

**Choose the Flip Sheet Squaring Option for Full Sheet Flipside Machining.**

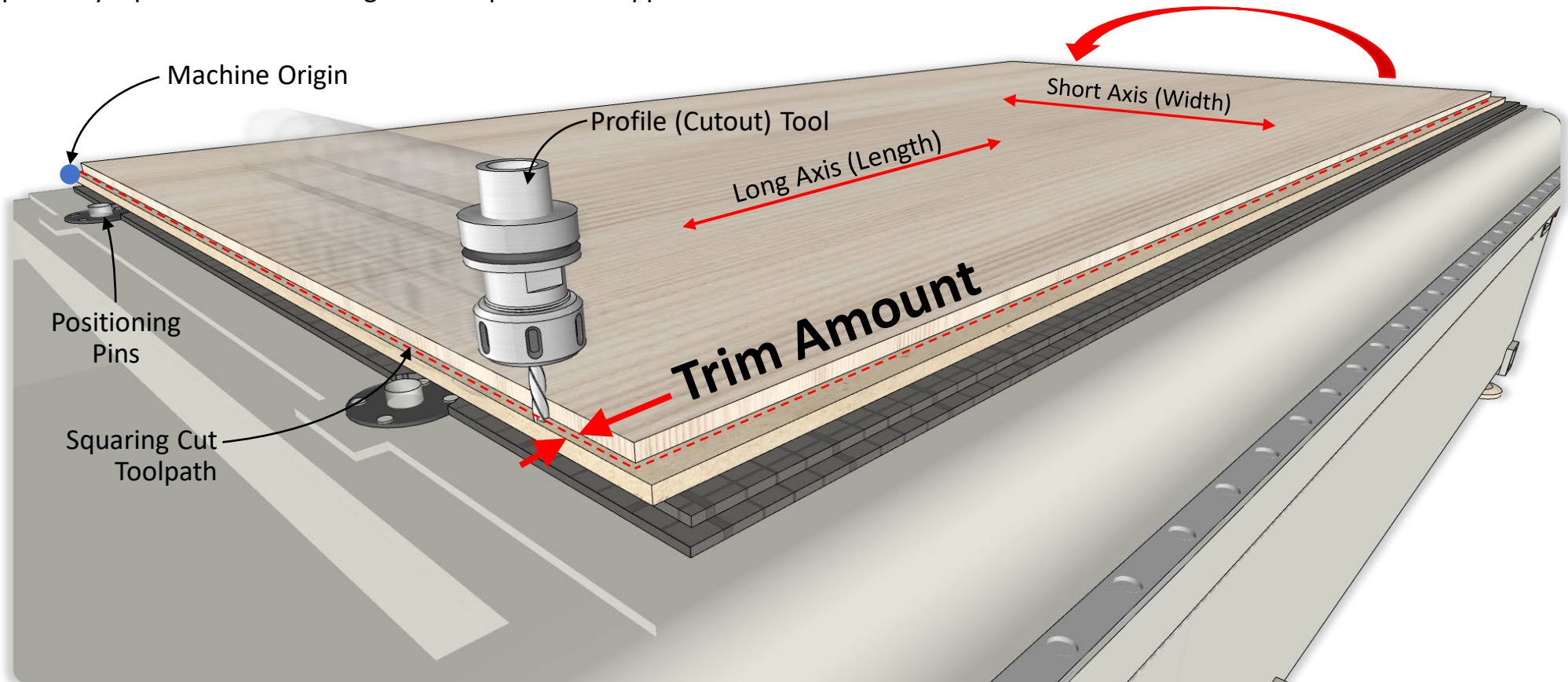
## 1. Add a Squaring Cut?

Choose to add a Squaring Cut for your full sheet flipside operations. It is recommended to add a squaring cut as flipside operations require precise placement of the material on your router for best results. Assuming you are using v10.1.5 or newer, the primary g-code will be adjusted accordingly.

Flip sheet squaring often requires your tool to enter your machines negative positions. Ensure you take enough off to eliminate possible overtravel or limit errors on certain machines. You may need to also ensure your Length and Width trim is large enough to account for your squaring cut.

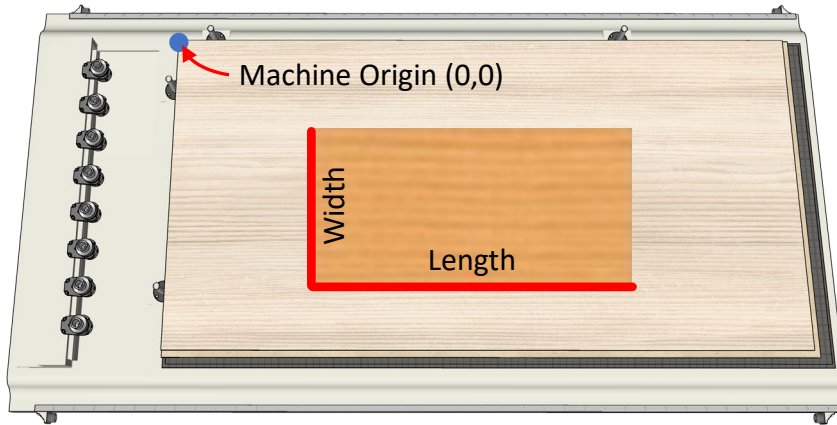
## 2. Trim Amount.

Choose the amount that the squaring cut will cut into the material. The trim amount for the squaring cut will ensure a perfectly square corner to fit against our pins once flipped.

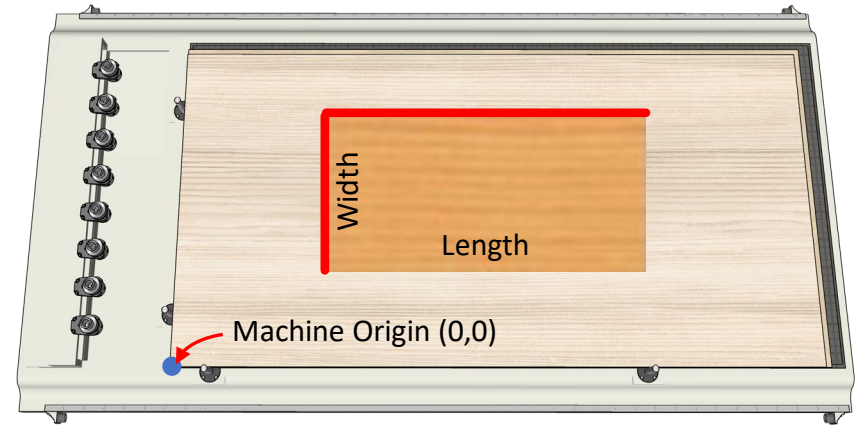


The Edges that you square will depend on the setup of your CNC Router. Use the Images below, to choose the best Square Cut option for your machine.

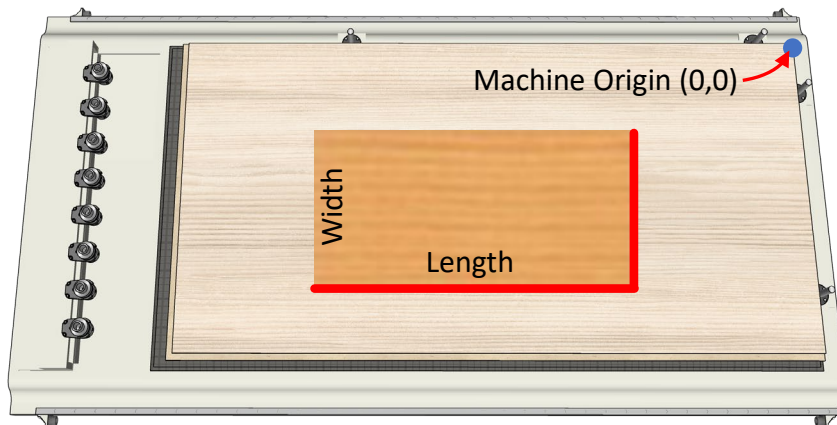
**3. Bottom Left Squaring Cut**



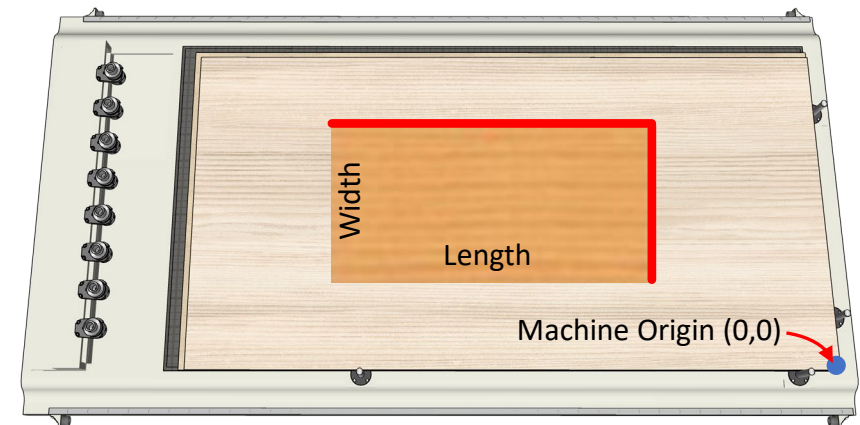
**5. Top Left Squaring Cut**



**4. Bottom Right Squaring Cut**



**6. Top Right Squaring Cut**



## 7. Save as Defaults

Once you are happy with your Squaring Cut Selections, click "Save As Default" so these settings will automatically be set.