



Courtesy of:



Outputting to a Gerber CNC Router from EnRoute 3

1. Router Firmware

Prior to outputting from EnRoute 3, make sure that your Gerber CNC Router has the latest available Gerber firmware.

Please contact Gerber tech support to find out which firmware version you are currently using and how to upgrade to the latest.

2. Gerber Spooler

The Gerber Spooler must be turned off prior to sending jobs from EnRoute 3 to the router.

3. EnRoute 3 Driver Setup

After EnRoute 3 has been installed, you have to setup the machine driver for your Gerber router(s).

- Open EnRoute 3 and open a new file.
- Hit the F6 key to bring up the Machine Driver dialog box.
- Click on the Active Drivers button at the lower left of the dialog box.
- When the Set Active Drivers dialog box appears, choose Gerber from the dropdown list of manufacturers and then choose the correct Gerber router model.
- Click OK to get back to the Machine Driver dialog box. Make sure that the Gerber model that you selected is the Active Driver at the top of the dialog box. If not, make it the active driver by selecting it from the dropdown list.
- Go down the list of driver parameters, and enter the default information for the router being setup. This information includes the dimensions of the router, default feed rates that you want to set, tool changer configuration (if necessary), and communications parameters.

4. Three settings that affect the output to the Gerber Sabre.

The combination of 'Arc tolerance' and 'Maximum turn angle' have a lot of affect on how the toolpaths are outputted to the machine. The Max turn angle and arc tolerance can be set in the Machine Setup dialog box under Advanced Parameters. By changing these parameters, you can fine tune how EnRoute 3 outputs to the machine. Here are some guidelines to follow:

Arc tolerance: 0.002 - 0.004

Maximum turn angle: 2 - 4

The third setting to check is the "Has Arc" option in the Advanced Settings. Make sure that this option is unchecked.

5. Outputting to the Machine from EnRoute 3

After the driver has been setup and configured, EnRoute 3 is ready to send jobs to the router. To send a toolpath that you've created to the router, go to the Machining menu and choose Output. This will bring up the Output dialog box. You can then choose the tools and/or strategies to be outputted and click on To Machine. This will send the job through the output control center to the machine. If you wish to hold the job and send it from the output control center, click Hold Output at the bottom of the Output dialog box. You can then send the job from OCC.

6. Configuring the Sabre (If you upgraded your firmware, contact Gerber Tech Support to learn about the difference between the old firmware and the new firmware.)

Prior to starting the job, make sure that the first bit to be used has been installed. Then do a Z Table Init so that the Sabre will know where the bottom of the bit is in relation to the top of the table. A Table Z Init to is required anytime the bit it changed. Then, when sending the job, choose A. Use Last (the last material thickness used), B. Use Nominal (the material thickness defined in the EnRoute 3 Plate Setup or C. Material Init (to use the Sabre to measure the material thickness). Whichever of the above you choose, it is important that the value ACCURATELY reflects the thickness of the material. If you are not sure of the thickness, choose option C and perform a Material Init to measure the thickness of the material. Then start the job.

Trouble Shooting

If the job does not show up at the router, here are some things to check.

- EnRoute 3 Gerber Setup. From the Gerber Driver setup in EnRoute 3, make sure that the communications parameters are correct. Check the settings from Artpath to make sure that the parameters are the same.
- Window's Port Settings. Go to the Window's Device Manager and go to Ports. Select the port being used to output to the router. Go to Properties > Port Settings > Advanced Port Settings, and make sure that the receive buffer is set to High (14). If it's set to Low (1), EnRoute can't communicate with the router.