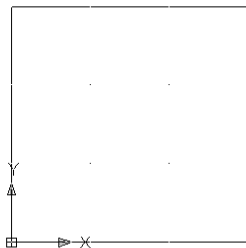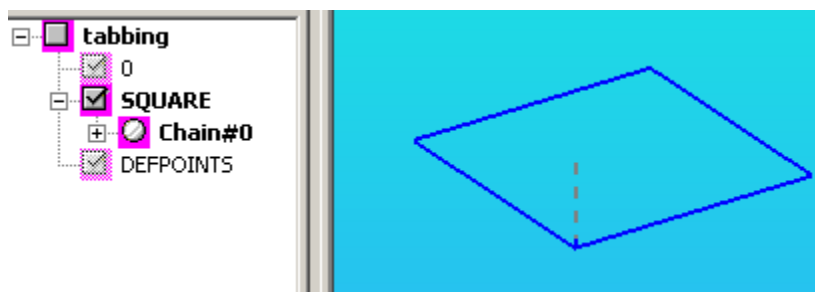## TUTORIAL #8 - LAZYCAM TABBING

This is just a quick tutorial on the tabbing function. Tabbing is defined as providing a number of cut slots around a profile. To show the process a simple profile was used. No testing was done to see the effects on different profiles.

Here are the basic steps:
1. A 4" square was drawn in CAD and put on a specific layer, the drawingwas saved as a ver 12 DXF, and imported into LC.
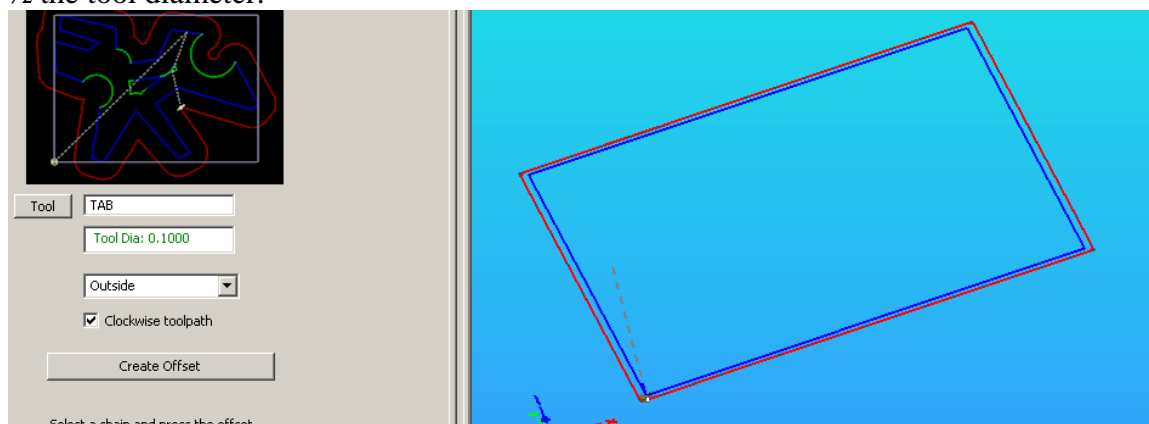


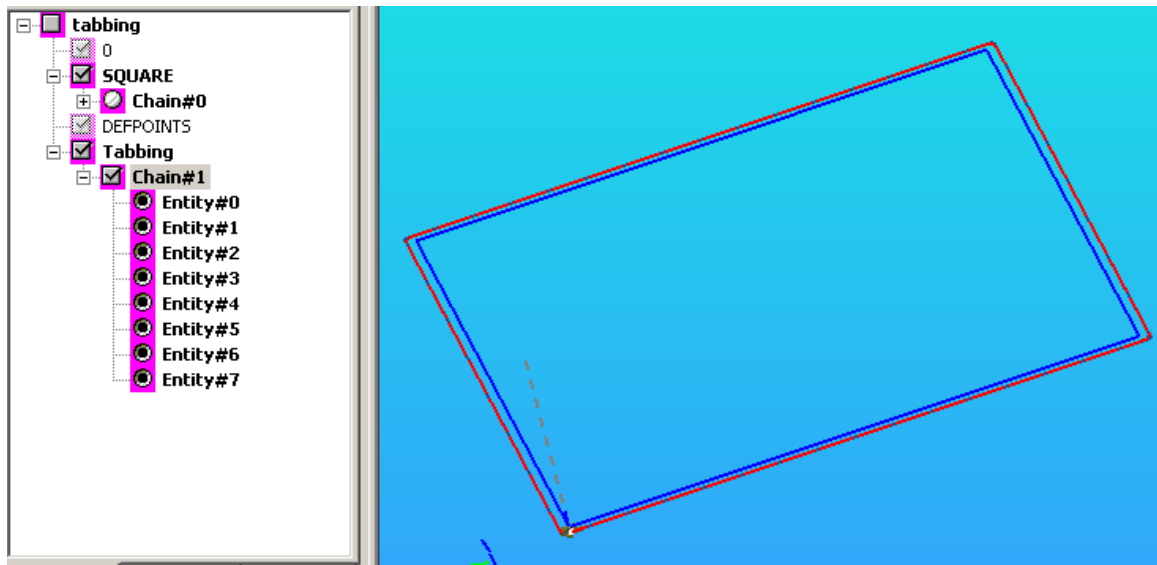2. The drawing was imported into LC, mill module selected, then cleaned.



3.Seems like in order to tab you need to make an offset of the profile. You are going to machine slots around the profile, ie; mill into the material some distance and for some length and retract Z back up etc, etc.
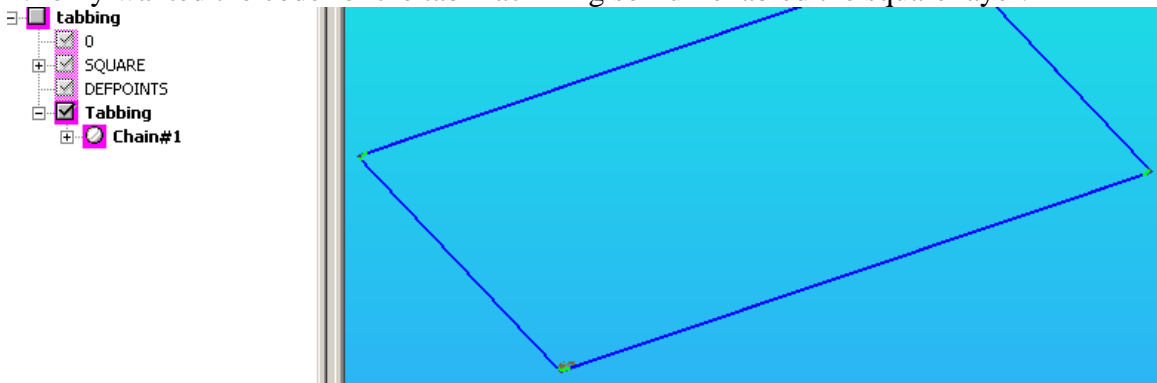So an offset was made based on a defined tool diameter. The tabbing offset is equal to ½ the tool diameter.

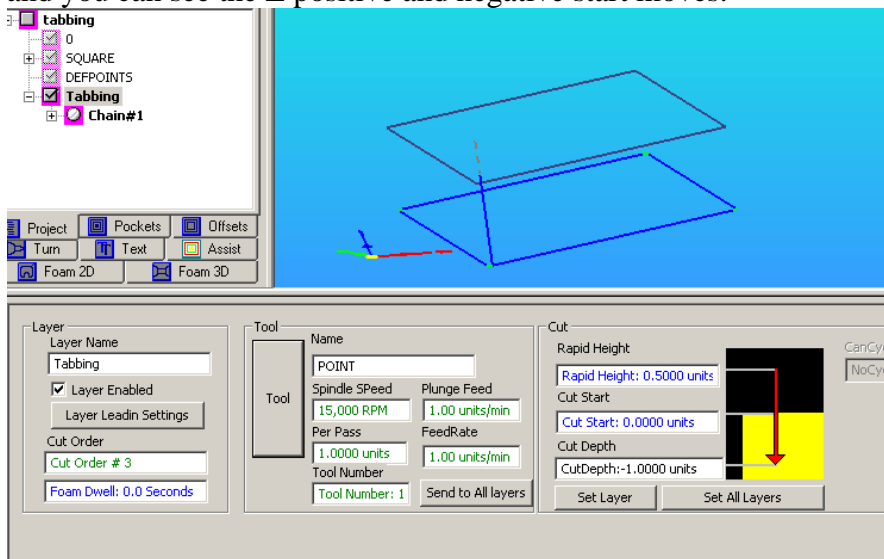

LC creates another chain and I changed the layer name to Tabbing.

4.I only wanted the code for the tab machining so I un-enabled the square layer.
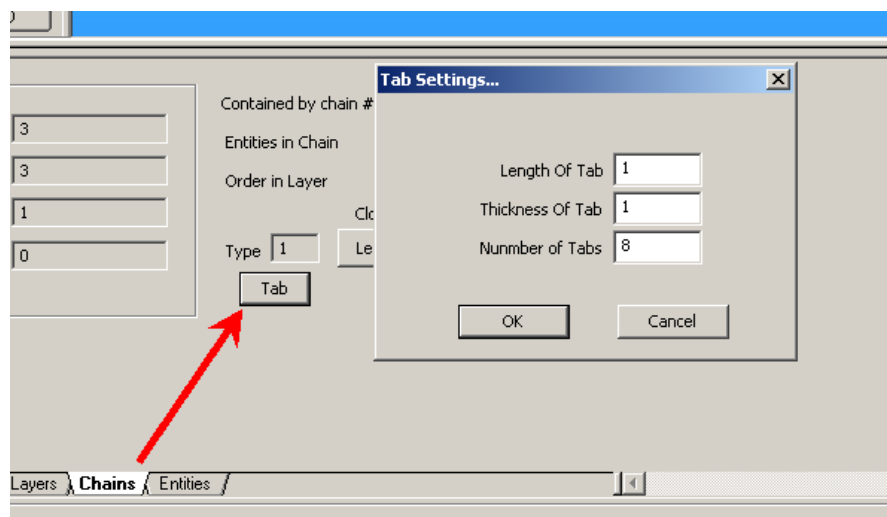


5.Now you will need to define to LC the tool you are going to use for machining the tabbing and apply it to the layer. LC creates the path for the tabbing as shown below and you can see the Z positive and negative start moves.

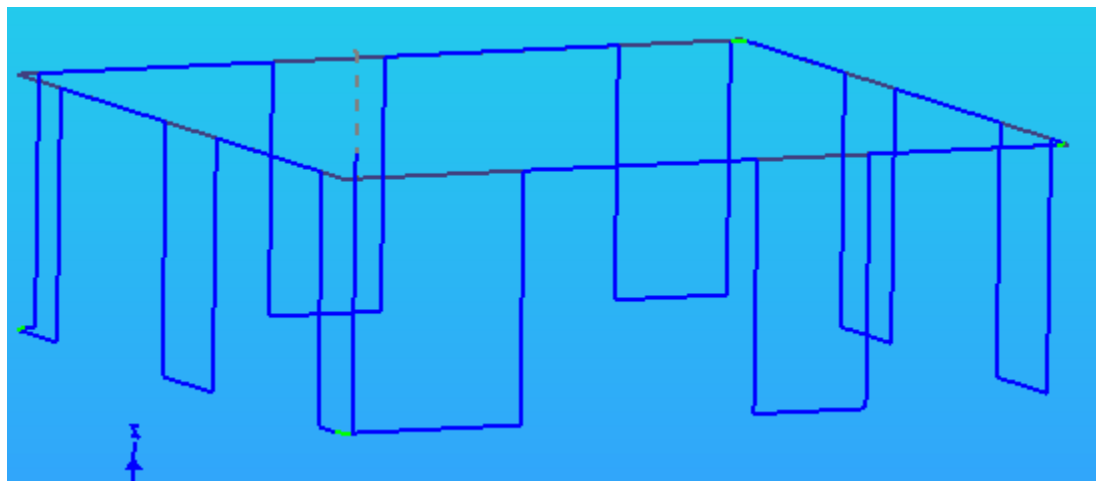6. Now LC will need to know how you want the tabbing done.
You simply select the tabbing chain, define the tool and cutting to be done, click the Chain tab, and input the tabbing information.
LC will <u>try</u> to provide a total of 8 tabs, 1" in length such that a slot will be cut into the surface for 1" and skipped for 1". **NOT SO!** The total linear path is 16" ( 4" square).
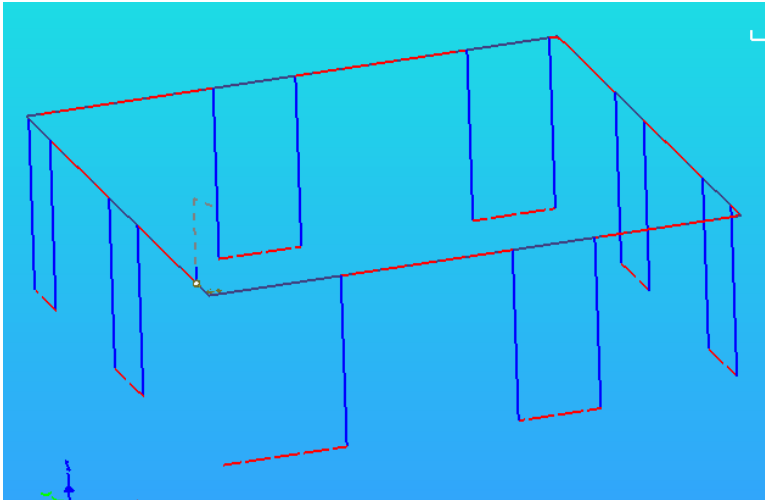


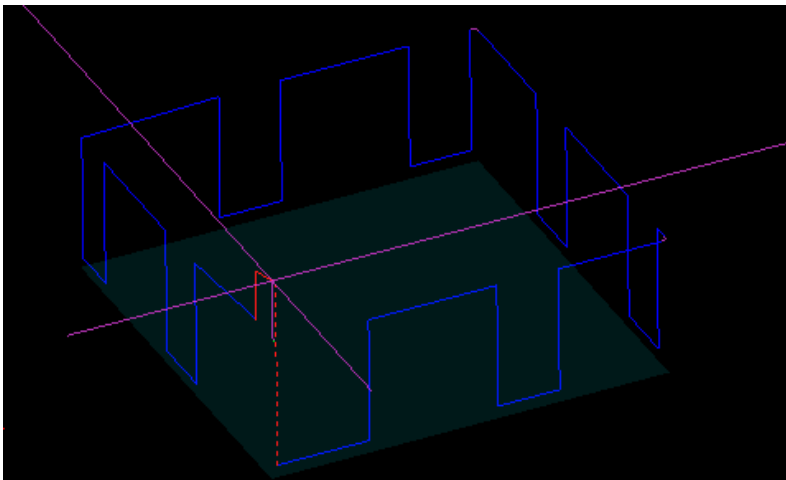LC created 8 chains from the starting point as shown below.
Since I don't like the tabbing occurring around the corners, I just will delete some of the tabbing elements from the chain.

Here is a screen shot after deleting some of the tabbing / elements.



7. Post the code to Mach. Here is the tabbing based on the LC's created Gcode. Tool travel is up and down and along the surface to machine the tabs.



Not bad for the price …….

If you want to do it manually just create the tabbing in CAD and assign the tool and associated cutting parameters to the appropriate CAD layer in LC.

I strongly suggest you have a read of the manual for anything not understood in this Tutorial. I would consider it a more advanced use of LC.

Have Fun….,

RICH