

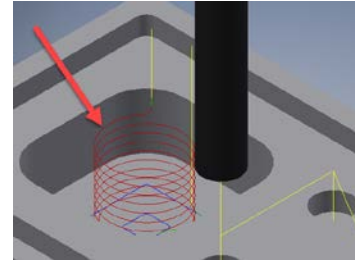


Solution: How to Change Ramping

Question:

When I make a **pocket in Inventor**, and then try to machine it with **HSM**, it takes forever to start cutting, and it swirls down into the part and moves very slowly. How do I get rid of this?

CAUTION: The change below should only be done when machining soft materials like wax or Renshape, butterboard or Styrofoam. If in doubt, Leave it alone!



Answer:

This is put there automatically when you chose a pocket and it is called a “**helical ramping**” operation. The post processor does this automatically so that the tool engages the material very slowly, to decrease chip load, and make it so the tool does not break.

Fortunately, when we are not working with metals, so we can safely remove this when using Renshape, wax, or a soft, non-metallic material, saving a lot of machine time in the process.

To change this in the **pocketing** operation, **edit** the operation, choose the **linking** tab, and scroll down to the **ramp** menu, and choose “**plunge**” from the menu. Be sure that you slow the feed rate down by ½ when you do this so as not to load the tool.

If you wanted to keep the helix, you can, just change the ramping angle to something greater to make it go faster. See below:

