CNC-MILLING MACHINE

1 get an appointment

›› appointment only for consultation and checking the file, not for the milling process itself
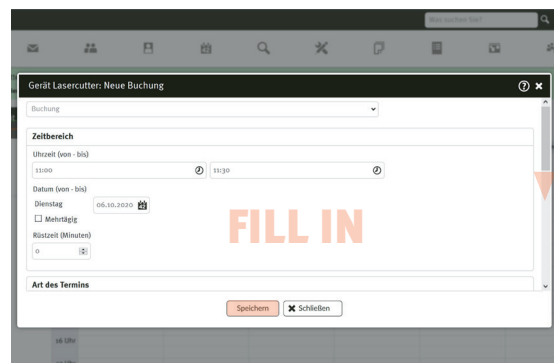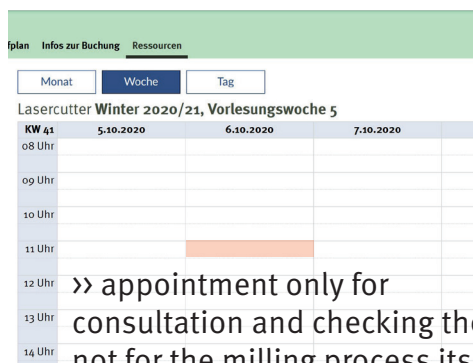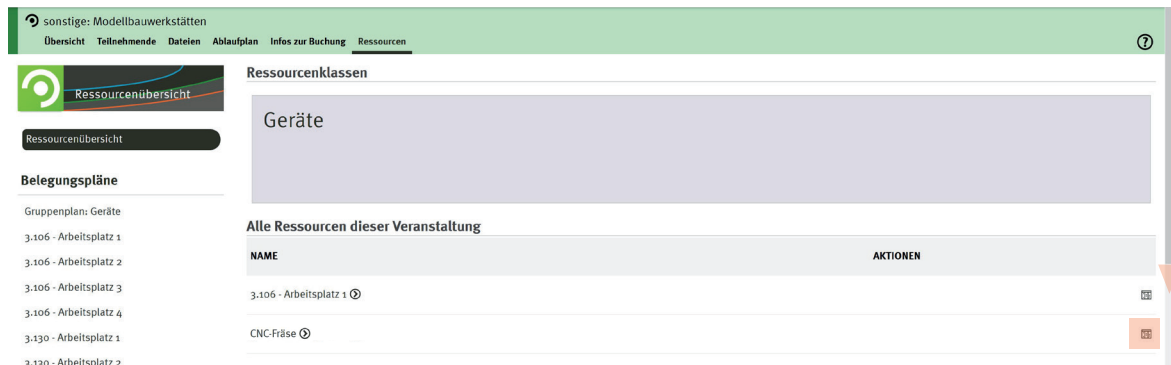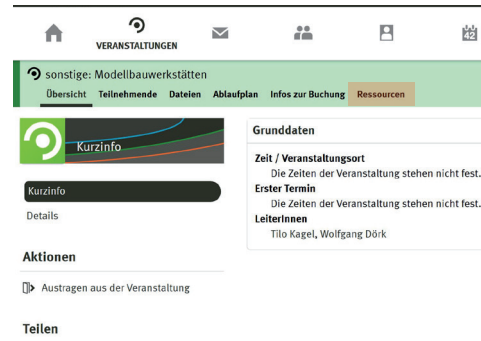
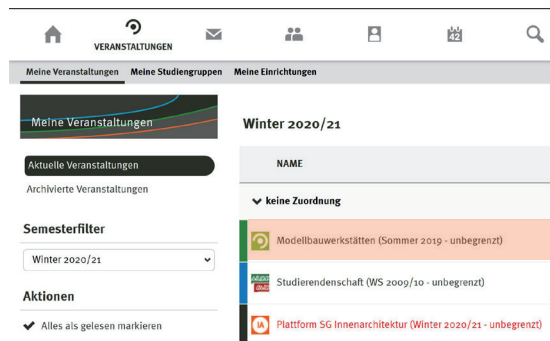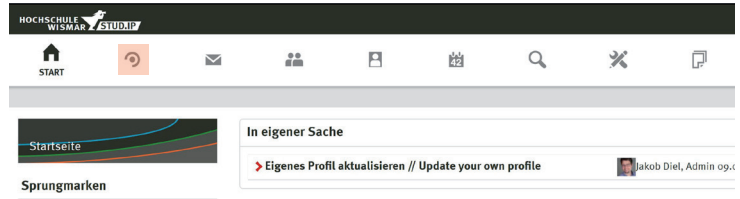**FILL IN**

2 create a file

operating range CNC-milling machine: **maximum 1570 x 1290mm**

create the draft in your CAD-program according to the **size of your material**

all round **margin of 50mm**
if you want to mill two or more objects out of one material, there needs to be a **space of minimum 30mm** between them

recommendation: create your file in **AutoCAD**
›› here you can work more precisely than with other CAD-programs and the transfer to the milling-program Mastercam works the best

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example
3D terrain model

Scale 1:1
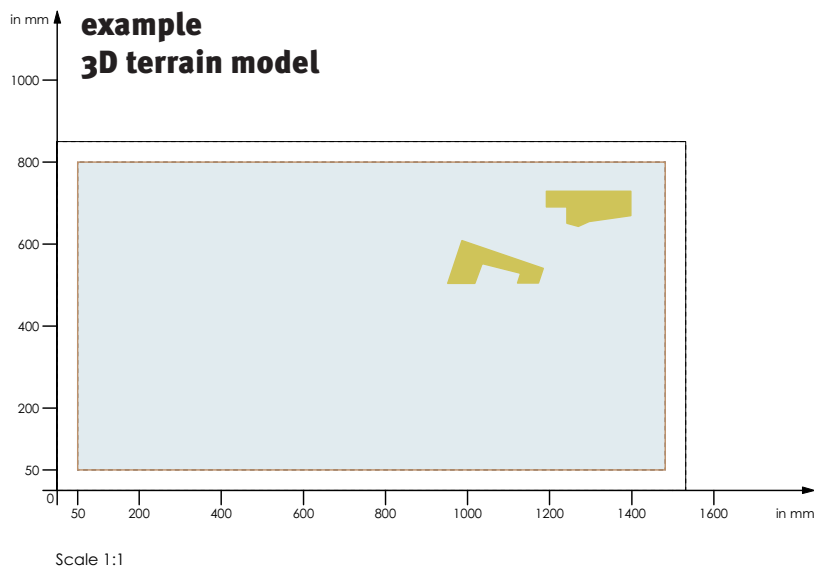
Layer	
Layer 1 __ 3D model	
Layer 2 __ 20mm deep	
Layer 3 __ 55mm deep	

›› compile the milling pockets as surfaces
›› place cutting lines as line drawings on a separate layer

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example
two objects out of one material

Scale 1:1
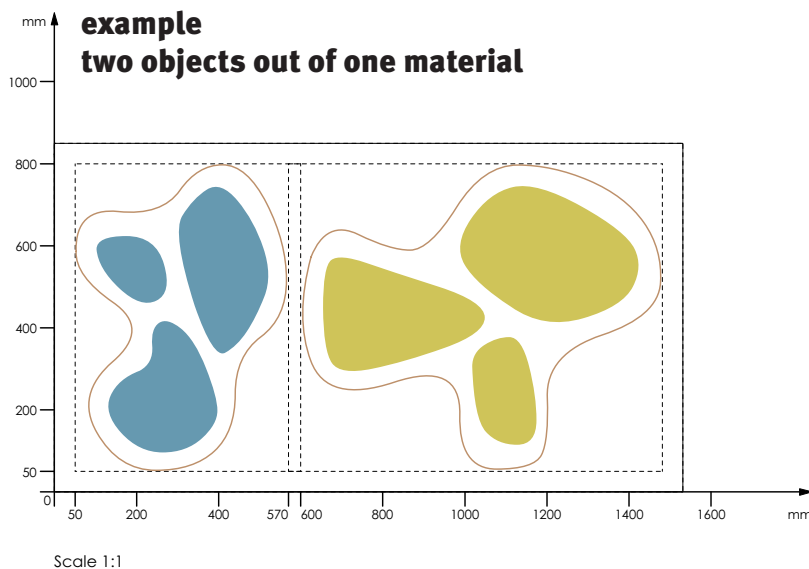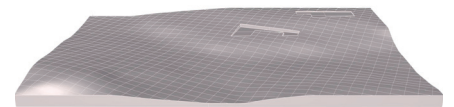
Layer	
Layer 1 __ 25mm	
Layer 2 __ 20mm	
Layer 3 __ 55mm	

›› compile the milling pockets as surfaces
›› place cutting lines as line drawings on a separate layer

example drill-holes
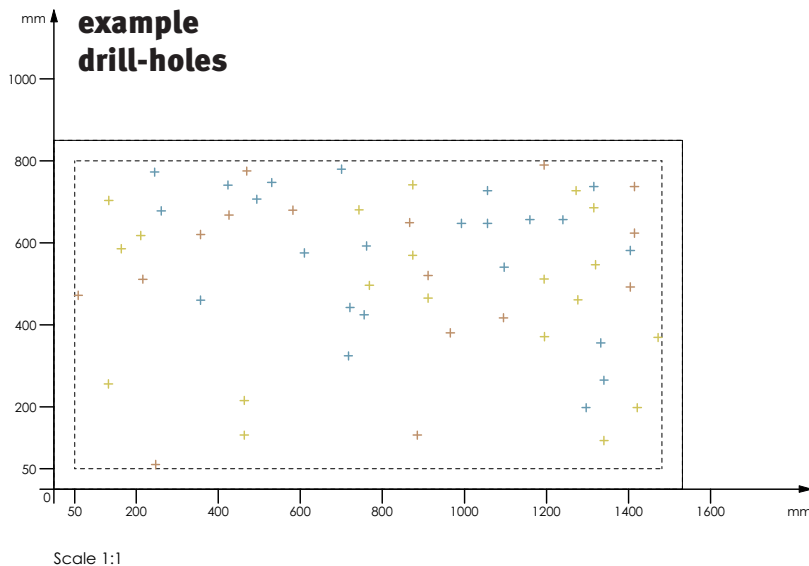
Layer
- Layer 1 __ 7mm depth, dm 3mm
- Layer 2 __ 10mm depth, dm 5mm
- Layer 3 __ 13mm depth, dm 7mm

›› a dot or cross works
   as the midpoint
   of the drill
›› also includable in 3D model

Scale 1:1

IMPORTANT !

the scale of your drawing needs to be 1:1

place the drawing at the point of origin (X=0, Y=0, Z=0)

use different layers for the various milling depths and name them

delete all unnecessary dots, lines and layers

lines have to be connected exactly

3 send your file

email your file to: **cnc-fg@hs-wismar.de**

save file as **dxf, dwg, step or 3dm**

labelling: **avoid special characters** (ä ö ü ; , . : - etc.) in your files' name
name the file with the **projects' title** and **your full name**

›› if you want you can check your file with the **study version of „Mastercam"**

4 what's possible?

maximum milling depth: 55mm
›› for a bigger size split the object appropriate and glue the pieces together
   afterwards

milling head sizes from 2 - 10mm available
›› radii in these diameters are possible