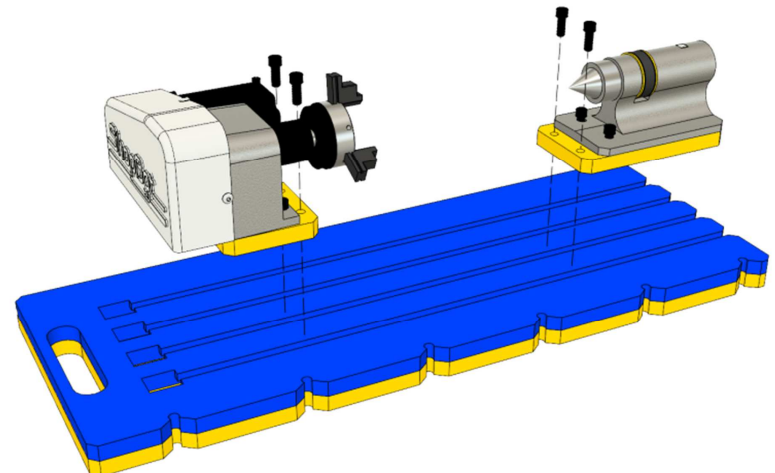
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Attach the headstock and tailstock to the riser blocks that were included with the Accessory Base.

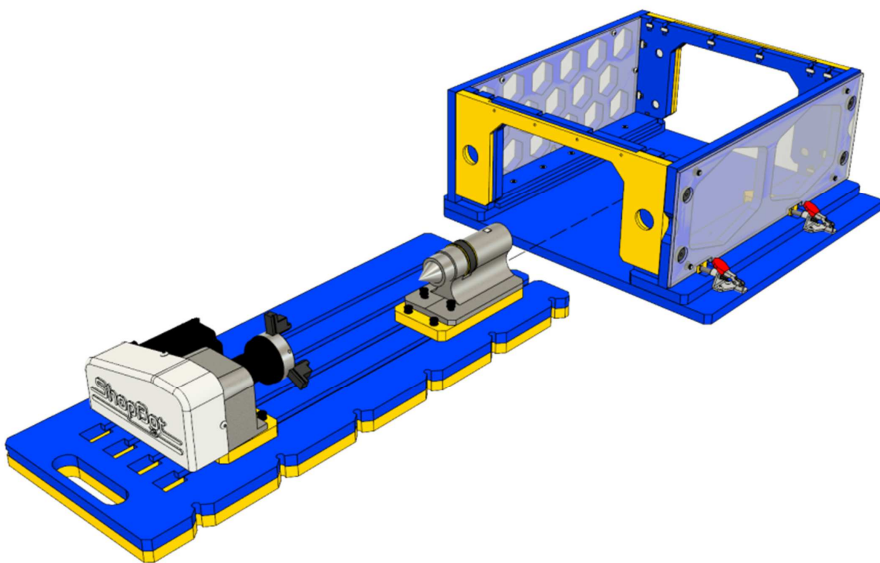


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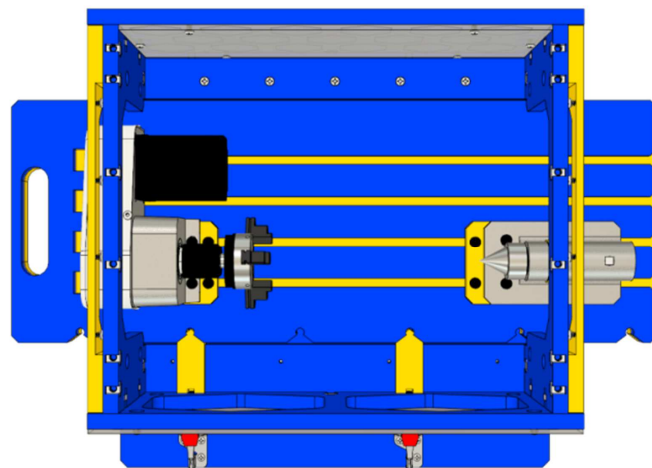
Bolt the headstock and tailstock to the T-slot tray.



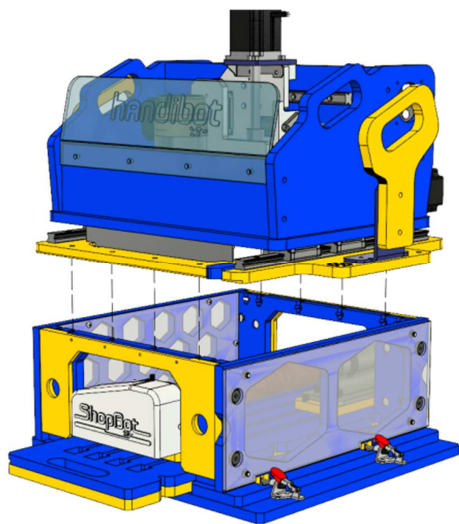
- 24** Slide the T-slot tray into the accessory base.



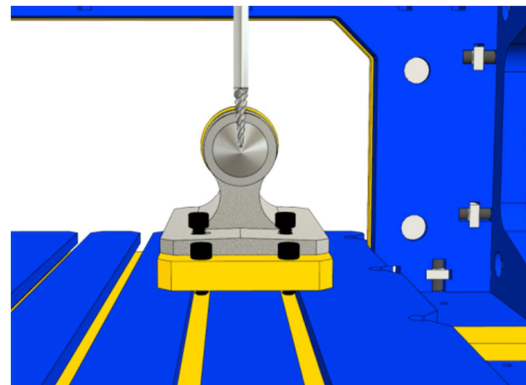
- 25** Lock the T-slot tray in place by depressing the two red toggle clamps on the side of the accessory base.



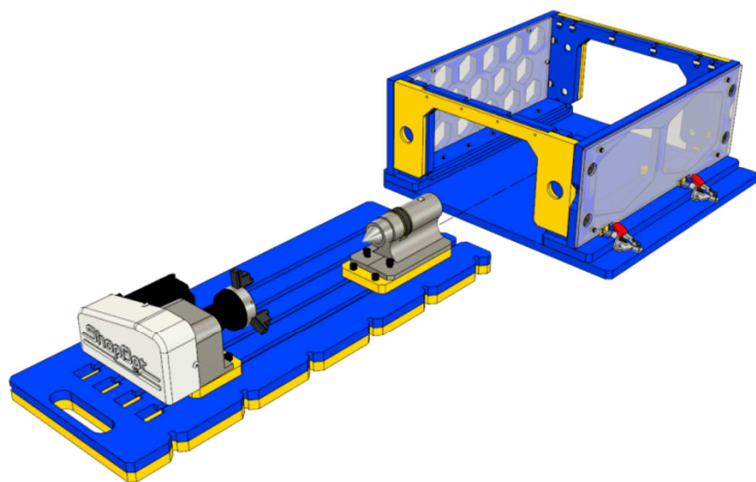
- 26** Attach the handibot to the accessory base using the 8 ¼-20 bolts that were packaged with the accessory base.



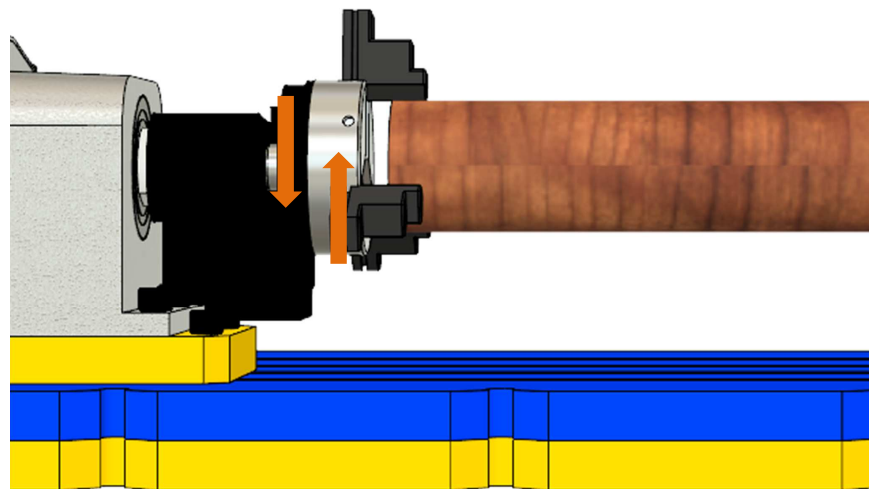
- 27** Insert a small-tipped bit, such as a v-bit, or ballnose bit into the router. Move the tool in all three axes until the tip of the bit is lined up with the pointed tip of the live center on the tailstock. This will be your home position—the center of the round stock that you'll be turning. Zero the X and Z axes here.



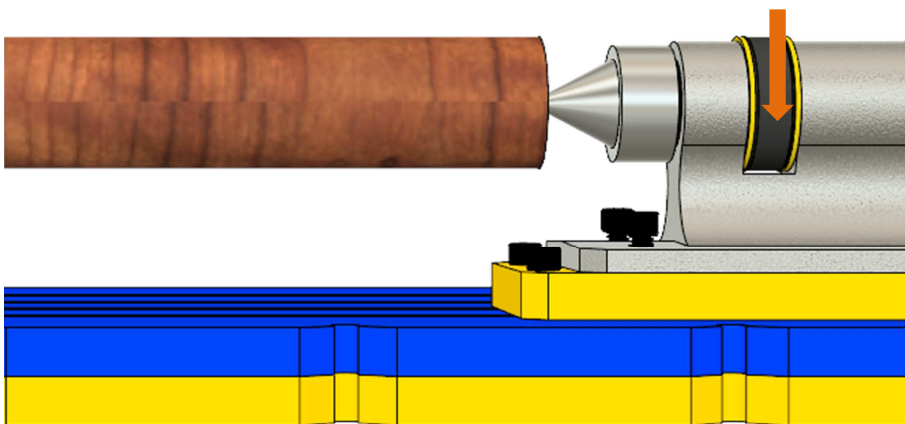
- 28** Release the toggle clamps to remove the tray in order to secure the material you wish to cut.



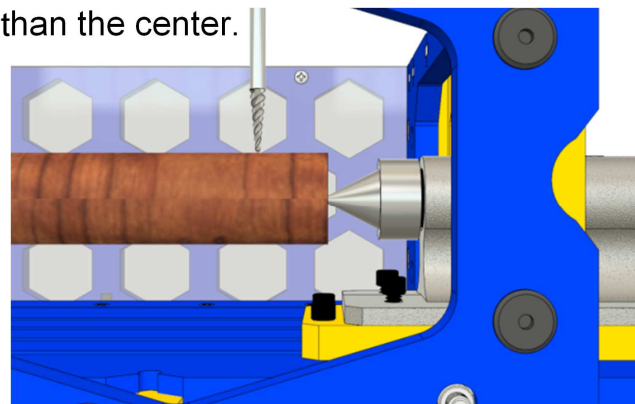
- 29** Rotate the hub of the headstock to open and close the jaws. Material should be held firmly by all three jaws of the chuck.



- 30** Rotate the collar on the tailstock to drive the live center into the center of your round stock.

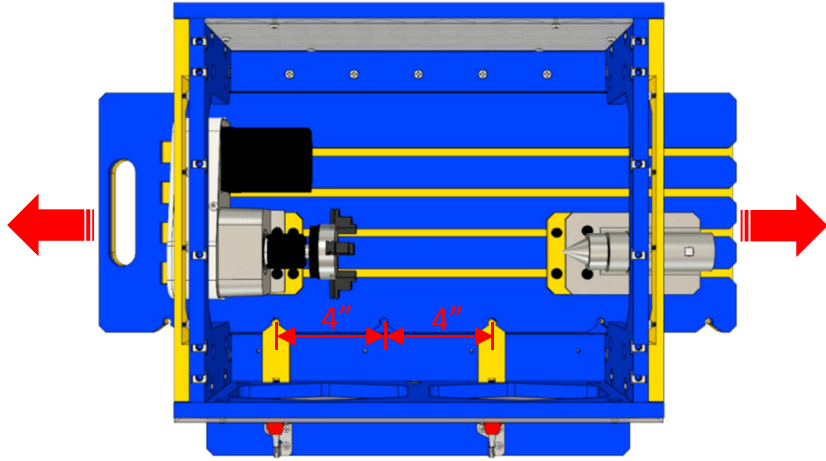


- 31** Slide the tray back into the accessory base. With the tool at X=0, enter the radius of your material into the Z position readout and press "Go". Verify that this moves the bit to your material surface. Depending on the way that you set up your rotary cut, you may need to zero the bit to the surface of the material rather than the center.



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To accomplish a “tiled” cut, release the red toggle clamps and shift the T-slot tray by 4 inches in either direction. Lock the clamps into the v-shaped grooves to precisely locate the work piece for your next cut.



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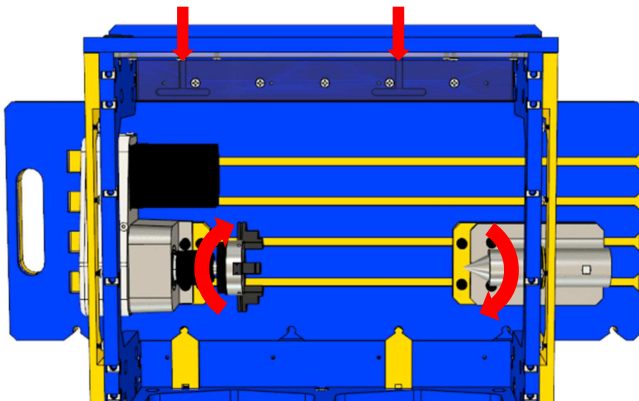
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Rotary Axis Troubleshooting

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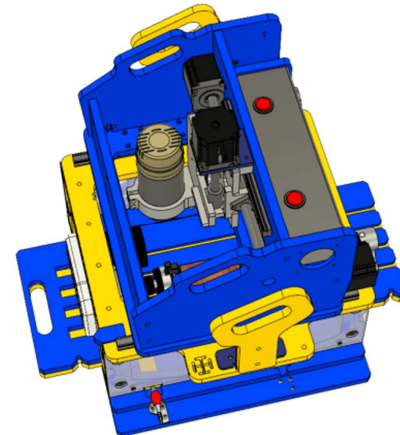
Problem: Material is not parallel to handibot y-axis.

Solution: Release toggle clamps, then adjust alignment screws on opposite side of frame to rotate the T-slot tray.



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Problem: Cutter doesn't reach material
Solution: Loosen router collar screws; lower router body until cutter can reach the center of your material when tool is at bottom of Z-axis travel.



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Problem: Tool not cutting deep enough

Solution: Verify that the material size in your cut file matches the actual material size exactly.

