

## MAE Waterjet:

### Setting up Waterjet:

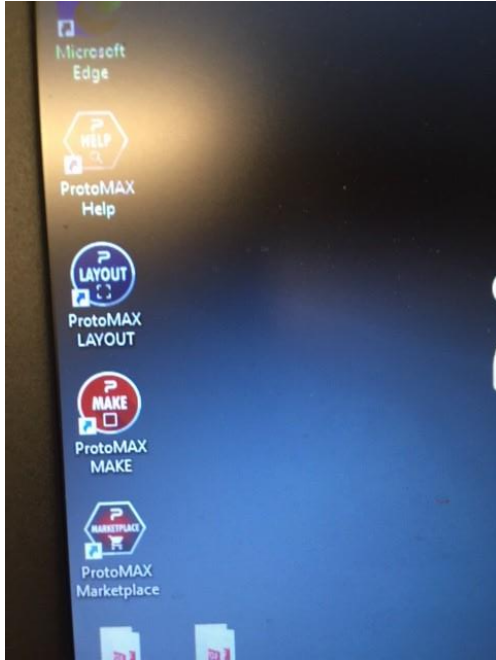
- A) If you need to create the cutting path please refer to the “Layout” guide.
  - B) If you have the cutting paths created in “layout” refer to the “Make” Guide.
  - C) If you are ready to set up the water jet follow the instructions below.
- 1) Turn on the water supply.



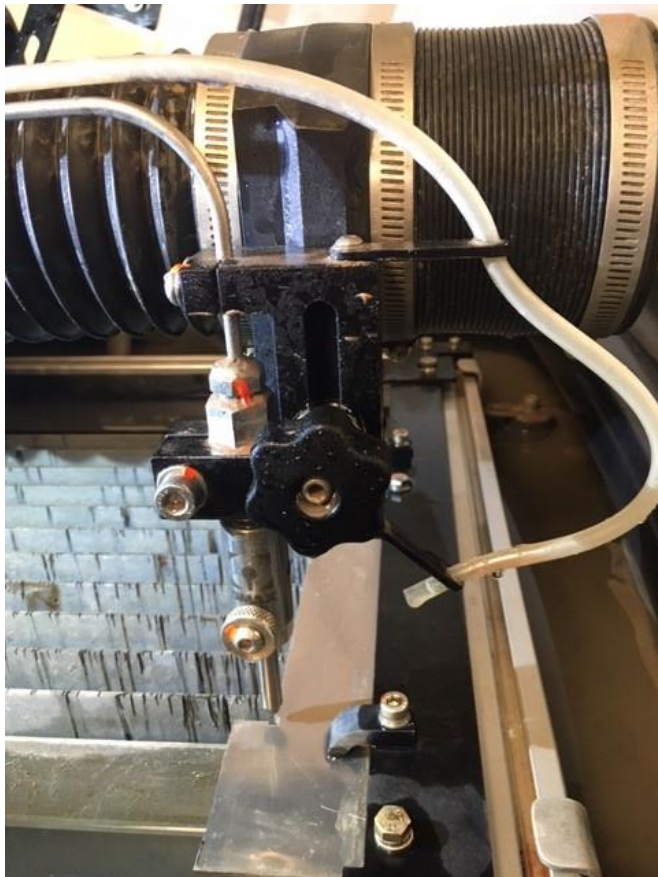
- 2) Turn on power to machine.



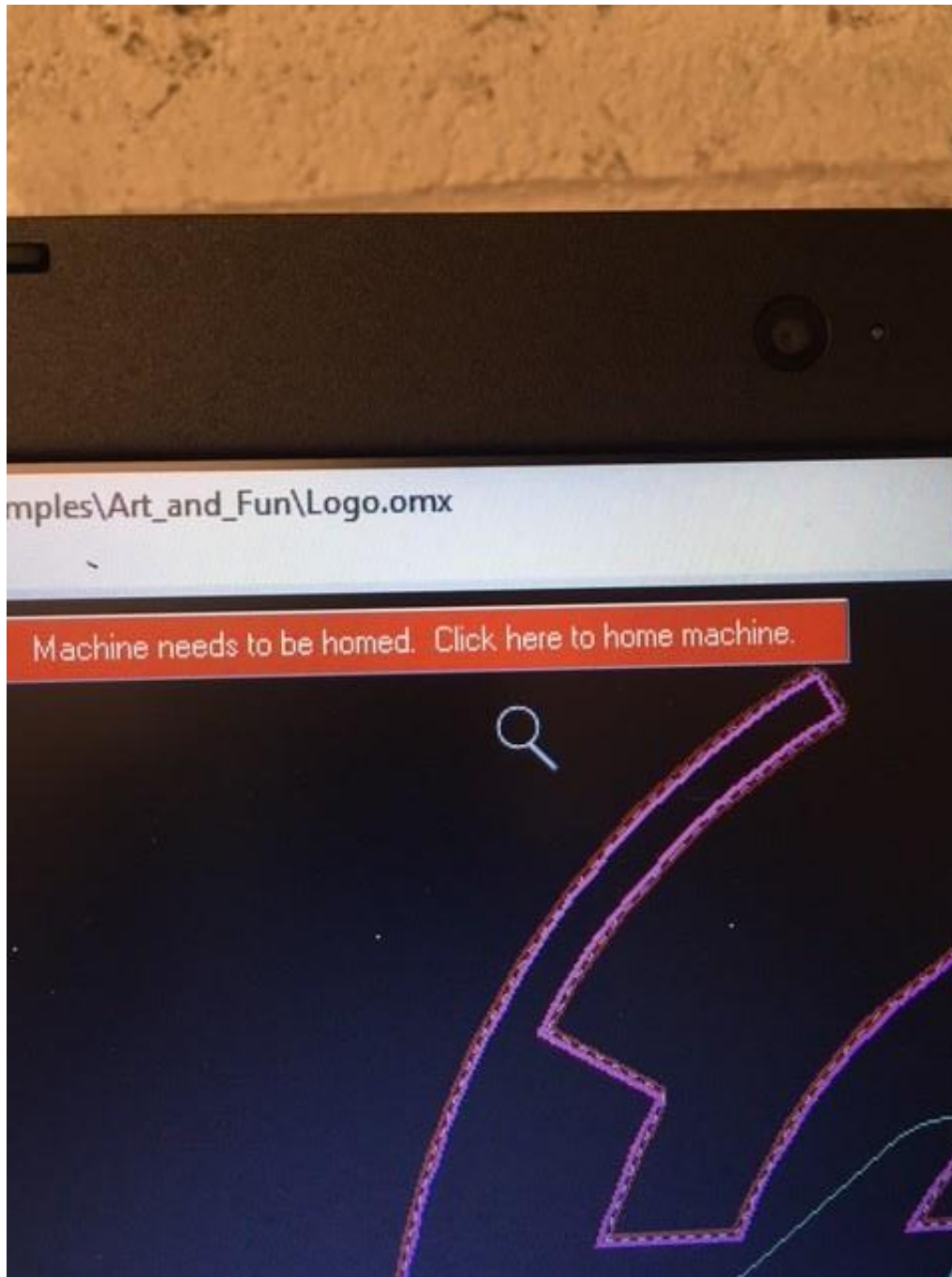
3) Turn on computer and open “Make” software.

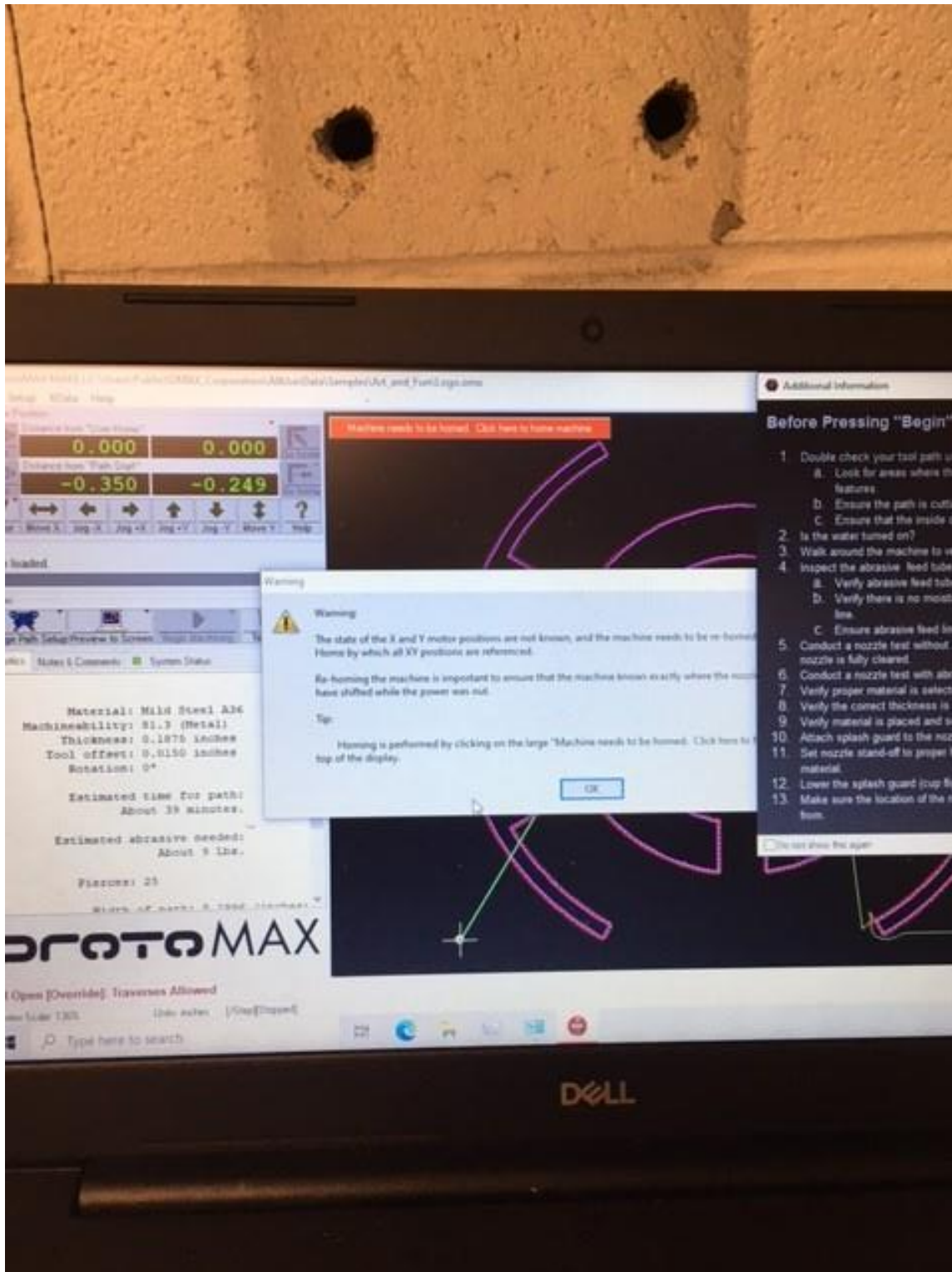


4) Remove abrasive tube from nozzle and pull away from hole. Raise nozzle.

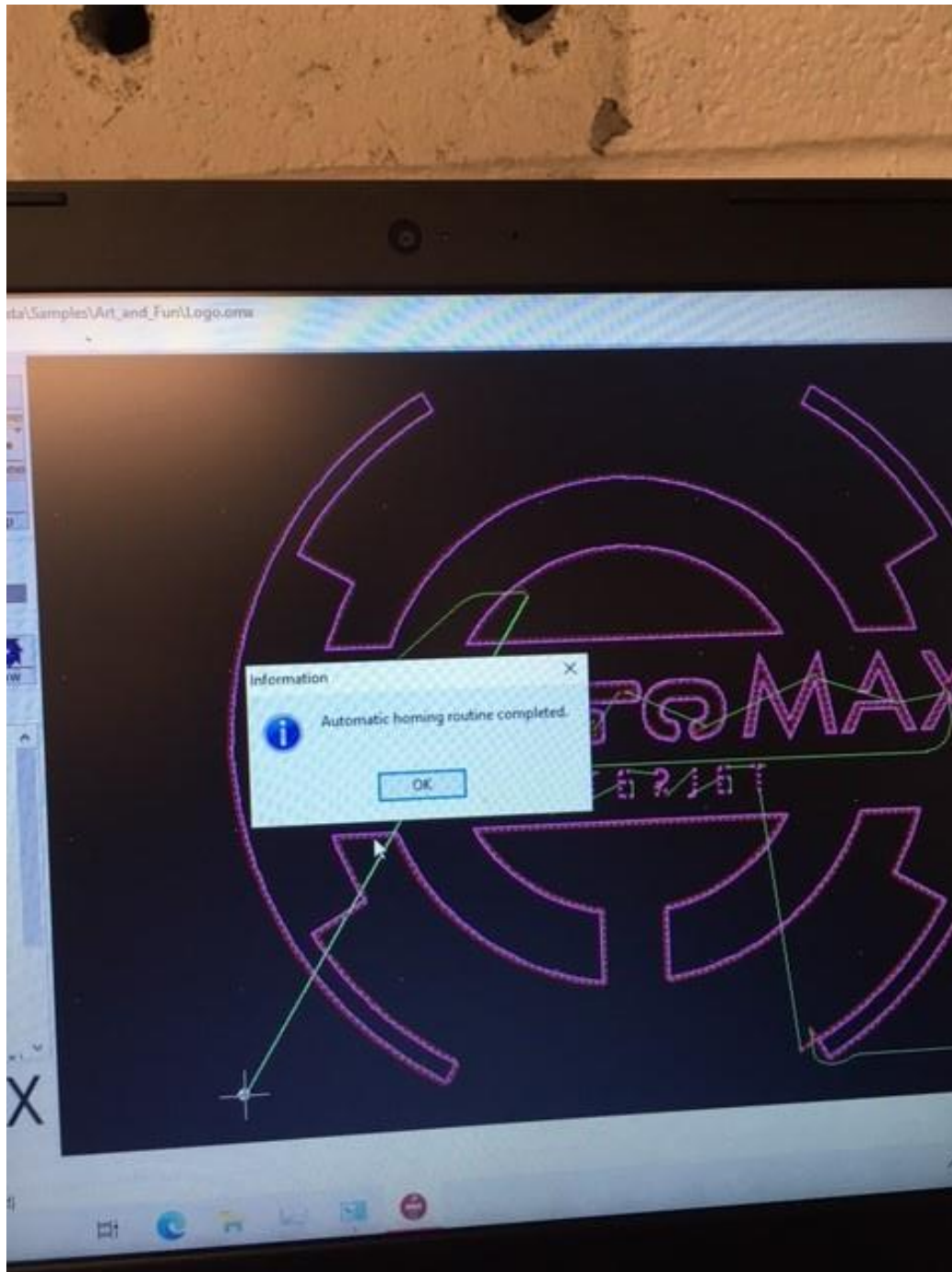


5) Home the machine. (make sure there is nothing in the way of nozzle)

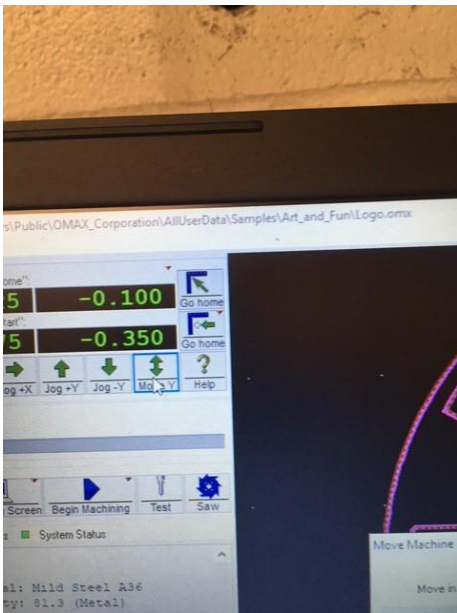
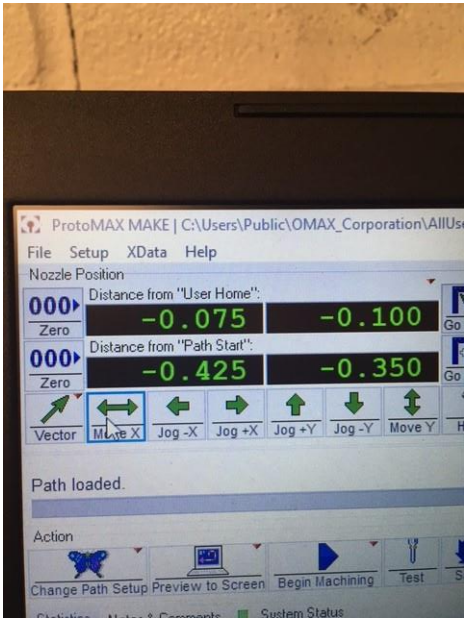








- 6) Move the X and Y axis to locate nozzle in between slats. (Usually X 1.000, Y 4.000)  
This is done by picking the Move X and Move Y button. Type in the Incremental value to move.





- 7) Close the lid on machine and pick the test button. This ensures that the nozzle is clear and the pump is running fine. Run full test of both pump and abrasive.

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3.900  
3.650

Go home  
Go home

Jog +Y Jog -Y Move Y Help

Begin Machining Test Saw

System Status

ild Steel A36  
1.3 (Metal)  
.1875 inches  
.0150 inches

Time for path:  
at 39 minutes.

Assive needed:  
About 9 Lbs.

25

Path: E 3004 (Alpha)

**OMAX**

**Test Operations**

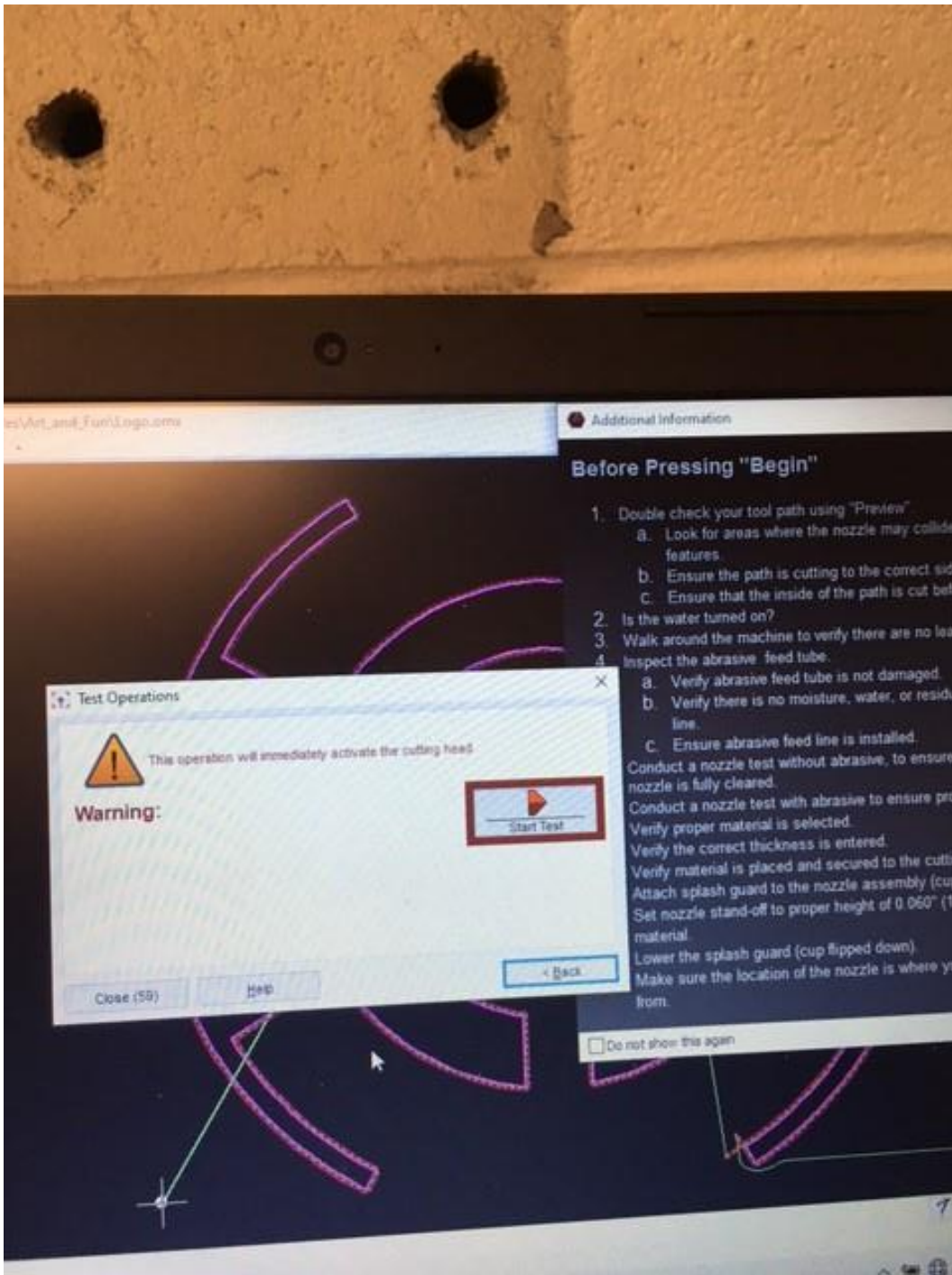
Select which option to perform

- Test Cutting Head (Pump, Jet, and Abrasive)
- Flush plumbing
- Reset Pump

Activates the cutting head for 60 seconds for operational testing.

Close Help Next





- 8) After test is run, replace the abrasive tube and position the nozzle over your material.

- 9) Lower the nozzle to the part with gauge in between nozzle and material, secure clamp.



- 10) Fill abrasive hopper with Garnet.



11) Position the material in desired location and clamp. (Two clamps preferably, one shown)



12) IMPORTANT!! Move the axis to the exact start position and set part zero.



13) Fill machine with water from sink to ¼" above material.



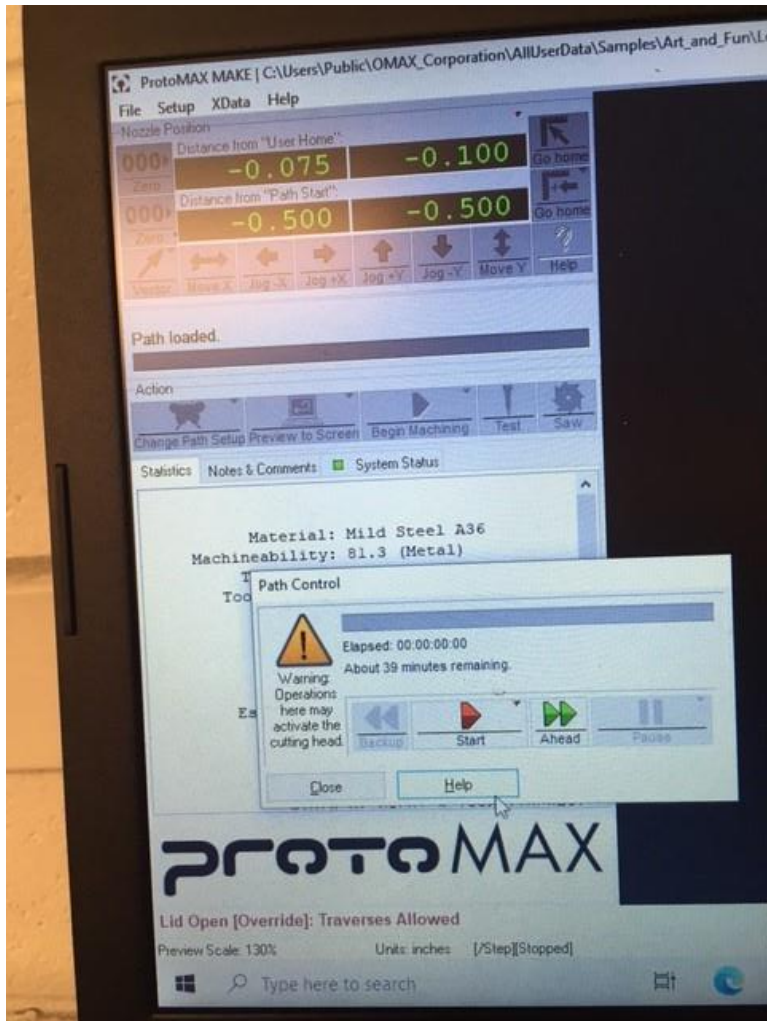
14) Position the overflow to start flowing at above this water level.



15) Pick Begin machining and then Start.

(You can hit Pause if you need to move the drain hose or check on something)  
Simply hit resume to restart.





16) After your job is finished you must clean machine, Purge and remove clamps.

17) Start by removing all of your materials and clamps.

18) Dry off clamps and put away.

19) Lower water level by submerging the drain tube a few inches.

20) Remove and pull away abrasive tube from nozzle.

21) Move X and Y axis to in between slats.

22) Run full test as before.



- 23) Using sprayer rinse all abrasive from machine.
- 24) Remove side trays by loosening thumb screws and dump used abrasive into trash pail provided.



- 25) Clean out trays and replace.
- 26) Do a final rinse and close lid.
- 27) Turn off water supply and power.