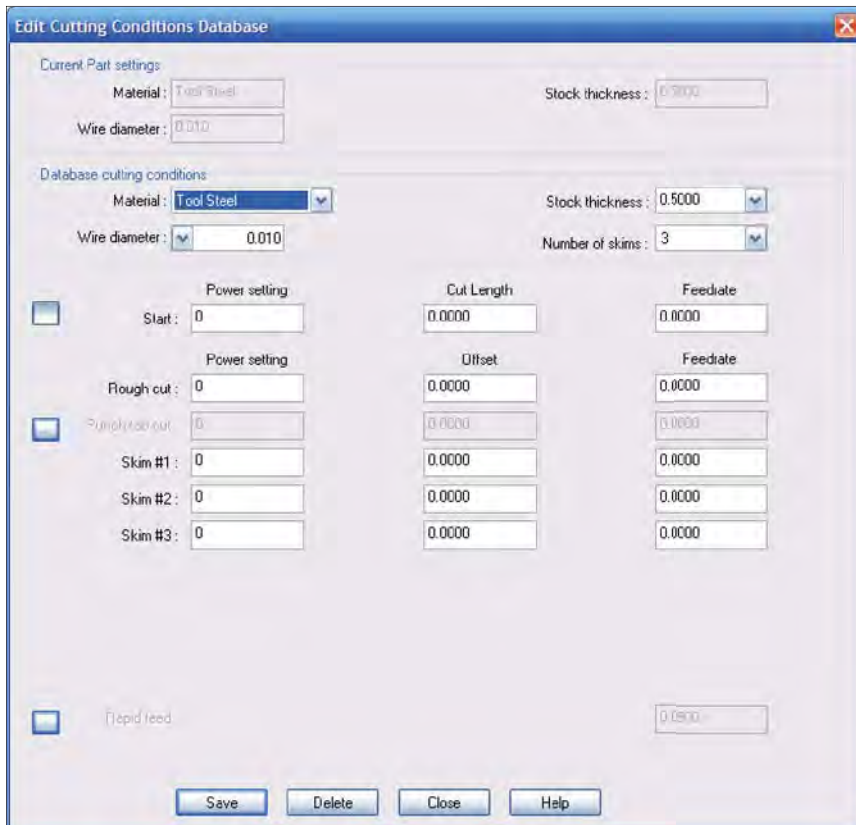
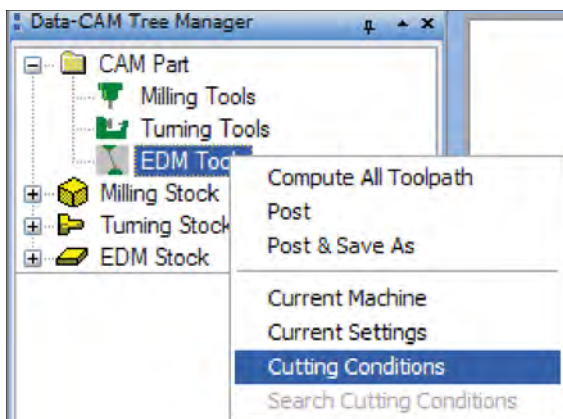


## FAQ #23: How do I change the cutting conditions?

**Q:** These conditions in the default database for my machine are close, but how to I change them to be what I really use in my shop?

**A:** That's built in to the software. To edit the database for any configured machine, right click on **EDM Tools** under **CAM Part** and choose **Cutting Conditions** from the menu. *Please note: if the database will not accept the changes made to it using the method described in this document, see [FAQ #48: How do I make a new WireEDM machine?](#) to get the cutting conditions database properly associated with the machine setup so that it can be auto-loaded into BobCAD-CAM.*



When the Edit Cutting Conditions Database dialog appears, it will be filled in with the conditions currently loaded for the part. Be sure to consult any documentation that came with the materials to be edited. All of the fields available for editing are detailed on the next page.

- **Current Part settings**
  - **Material:** This field displays the material assigned to the current part though the **Stock Settings** dialog box.
  - **Wire diameter:** This field displays the wire diameter currently set in the CAM tree.
  - **Stock thickness:** This field displays the **Stock thickness** currently set in the **Stock Settings** dialog box.
- **Database cutting conditions**
  - **Material:** This field sets the material in the database to be edited.
  - **Wire diameter:** This field allows the user to set the wire diameter for this material and thickness in the database.
  - **Stock thickness:** This field sets the **Stock thickness** for this material and wire diameter to be edited.
  - **Number of skims:** This field sets the number of skims allowed for this database record.
  - **Start button:** The button opposite the **Start** row permits editing of the starting parameters of the cut. If it is set, the user will be permitted to override the settings in the cutting conditions database for the wire starting conditions in this material.
- **Power Setting**
  - **Start:** This **Start** field permits the user to change the power setting used at the start of the cut.
  - **Rough cut:** The **Rough cut** field permits the user to change the power setting used for the duration of the first pass of the cut.
  - **Punch tab cut button:** This button specifically enables the user to change the values governing the **Punch tab cut**.
  - **Punch tab cut:** The **Punch tab cut** field permits the user to change the power setting used for the tab cut of this material and thickness.
  - **Skim #1-#7:** These fields contain the individual **Power setting** values for each of the skimming passes on the feature. Only as many rows will appear as skim passes chosen **Number of Skims** field under **Database cutting conditions** described above.
- **Cut length / Offset**
  - **Start:** This field permits the user to change this machine's setting for the amount that the wire will cut into the part before switching from the start conditions to the rough cut settings.
  - **Rough cut:** The **Offset** field in the **Rough cut** row allows the user to change the default offset specified for the roughing passes.
  - **Punch tab cut button:** When this button is set, the user will be permitted to change the **Offset** value for the **Punch tab cut** for this machine.
  - **Punch tab cut:** The **Offset** field in the **Punch tab cut** row allows the user to alter the offset specified for the punch tab cut for this machine.
  - **Skim #1-#7:** The **Offset** fields in each of the skimming pass rows allow the user to change the default offsets specified for each skim pass individually. There will only be as many rows available as there are skim passes specified in the **Number of Skims** field under **Database cutting conditions** described above.
- **Feedrate**
  - **Start:** This field permits the user to change this machine's starting feed setting for the amount that the wire will cut into the part before switching from the start conditions to the rough cut settings.
  - **Rough cut:** The **Feedrate** field in the **Rough cut** row allows the user to change the default feed specified for the roughing pass for this machine.
  - **Punch tab cut button:** When this button is set, the user will be permitted to change the **Feedrate** value for the **Punch tab cut** away from the default listed for this machine.

- **Punch tab cut:** The **Feedrate** field in the **Punch tab cut** row allows the user to change the default offset specified for the punch tab cut.
  - **Skim #1-#7:** The **Feedrate** fields in each of the skimming pass rows allow the user to change the default feeds specified for each skim pass individually. There will only be as many rows available as there are skim passes specified in the **Number of Skims** field under **Database cutting conditions** described above.
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- **Rapid feed button:** When this button is set, the user will be able to change the default rapid feed rate used when the wire path crosses open spaces within the cut.
  - **Save:** If the user has altered any of the settings used for this record, the **Save** button allows the modified settings to be saved to the database to become the default settings for this type of material, thickness, and wire diameter set in future parts.
  - **Delete:** The **Delete** button erases this record from the currently loaded database file.
  - **Close:** This button closes the dialog. Click this when finished editing the database.
  - **Help:** The **Help** button displays the **Help** page for this dialog in the system.