

Plot buffer/Plot item

Attempting to cut too deep in a single pass causes stress on the cutting tool and the machine. It is often the case, that a router or milling machine must make several passes over the material. With each pass, the cut depth is increased deeper into the material. You are given the choice between single or multiple pass cutting. In the example of “plot buff” on the last page, if you had responded with a “no”, the command line would have asked for the final depth of cut and the depth of each pass (incremental) cut.

```
Command:plotbuff on xytable, line_cnt 4
Yes - Cut to Depth 0.125000 - No to Repeat to Depth <N:Y>No
Enter Final Cut Depth <1.000>: .500
```

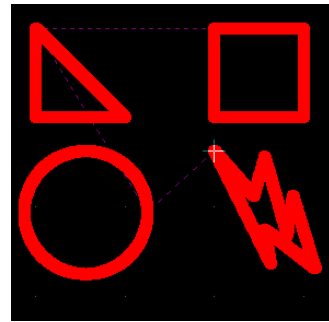
A “no” response causes the command line to ask for the final cut depth. Type and enter.

```
Enter Final Cut Depth <0.500>:
Enter Incremental Cut Size <0.010>: .100
PLOT OK <N:Y>? |
```



Next, it will ask for the cut depth of each pass cut. Type and enter.

In this example, the machine will go over the whole pattern 5 times, each time going one tenth of an inch deeper until the final depth of one half inch is achieved.



```
PLOTBUFF item 0 25 - line 4,4,5,4,5,3,4,3,4,40
PLOTCHAR Select Item <nxt:end>:
PLOTITEM PLOT OK <N:Y>? |
GRID
SNAP
```

The plot item command makes it possible to select a single item for cutting. The square is selected with the crosshair. The item turns red. Click the right button to end the selection. Right click to plot. Machine will start cutting.

