

## Replacing a Sacrificial Table Surface on Sabre™ Series Routers

**Gerber FastFact #:** 5036

**Supplied By:** Gerber Service

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**Summary:** This document outlines the basic recommended procedure and important steps for replacing the sacrificial table surface of Sabre series routers.

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### Removal of Sintra mats:

The first step is to remove the old table mats. This can be accomplished prying up the table mat, starting at one end, with a putty knife and peeling it off. This will leave some adhesive behind, which must be completely removed.

### Preparation of the aluminum table surface:

The adhesive can be removed with most any strong solvent\*. Once you have completely removed the adhesive, wash the table surface with a lint-free cloth and any ammonia-based window/surface cleaner. Go over the table again with a new lint-free cloth and 99% isopropyl alcohol. Your table is now ready to accept new mats.

*Note: If you wait more than 30 minutes before installing the new mats, you must repeat the last step (alcohol) in the table preparation before continuing.*

**\*Be sure to comply with any safety precautions of all chemicals.**

### Preparation of the new mats:

Before applying the two-sided tape to the mats, you must wipe them with a new lint-free cloth and 99% isopropyl alcohol. Once the mats are dry, apply the tape to each mat by cutting a length off the roll that is about 2+ inches longer than the mat using a squeegee. It is important that there are no air bubbles and that the tape is applied with maximum pressure. Trim off any excess.

### Installing the mats onto the table:

It is easy to tell where the old mats were—the aluminum surface will appear newer. Peel the liner off the tape, position the mat exactly where the old one was, and apply it to the aluminum slat. You should use a good amount of pressure to ensure that the tape will adhere properly to the aluminum, concentrating on the edges. Repeat this seven times and you've got a new tabletop.

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## Vacuum tables:

If your table is equipped with a T-Vac™ system, you will need to drill and pocket the new mats. The files needed to do this are located in the *rtp* folder under the *Jobs* directory. Make sure you choose the correct files for your machine.

Install a 1/8" bit . Position the router so that you are at machine 0 in the Y axis (closest to the front), and in the exact center of the center slat in the X axis. This is achieved by measuring the center slat, marking the middle, and positioning the 1/8" bit at dead center on that mark. Set your home here.

Next, check the revision level of your Sabre™. This can be found in the menu structure at the keypad under 'Configuration'. The revision level will read 'Control Rev.: X.X'.

**For Sabre routers with firmware revision I.4 or lower**, initialize the bit to the table surface, using the '**material init**' setting on the Sabre. Your tabletop is your material in this case.

**For Sabre routers with firmware revision L.2 or L.2e and higher**, initialize the bit to the table surface using the '**table init**' setting of the Sabre. The 'Thickness' value in the output screen of ARTPath should be set at '0.00', and you should use the 'Nominal' thickness when asked at the Sabre keypad.

Now, open the *drill* file specific to your router (this file uses a 1/8" bit to drill the holes). You will see that the Start/Stop position is in the lower left corner, or 0,0. You must change the Start position to the lower **center**. You can do this from the Setup pull-down menu, or in the output screen. Now you are ready to send and run the job.

Once your holes are drilled go into the Sabre menu and 'Return Home'. Your next job, which created the pockets, needs to start in the same place as the drill job.

The *pocket* file uses a 7/16" 2 flute straight bit and should be initialized the same way as the 1/8" bit. If you don't have a 7/16" bit and can't find one at a hardware store, you can order one through your distributor (Part # P51505A). As with the *drill* file, the Start position of this file must be changed to lower **center**.

The last step is the *mill* file. It uses the 1¼" table-surfacing tool that came in the Sabre tool kit. Again, initialization of this tool depends on firmware revision of the Sabre. For this file, position the router at 0,0, and leave the Start/Stop position of the file at 0,0.

**If you have any questions, please call Gerber Service at (860) 644-6971.**