

Summary

To: Professor Christopher
From: Nick Groselak, Kayla Lett, Cory Wyn
Date: December 4, 2021
Subject: Vertical Machining Center Operations and Verification of the Machine Tool

Introduction

In this lab students learned to use the CNC milling machine. The CNC milling machine is a vertical milling machining center that is capable of creating complex geometric features through the implementation of G-code into the CNC system. The process of using a CNC milling machine includes first designing the part to be milled in a CAD software such as SolidWorks, creating a milling procedure using CAM software such as SolidWorks AutoCAM, generating the G-code based on the CAM work, and then programming the CNC milling machine to cut the steel stock into the designed part.

For this laboratory exercise, the design of the milled part was to be created by the students with design requirements to be met. These requirements included making a wrench to fit two different standard sized nuts with two additional features and the cutting process that must include 2 different end mills with a machining time of less than six hours. The design created was based upon the body of a two-dimensional shark that included three different wrench sizes (8 mm, 10mm and 12 mm), along with a bottle opener, key chain hole, and a flathead screwdriver. A drawing and model of this design along with the G-code used can be found in Appendix A.

Process Plan

To begin, several ideas were developed using hand sketches. A final design was then chosen from the options created. The final design was then modeled in solid works. The photo upload feature was used to put the sketch made into solidworks. The drawing for the model was then created by tracing over the line of the sketch with spliced lines in solid works. The sections of the drawing, the wrench head sections and the bottle opener were dimensioned accordingly while the general outline of the shape was based on appearances.

Once the CAD model was made, the machining process was chosen. The raw piece was a thin rectangular shape. This piece was clamped into the CNC machine on top of another identical piece to provide some safety clearance to aid in avoiding cutting the table of the CNC. Both pieces were clamped using one clamp on either minor edge of the rectangle. The clamps were placed so that they provided enough security that the part would not move, but did not take up more surface area than needed.

Tool sizes were selected to machine the part. Based on these the feed rates were then determined using the chart provided on the Shark CNC machine. These were based on a cutter with 2 teeth.

It was determined that a 1/2" bit would be used to cut the initial rough pass with a depth of cut of 0.025". The roughing pass would follow the general shape of the perimeter of the part but not include any of the details. It's main goal was to remove a bulk of material which would expedite the process and help produce a cleaner part. A thin layer 0.010" thick was left at the bottom to keep the part from breaking free. A finishing pass was then completed using a 1/8" cutter with a 0.005" depth of cut. This pass included

all of the details of the part. Like the roughing pass, a thin 0.010" layer was left so that the part did not come loose.

Once the passes on the CNC were completed the part was removed from the machine. A hand held grinder with 80 grit sandpaper was used to remove the thin layer left and separate the part from the rest of the scrap metal. A drill press with a 1/8" bit was then used to create the hole for the eye of the shark and the keychain hole.

Results and Discussion

The final product of the wrench part matched the designed piece and the finish was satisfactory. All of the features were tested and worked properly. The finish on the edges and faces were clean and met expectations. The completed part can be seen in Figure 1. The only alteration between the original design and the manufactured part was the "gills" of the shark which were removed due to time constraints. A few additional issues were run into during the milling process that needed to be addressed during the manufacturing of the part. While trying to cut out the gills which were put into the first design iteration, the depth of cut was set too large for the size of the cutter and it broke after making the first pass on the first gill. After running into this issue in combination with the estimated time it would take for them to be completed with the fixed depth of cut it was decided not to continue cutting the gills.

While making the roughing pass, there were several areas near the fins of the shark which were cut fully through rather than leaving the anticipated thin layer of material to hold the part in place. This was likely due to warp in the material, causing some sections to be raised and thus cut through before others. Enough of the material was still left in tact to hold the part in place for the rest of the cutting operations. The depth to be left for the finishing pass was increased so as to avoid this issue and refrain from cutting the part free from the rest of the stock material.

The time spent on the machine, including set up, tool replacement and cutting time was about 4 hours. When determining the cutting speeds it was assumed that a 2 tooth cutter would be used, however the larger cutter used for the roughing pass had 4 teeth. Because of this the speed set for cutting the roughing pass could have been faster. According to the calculations it should have taken about 2 hours to cut the part, in reality it took a bit over 2.5 hours for the cutting process. The calculations for the machining time can be found in Appendix B.



Figure 1: Finished work-piece

Appendix A - CAD Drawing

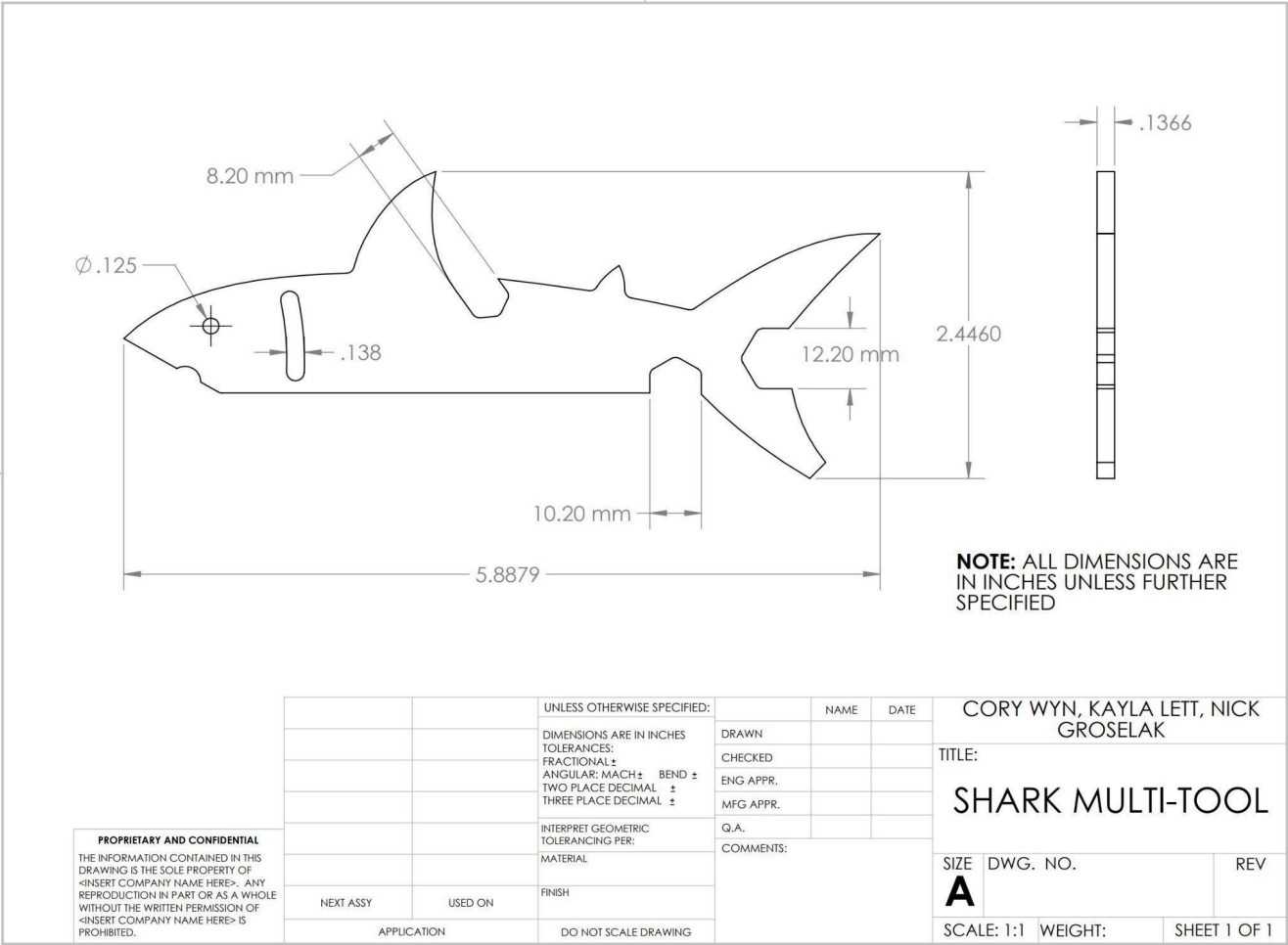


Figure A-1: SolidWorks drawing of Shark Multi-Tool

Appendix B - Machining Time Calculations

Tool 1 Diameter	0.125	inches	N	fr	Tm for one pass (min)	Passes required	Total time for tool 1 (min)
depth of each cut	0.005	inches	0.3978873577	7.957747155	2.45044227	27.32	66.94608281
speed/feed	10	inch per minute					
teeth	2						
RPM	1222						
Tool 2 Diameter	0.5	inches	N	fr	Tm for one pass (min)	Passes required	Total time for tool 2 (min)
depth of each cut	0.025	inches	0.3978873577	1.989436789	9.801769079	5.464	53.55686625
speed/feed	2.5	inch per minute					
teeth	2						
RPM	306						
Approximate profile length	19.5	inches		Total time	120.503	minutes	
Total Part Depth	0.1366	inches			2.008	hours	

Figure B-1: Used Calculated Machining Time

Tool 1 Diameter	0.125	inches	N	fr	Tm for one pass (min)	Passes required	Total time for tool 1 (min)
depth of each cut	0.005	inches	0.3978873577	7.957747155	2.45044227	27.32	66.94608281
speed/feed	10	inch per minute					
teeth	2						
RPM	1222						
Tool 2 Diameter	0.5	inches	N	fr	Tm for one pass (min)	Passes required	Total time for tool 2 (min)
depth of each cut	0.025	inches	0.3978873577	3.978873577	4.90088454	5.464	26.77843312
speed/feed	2.5	inch per minute					
teeth	4						
RPM	306						
Approximate profile length	19.5	inches		Total time	93.725	minutes	
Total Part Depth	0.1366	inches			1.562	hours	

Figure B-2: Corrected Calculated Machining Time

Appendix C - G Code

G-Code of Shark Multi-Tool Produced using the SolidWorks feature SolidCam,

%

O1000 (SHARKMULTITOOL_INCH)

N100 (COMPENSATION-WEAR)

N102 (REV-0.70)

N104 (DEC- 1-2021-2:26:16PM)

N106 (TOOL 2 - DIA 0.5)

N108 (TOOL 1 - DIA 0.125)

N1 G90 G17 G40 G80 G00

N110 M06 T2 ()

N112 (F-contour5)

N114 G00 G54 G90 X0.225 Y1.5921 S335 M03

N116 G43 H2 Z2.

N118 Z1.

N120 Z0.0787

N122 G03 X-0.109 Y1.69 Z-0.025 I-0.1166 J0.2211 F1.

N124 X-0.109 Y1.69 I0.2175 J0.1233 F2.5

N126 X0.225 Y1.5921 I0.2175 J0.1233

N128 G02 X0.2669 Y1.6136 I0.9646 J-1.8295

N130 G01 X0.2677 Y1.614

N132 G02 X0.2747 Y1.6174 I0.1152 J-0.2275

N134 G01 X0.3301 Y1.6434

N136 G02 X0.3356 Y1.6459 I0.1082 J-0.2309

N138 X0.4664 Y1.6989 I0.9536 J-2.1661

N140 G01 X0.469 Y1.6999

N142 G02 X0.4756 Y1.7022 I0.0899 J-0.2386

N144 G01 X0.5389 Y1.7241

N146 G02 X0.5441 Y1.7259 I0.0833 J-0.241

N148 X0.6943 Y1.7696 I0.8751 J-2.7213

N150 G01 X0.6946

N152 X0.6982 Y1.7707

N154 G02 X0.7027 Y1.7718 I0.0643 J-0.2468

N156 G01 X0.776 Y1.7895

N158 G02 X0.7833 Y1.7912 I0.0598 J-0.2479

N160 G01 X0.8612 Y1.8075

N162 G02 X0.8644 Y1.8082 I0.0525 J-0.2495

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N170 G02 X1.0406 Y1.8379 I0.7478 J-3.9332
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N178 G02 X1.2292 Y1.8605 I0.0268 J-0.2536
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N182 G02 X1.3305 Y1.8695 I0.0227 J-0.254
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N190 G02 X1.4444 Y1.8775 I0.0162 J-0.2545
N192 G01 X1.5613 Y1.8842
N194 G02 X1.5642 Y1.8842 I0.0144 J-0.2546
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N198 X1.5977 Y1.9117
N200 G02 X1.6004 Y1.9187 I0.2386 J-0.09
N202 X1.6514 Y2.0305 I1.5163 J-0.6238
N204 X1.6517 Y2.0311 I0.2279 J-0.1144
N206 G01 X1.6526 Y2.0329
N208 G02 X1.6554 Y2.0383 I0.2276 J-0.115
N210 G01 X1.6805 Y2.0851
N212 G02 X1.6829 Y2.0894 I0.2248 J-0.1204
N214 G01 X1.6839 Y2.0912
N216 G02 X1.6847 Y2.0928 I0.2224 J-0.1248
N218 X1.7538 Y2.2048 I1.6639 J-0.949
N220 X1.7545 Y2.2058 I0.2123 J-0.1412
N222 X1.8616 Y2.348 I1.3842 J-0.9307
N224 X1.8635 Y2.3503 I0.1952 J-0.164
N226 X1.94 Y2.4327 I1.1325 J-0.9746
N228 X1.9418 Y2.4345 I0.1802 J-0.1804
N230 X2.0653 Y2.5403 I0.8573 J-0.8752
N232 X2.0675 Y2.542 I0.1527 J-0.2042
N234 X2.1996 Y2.6248 I0.6474 J-0.8852
N236 X2.2025 Y2.6263 I0.1198 J-0.2251
N238 X2.2943 Y2.6685 I0.5035 J-0.9759
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N326 G02 X4.5938 Y1.7646 I0.1397 J-0.2134
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N532 X0.225 Y1.5921 I-0.2496 J-0.0143
N534 G02 X0.2669 Y1.6136 I0.9646 J-1.8295
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N542 G02 X0.3356 Y1.6459 I0.1082 J-0.2309
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N548 G02 X0.4756 Y1.7022 I0.0899 J-0.2386
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