

# Water-Jet Cutter

**This instruction set assumes that you have already cleaned your drawing, set the quality, added Lead In/Out paths, and created cut-paths before saving the ORD file.**

## Setup

1. Drag **ORD** file onto desktop of Water-Jet computer.
2. Double-click ORD file (opens OMAX **Make**).
3. Select **material** (usually mild steel).
4. Enter **thickness** (20Ga = 0.9mm, 16Ga = 1.6mm).
5. Right-click **Check for Collisions** and select **Heads Up**.
6. Click **Nest** if you want more than one copy of your part.
7. De-select all check boxes except for **Use Terrain Follower**.
8. Click on **Change Path Setup** to modify any of these parameters in the future.

## If Cutting Plastic

1. Click on **Change Path Setup**.
2. Select **ALL** check boxes.

## Operation

1. Add **grit** to hopper if level is low.
2. Click **Z1 Up** to raise **Z-Axis** so nozzle is above table side (Figure 1A).
3. Right-click **Go home** and select **Go to Load Home** (moves nozzle to top right).
4. Load **material** on table and secure.
5. Click **Go Home** (moves nozzle to bottom left).
6. Use **Shift-Arrow keys** and **Z1 Up/Down** to position nozzle  $\frac{3}{8}$ " above start position.
7. Raise **water** level **1-2"** above material (Figure 2B).
8. Turn **pump** on (black knob - Figure 3C).
9. Click **Begin Machining**.
10. **Clean up** after yourself.
  - a. Repeat steps 2 & 3
  - b. Remove part & material
  - c. Turn off pump
  - d. Close OMAX Make
  - e. Delete ORD file from desktop.

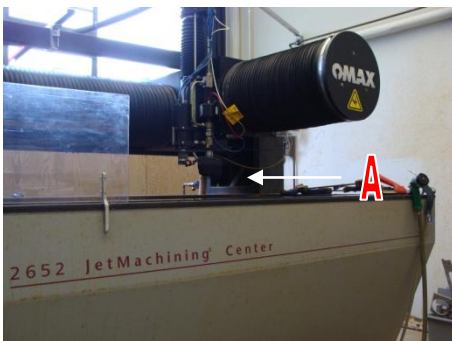


Figure 1: Nozzle Height

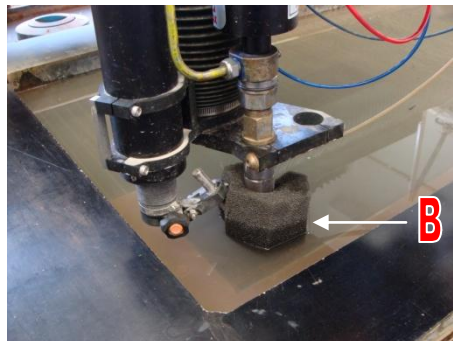


Figure 2: Water Level



Figure 3: Pump Switch