

5 Axis Chip Collection

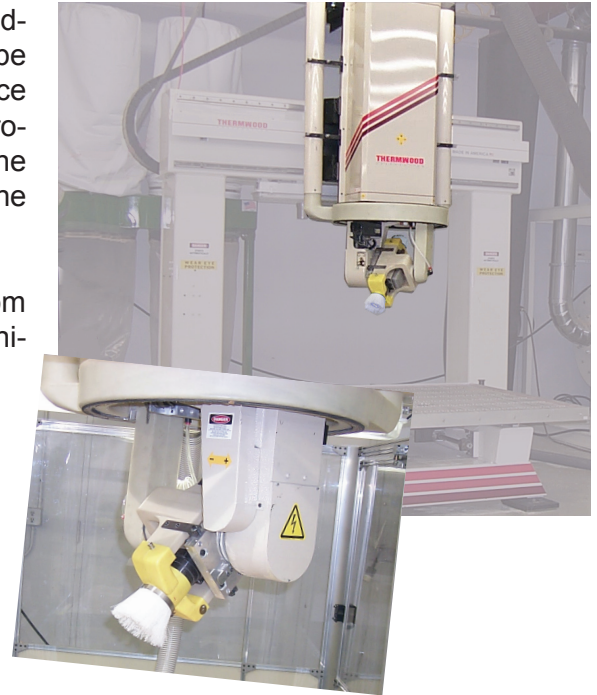
The chip collector option provides the user for the first time with a means to capture and collect dust and chips which are the by-product of the five axis cutting operation. In many cases the chips can be sold and become an asset rather than a liability. It can also reduce the amount of cleanup required around the machine as well as prolonging machine life by keeping it cleaner. The option consists the piping, ducting, hoods and swivels which are actually attached to the Thermwood. The Chip Collection Unit is not included.

The hoods and swivels which are machine mounted are custom designed, formed plastic parts which provide high airflow while minimizing the bulk to avoid interference. In order to operate properly it requires a collections system which has a highvac fan which delivers at least 1,300 acfm at 30" wg total static pressure.

Five-axis chip collection is a very difficult and demanding task. On one hand the more airflow the better, on the other it is imperative to keep the size of the ducts around the router motor itself as small as possible. We have attempted to provide the best compromise. The unit will work better in some applications than others. In some applications it may not work at all and must be removed to provide the necessary clearances to trim the part. To facilitate this the lower sections of the ducting are easily and quickly removable. The unit will work best when using standard length bits and on parts which can be trimmed with the dust hood brush rubbing the part. When using long bits or bit extensions the hood brush cannot touch the part and stop the momentum of the chips. This will result in subpar collection.

The Chip Collection System can be added to most Model 67 machines with exception of a machine utilizing the automatic tool change system.

The Chip Collection System can be added to existing Model 70 machines with travel limitations. The Z Axis must home 4" lower, Therefore 4" of router to table clearance is lost. If the machine currently has a toolchanger in the bridge leg the toolchanger must be moved down to the table surface. Doing this makes the back 13" of the table unusable, due to router clearance. Axis 5 rotation will be limited to 240 degrees instead of 270 degrees.



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