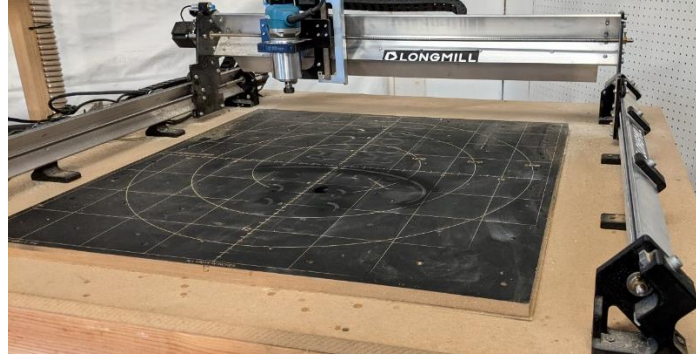# IDC WOODCRAFT

LONGMILL 30X30 BREAK-IN CYCLE

G-CODE & INSTRUCTIONS

Please read this entire instruction set before running this project

Hello Fellow CNC'er!

I'm Garrett Fromme with IDC Woodcraft. Congrats on getting your Longmill 30x30 CNC router.

As a journeyman CNC machinist, one of the things we knew was important when a new machine arrived, was to run it through a break-in cycle to get all the components 'settled in'.

This is just as important for your Longmill CNC machine.

Another benefit to this practice is so you can get familiar with your machine. So take the time to do this step before running projects.

You have downloaded a simple file that will cycle your Longmill 30x30 along the X, Y & Z axis for about a half hour to break it in.

Once the cycle is complete, clean any debris and check all moving parts to make sure they are tight. If not, tighten them up.

This file will run on any CNC software. If your software cannot read it, simply change the extension that your software requires.

IDC WOODCRAFT

BEFORE YOU BEGIN

- Double check your assembly to make sure they are tight.
- Make sure to remove the dust shoe bracket before running this program
- Make sure your you have moved all axis of your router using the gSender control software (or whatever control software you use).
- Make sure nothing is in the way of the machine travel along all axis.
- If you have limit switches or sensors, remove them
- Remove any bits
- Put a small amount of light 3-in-1 oil on the screws

WHAT TO EXPECT

- While running, each axis will move back and forth many times across the entire distance of the machine
- Sometimes, the machine may make a slight vibrating noise while breaking in. Just put a little more oil on the screws.
  - The noise will settle as the machine breaks in
- You may hear music type sounds as the machine moves around. This is normal.
- The tracks the rollers ride on will have some debris from the V-wheels when the cycle is complete. This is normal…the wheels are breaking in. Simply wipe it off.

WHEN THE CYCLE IS COMPLETE

- Check all wheels and other moving parts to make sure they are still tight.
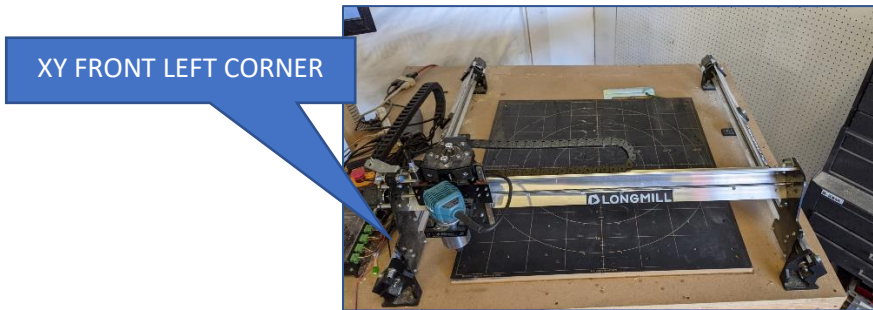- Adjust as necessary

IF YOU WANT TO MAKE A SPOILBOARD FOR YOUR LONGMILL 30x30, CLICK HERE FOR A VIDEO THAT EXPLAINS HOW TO DO THIS.
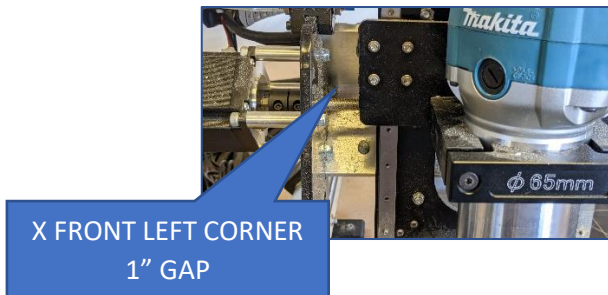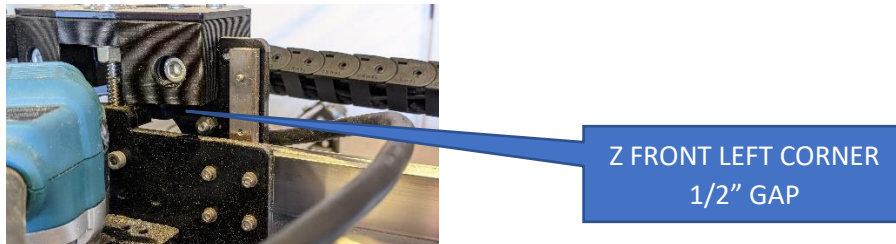
IDC WOODCRAFT

GET YOUR LONGMILL IN POSITION

Move the X and Y to the front left corner (toward you).

XY FRONT LEFT CORNER

Leave about 1" distance between the ends of travel.

X FRONT LEFT CORNER
1" GAP

Y FRONT LEFT CORNER
1" GAP

Move the Z to about ½" from the upper limit.

Z FRONT LEFT CORNER
1/2" GAP

Set XYZ zero here

You are ready

Install the G-code program titled "Longmill 30x30 CNC Router Break In Cycle"

Start the program

The program will run for about 30 minutes

When it is finished, your Longmill has been broken in.