MEKANIKA

ADVANCED SPOILERBOARD KIT

HOW TO FACE THE BOARDS AND PLACE THE INSERTS

This documentation will guide you step by step to surface your spoilerboard and to correctly place the threaded inserts.

Before starting, download the kit content on our support page and verify that you've received everything.

This written tutorial is organized in three chapters:

1. Facing the spoilerboard

2. Drilling the holes for the inserts

3. Placing the inserts
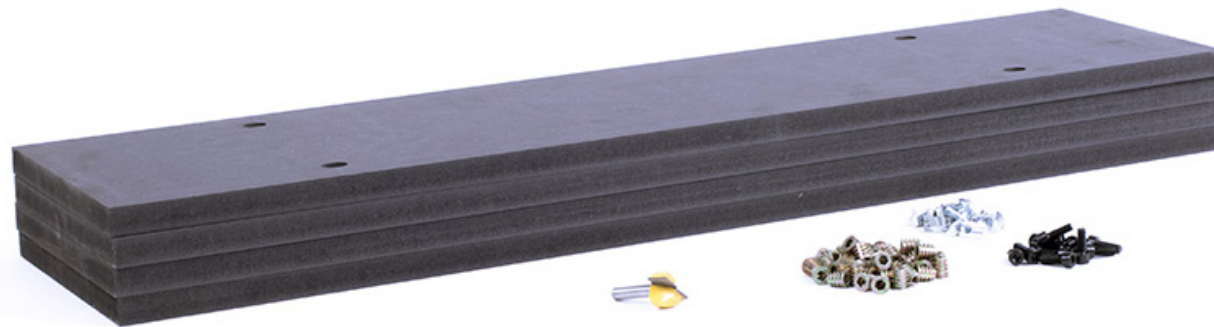
*If you haven't attached the boards on the machine yet, please refer to the document available on our support download page, or to the [last chapter of the mounting video of EVO](#).
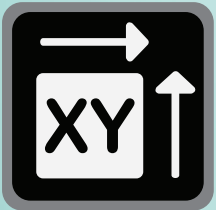
STEP #01 : HOMING THE MACHINE

1. Switch on the control unit of the CNC router
2. Press the **"Home"** button
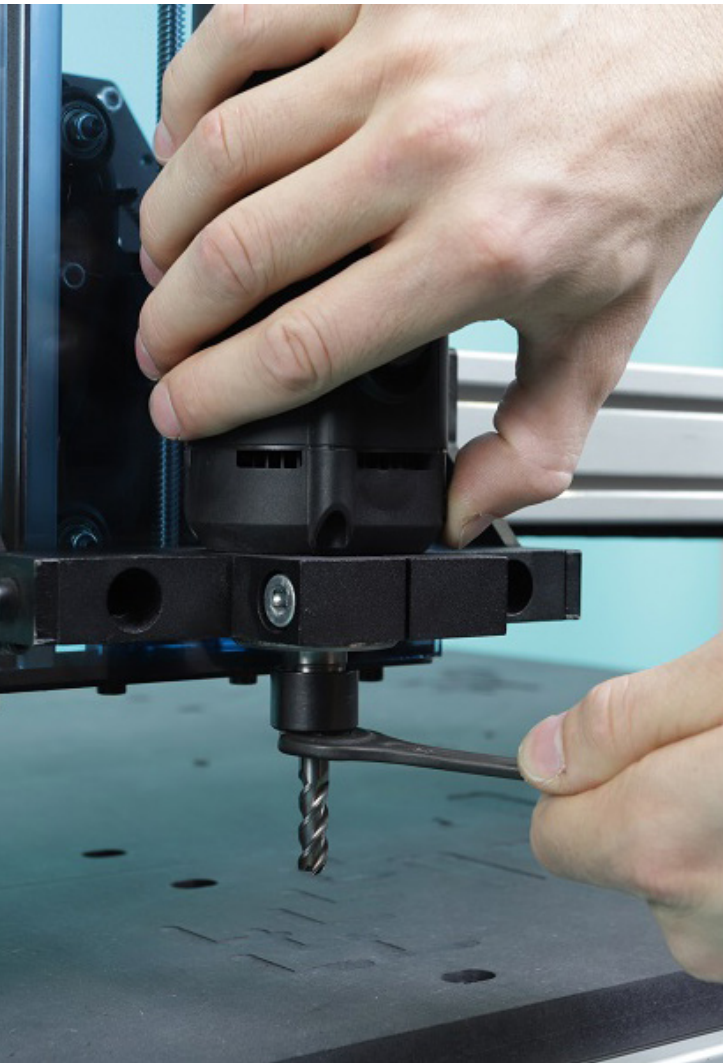
1. Press the **"XY"** button to define the current position as the X0 Y0 working coordinates
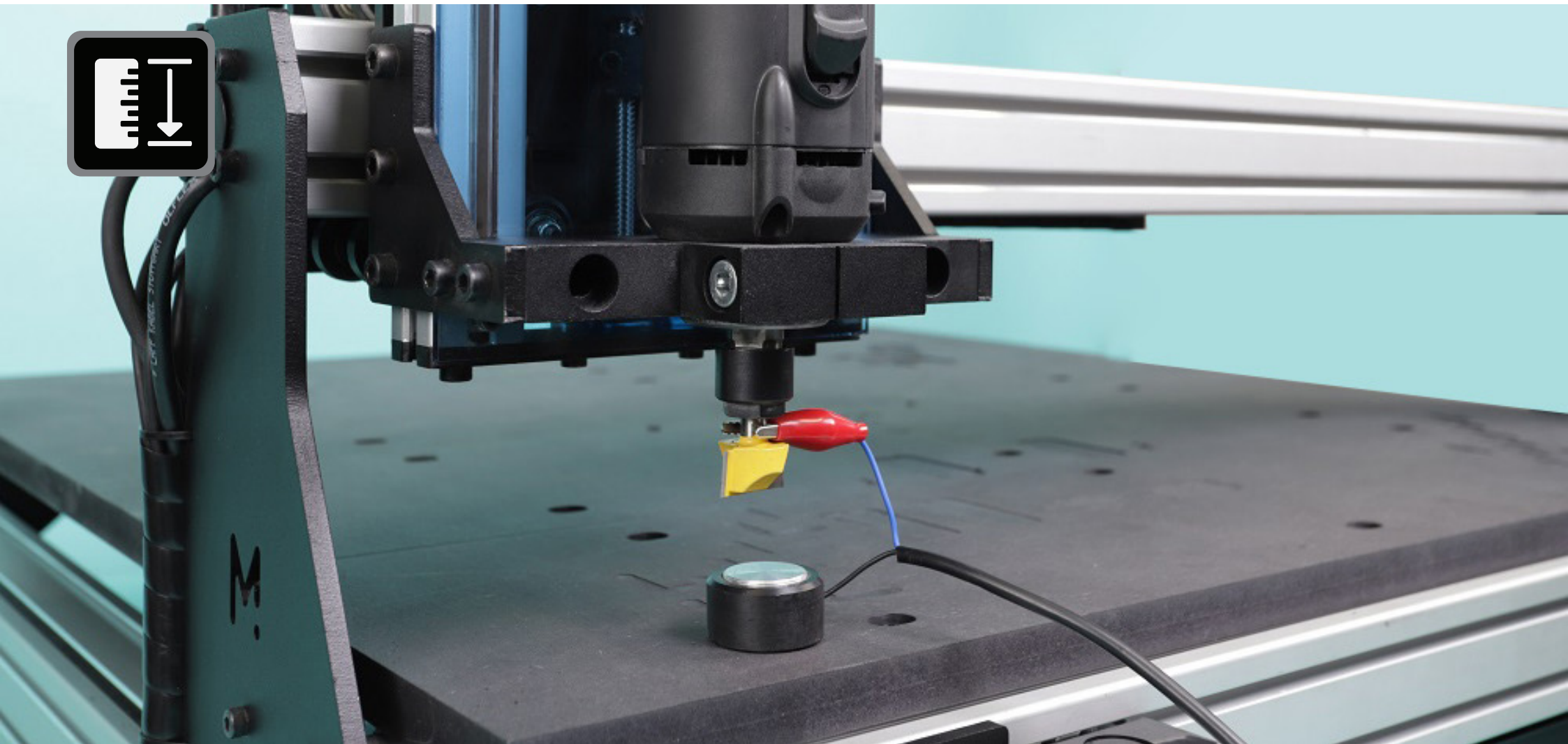
STEP #03 : CHANGING THE ENDMILL

1. Remove the endmill in place
2. Place the **8mm collet** inside the clamping nut and **insert the 25mm endmill**
3. Tighten the clamping nut with the spanner

STEP #04 : MEASURING THE TOOL LENGTH

1. Place the crocodile clip on the endmill shaft
2. Place the probing device underneath the endmill
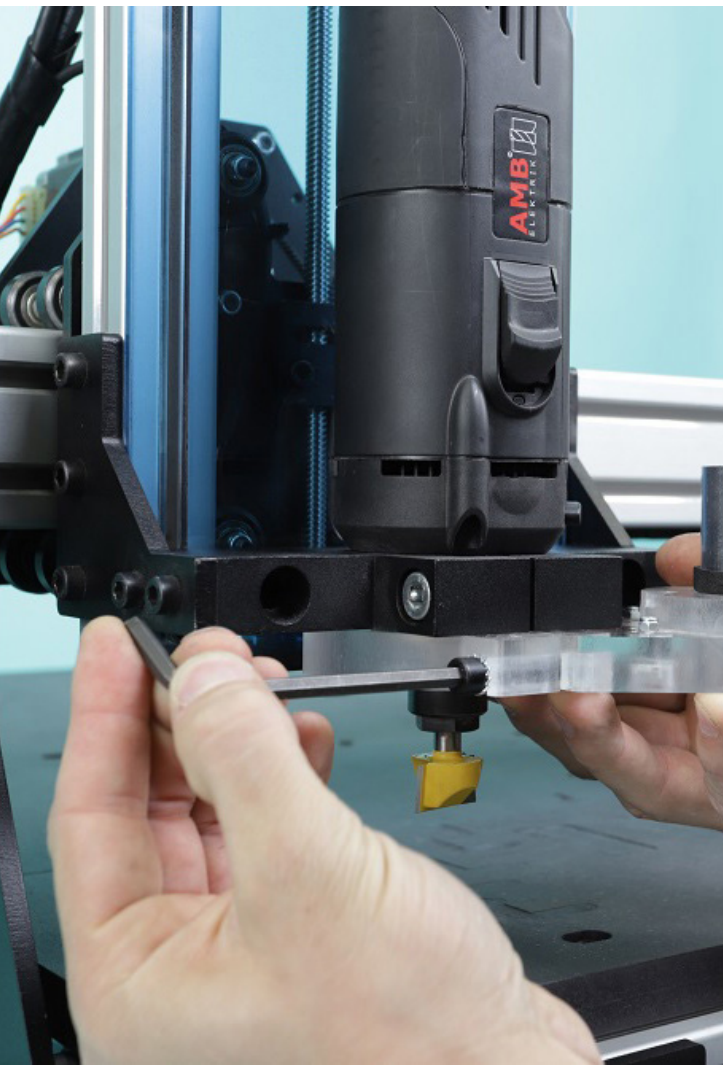3. Press on the **"Tool measure length"** button

STEP #05 : INSTALLING THE DUST SHOE

For this facing operation we highly recommend placing the Mekanika Dust shoe.

To install it properly, please refer to the relevant documentation on our support page.

**DO NOT SWITCH ON THE SPINDLE BEFORE INSTALLING THE DUST SHOE SHOE**

1. Download the **Surfacing and Drilling G-codes** on our support page

2. Load them on your control unit with a USB key or using the Shared folder of the Raspberry Pi

3. Press the **"Open G-code"** button

4. Open the **"Facing - Endmill 25"** that corresponds to your Evo model (S, M or L).

1. Set the rotation speed on **"6"**

2. **Switch on the spindle**
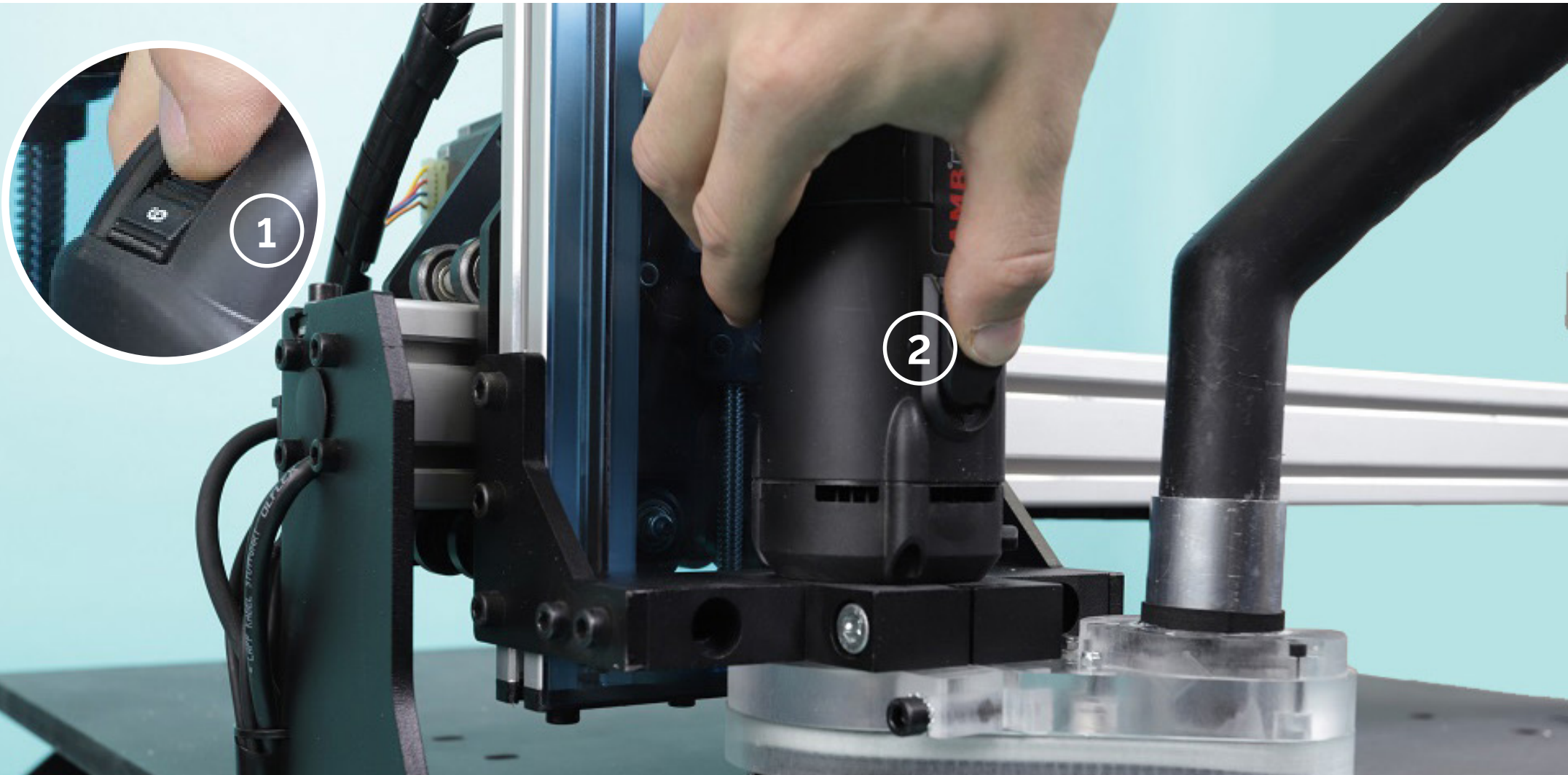
1. FACING THE BOARDS

1. Press the **"Play"** button

WEAR SOME SECURITY GLASSES AND EAR PROTECTIONS
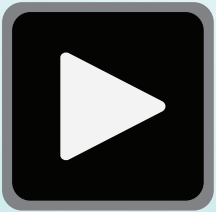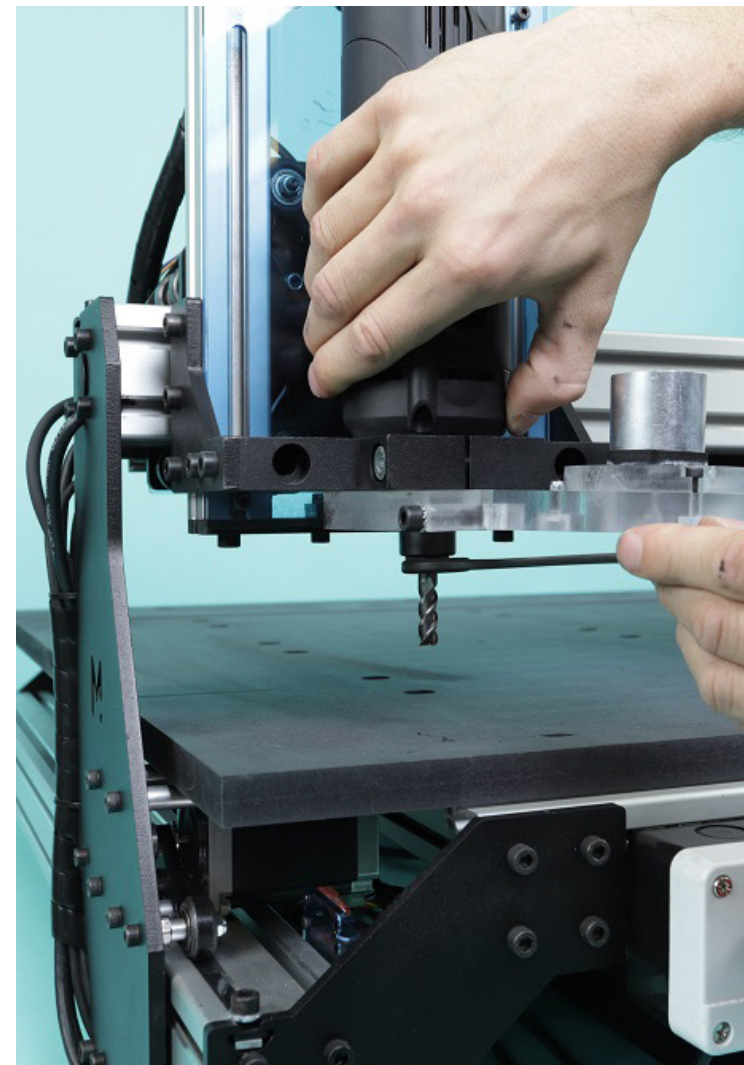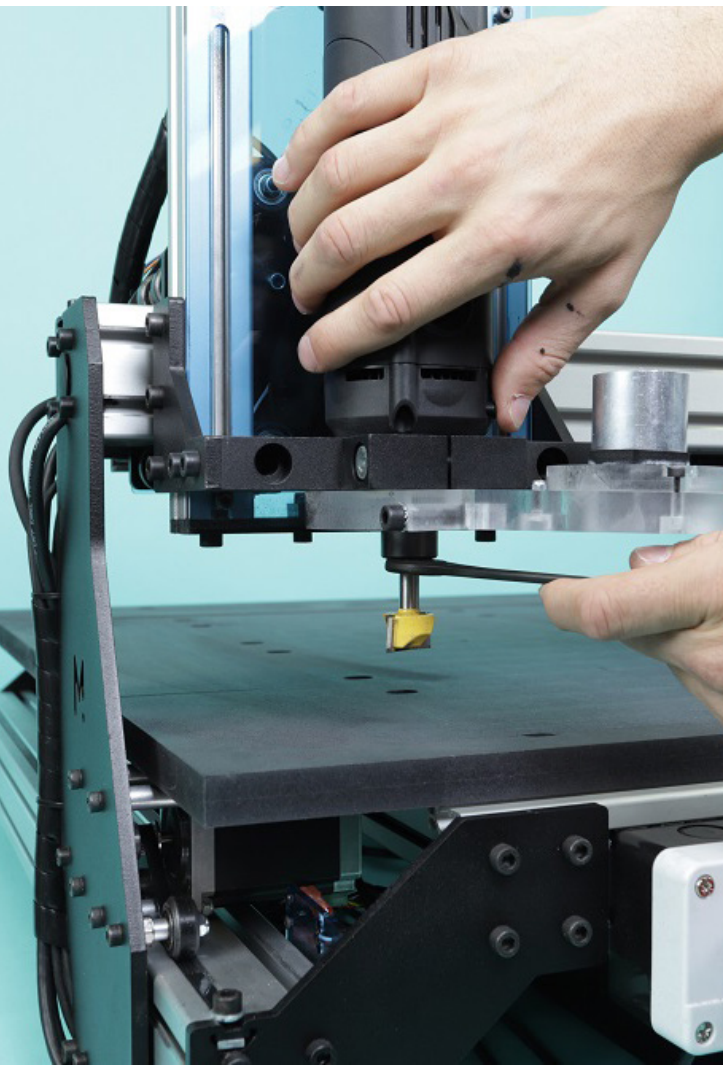
1. FACING THE BOARDS

1. Once the work is finished, press the **"Stop"** button

2. Switch off the spindle

3. Bring the machine to the front with the **"Y- arrow"** button

4. If the spoilerboard hasn't been milled over its entire surface, go back to **STEP #05** to make a new tool measure length on the milled surface and repeat the operation with the same G-code.
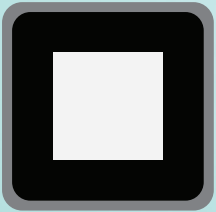
STEP #01 : CHANGING THE ENDMILL

1. Remove the 25mm endmill
2. Place the **8mm endmill** and let it **stick out of 25mm** at least.

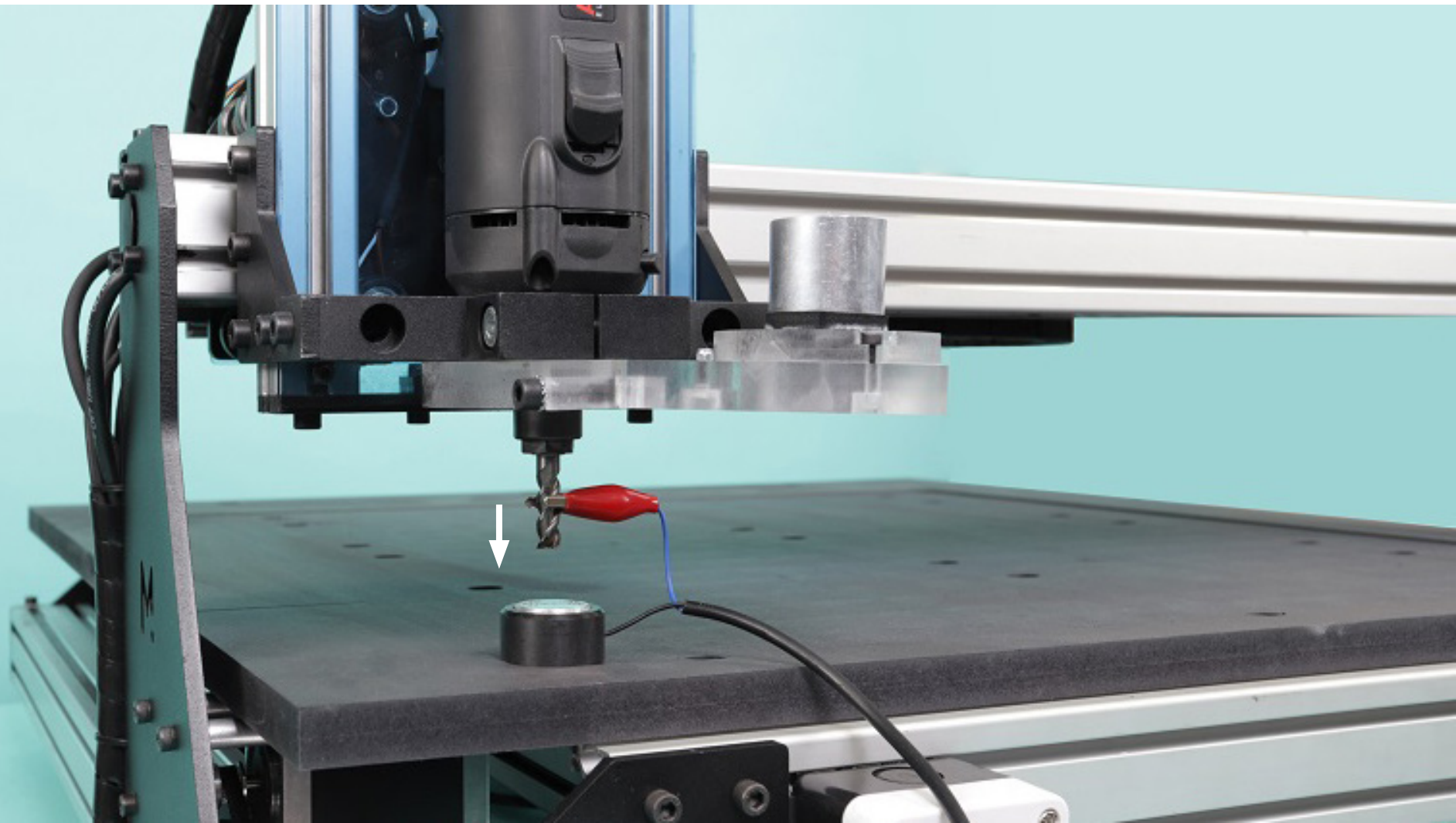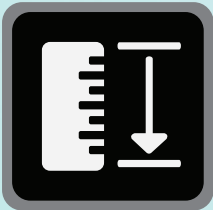1. Place the crocodile clip on the endmill
2. Place the probing device underneath the endmill
3. Press on the **"Tool measure length"** button

PLACE THE PROBING DEVICE ON THE BRAND NEW FLAT SURFACE

2. DRILLING THE HOLES

1. Press the **"Open Gcode"** button

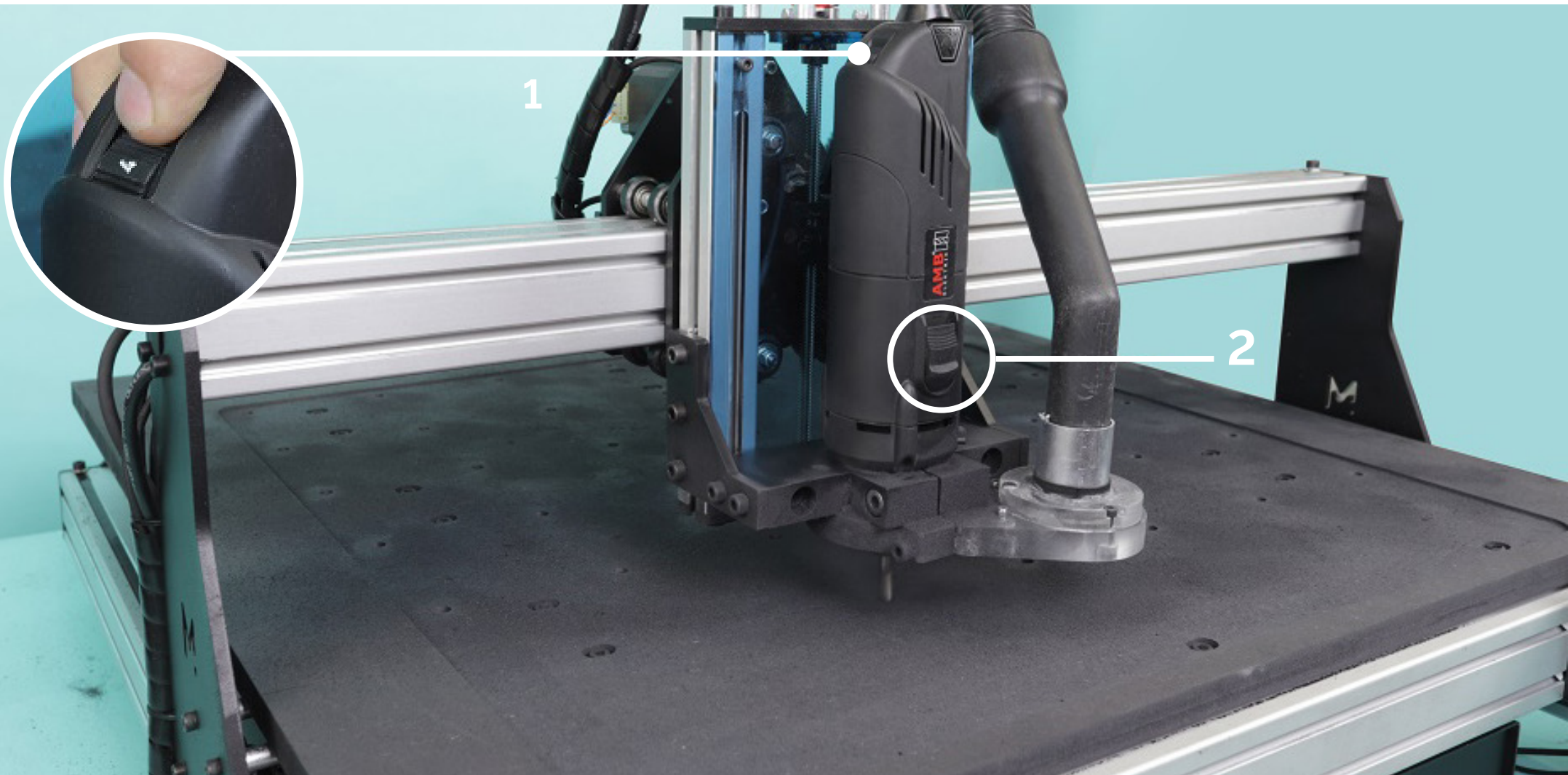2. Open the **"Holes - Endmill 8"** that corresponds to your Evo model (S, M or L).

2. DRILLING THE HOLES

1. Set the rotation speed on **"4"**

2. **Switch on the spindle**

WEAR SOME SECURITY GLASSES AND EAR PROTECTIONS

NO NEED TO INSTALL THE DUST SHOE FOR THIS OPERATION

1. Press the **"Play"** button

3. PLACING THE INSERTS

1. Gently place the inserts **as vertical as possible** thanks to the **6mm hex key** (included in the EVO kit)
2. Tighten the inserts until the flanged part touches the surface of the board

DO NOT OVERTIGHTEN THE INSERTS