



HMH Australia Pty Ltd
Level 2, 54 Hotham Parade
Artartmon, NSW 2064
PO Box 713, Artarmon 1570
T. 612-9438 3654
F. 612-9438 3634
info@hmhaustralia.com.au
www.hmhaustralia.com.au

Procedures for Braille-OZ unit (supplied with measuring pin and spare o-ring for nose-cone)

IMPORTANT NOTE: THIS UNIT MUST NEVER HAVE OIL OR ANY OTHER LUBRICANT APPLIED.

1. Drill Braille text holes to **MEASURE 1.5mm** diam (60thou) and **1.1mm deep** (40 to 44thou) IN MATERIAL with Braille hole cutting tool. **THESE MEASUREMENTS ARE CRITICAL FOR THE SUCCESSFUL OPERATION OF THE UNIT AND MUST BE MEASURED WITH VERNIERS.**
2. **Measure the size** of the pre-drilled holes – the enclosed measuring pin must fit **FIRMLY** into the hole – if the pin does not fit into the hole **DO NOT PROCEED** – you **WILL** damage the unit. This damage is not covered under warranty.
3. Remove engraving spindle from machine and install Braille-OZ attachment (**LOADED WITH BALLS**)
4. Move the installed unit to the area over the pre-drilled text holes.
5. To set the height for the attachment - using the Z axis, move attachment down to the surface of the material, so that the bottom of the nose-cone **SOFTLY** touches the material. Set this as your zero height.
6. Machine Parameters in the software for Braille-OZ unit must be as follows (for plastics only)
 - (a) Engraving spindle turned **OFF**
 - (b) Spindle lift set to a **MINIMUM** of 5mm (.200")
 - (c) **Depth set to 3.3mm (.136")**
 - (d) Feed speed approx 45mm per second (1.8" per sec)
7. Re-run the Braille text using the above parameters to install the balls in the pre-drilled holes.

PLEASE NOTE: IT IS STONGLY ADVISED THAT TEST DRILLING BE PERFORMED ON A SCRAP OF THE SAME TYPE OF MATERIAL -----

HOLE must measure 1.5mm Diam (60 THOU) x 1.1mm deep

We have found that different brands of engraving material will drill out at different sizes so it is important to **drill and measure test holes**

If unit is unscrewed, make sure both lid and nosecone are done up tightly