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Table Of Contents

4 Axis Introduction	25
Introduction To 4 - Axis Programing	26
The Mastercam® User Interface:	29
Setting The Grid	30
Home Tab Attributes And Organize Groups And The Mini Toolbar	32
Data Entry Shortcuts	34
The Right Mouse Click Menu	35
AutoCursor	36
About Rotary Axis Control	37
Mastercam® 4 - Axis Work Flow:	38
Conventions Used In This Book	41
Axis Substitution Roll	43
Introduction:	44
Instructor Demonstration Preview:	46
Exercise 1: Axis Substitution - Roll The Geometry	47
Step 1: Locate Part Geometry	47
1. Open File	47
Step 2: Set The Stock As Cylinder In The Stock Setup	47
Step 3: Roll The Geometry	48
1. Change The Active Level To 2 And Name It "Rolled Geometry"	48
2. Roll The Geometry	48
3. Make Visible Only Level 1, The Flat Geometry	49
Step 4: Drill The 0.25" Diameter Holes	49
1. Select The Toolpath	49
2. Set Tool	49

3. Set Cut Parameters	49
4. Set Linking Parameters	50
5. Set Tip Comp	50
6. Backplot The Toolpath	50
Step 5: Substitute X-axis	50
Step 6: Drill The 0.5" Diameter Holes	52
Step 7: Machine The Inside Obround Shape Using Slot Mill Toolpath	53
Step 8: Machine The Outside Obround Using Contour Toolpath	55
7. Set Cut Parameters	56
8. Set Lead In/Out	56
9. Set Linking Parameters	57
10. Set Rotary Axis Control	57
11. Make Only Level 2 Visible	57
12. Backplot The Toolpath	57
Axis Substitution Unroll	59
Introduction:	60
Instructor Demonstration Preview:	61
Exercise 2: Axis Substitution - Unroll The Geometry	62
Locate Part Geometry	62
1. Open File	62
Step 1: UnRoll The Geometry	62
Step 2: Create Extra Geometry To Be Able To Machine The Open Areas	63
Step 3: Use Pocket Toolpath To Machine The Part	64
2. Set Cut Parameters	64
Step 4: Change The Tool And The Stepover	67
Step 5: Rolldie C-Hook	68
Using Rolldie C-hook To Machine With The Side Of The Tool	68
Axis Substitution Helix	71

Introduction:	72
Instructor Demonstration Preview:	73
Exercise 3: Axis Substitution - Creating A Cylindrical Helix	74
Create The Geometry For The Helix	74
1. Create The Horizontal Line	74
2. Create The Vertical Line	74
3. Create Line Parallel	75
4. Create The Hypotenuse Of The Right Angle Triangle As Shown In The Drawing	75
5. Delete The Two Horizontal Lines And The Vertical Line	75
Select The Default Mill Machine	75
Machine The Helix Using Contour With Axis Substitution	76
1. Select The Toolpath	76
2. Set Tool	76
3. Set Cut Parameters	76
4. Set Depth Cuts	77
5. Set Lead In/Out	77
6. Set Linking Parameters	77
7. Set Rotary Axis Control	77
8. Backplot The Toolpath	78
9. Verify The Toolpath	78
10. Save The File As "Cylindrical Helix"	78
Exercise 4: Axis Substitution - Creating A Conical Helix	79
Create The Geometry For The Conical Helix	79
1. Use Analyze Entity Properties Command To Modify The Geometry	79
Machine The Conical Helix	80
1. Select The Toolpath	80
2. Set Tool	80

3. Set Cut Parameters	80
4. Set Depth Cuts	80
5. Set Lead In/Out	80
6. Set Linking Parameters	80
7. Set Rotary Axis Control	80
8. Backplot The Toolpath	81
9. Change The Graphics View To Right Side View.	81
10. Verify The Toolpath	81
Axis Substitution Dynamic Mill	83
Introduction:	84
Instructor Demonstration Preview:	85
Exercise 5: Axis Substitution Pocket	86
Locate Part Geometry	86
1. Open File	86
Step 1: Create The Wireframe Using Curve All Edges	86
Step 2: Unroll The Geometry	87
Step 3: Fix The Geometry	89
Step 4: Select The Machine And Set The Properties	90
Step 5: Create The Pocket Toolpath Using Axis Substitution	90
Axis Substitution Rolldie	93
Introduction:	94
Instructor Demonstration Preview:	95
Exercise 6: Axis Substitution & Rolldie - Barrel Cam	96
Step 1: Select A Machine And Set The Properties	96
Step 2: Create The Contour Toolpath Using Axis Substitution	96
Step 3: Rolldie C-Hook To Machine The Barrel Cam	100
Step 4: Using Rolldie C-hook To Machine The Right Side	100
Step 5: Using Rolldie C-hook To Machine The Left Side	103

Axis Position & Transform	105
Introduction	106
Instructor Demonstration Preview:	107
Exercise 7: Axis Substitution, Axis Positioning & Transform - Rotate	108
Step 1: Locate Part Geometry	108
Step 2: Drill The Four 3/8" Diameter Holes Using Y-Axis Substitution	108
Step 3: Drill The Eight Holes Using Rotary Axis Positioning	110
Step 4: Engrave The Numbers Using Axis Substitution	111
Step 5: Machine One Slot Using 2D Contour	113
Step 6: Transform - Rotate Toolpath To Machine The Rest Of The Slots	114
Planes - Indexing A-Axis	117
Introduction:	118
Instructor Demonstration Preview:	119
Exercise 8: Tool Planes - Indexing About A-Axis	120
Step 1: Machine The Cutouts Using Contour Toolpath With Axis Substitution.	120
Step 2: Setup The Tool Plane Using Dynamic	123
Step 3: Drill The 25/64" Diameter Hole	124
Step 4: Transform - Rotate By Tool Plane To Machine The Other Two Holes	125
Step 5: Machine The Top Cutout Using Contour Toolpath	127
1. Set Linking Parameters	127
2. Set Rotary Axis Control	127
3. Backplot The Toolpath	127
Step 6: Machine The Bigger Slot At 120 Degrees In A New Tplane	128
1. Select The Toolpath	128
2. Set Tool	128
3. Set Cut Parameters	128
4. Set Lead In/Out	128

5. Set Linking Parameters	129
6. Set Rotary Axis Control	129
7. Backplot The Toolpath	129
8. Make Level 3 Visible	129
9. Verify the Toolpaths	130
10. Remove The Chips	130
Tool Planes - Horizontal Machining	131
Introduction	132
Instructor Demonstration	133
Exercise 9: Tool Planes - For Horizontal Machining Centers	134
Step 1: Locate Part Geometry	134
Step 2: Setup The Plane At An Angle	135
Step 3: Machine The Face	136
1. Select The Toolpath	136
2. Set Tool	136
3. Set Cut Parameters	136
4. Set Depth Cuts	136
5. Set Linking Parameters	136
6. Backplot The Toolpath	137
Step 4: Drill The 3/8" Hole	137
1. Select The Toolpath	137
2. Set Tool	137
3. Set Cut Parameters	137
4. Set Linking Parameters	137
5. Set Tip Comp	138
6. Set Up The Stock	138
7. Verify The Toolpaths	138
Step 5: Circle Mill The 0.75" Hole	138

1. Select The Toolpath	138
2. Set Tool	138
3. Set Cut Parameters	138
4. Set Transitions	139
5. Set Depth Cuts	139
6. Set Linking Parameters	139
7. Verify The Toolpaths	139
Step 6: Setup The Right Side Plane	139
Step 7: Machine The Right Side Slot	141
1. Select The Toolpath	141
2. Set Tool	141
3. Set Cut Parameters	141
4. Set Rough/Finish	141
5. Set Depth Cuts	141
6. Set Linking Parameters	141
7. Verify The Toolpaths	142
Step 8: Setup The Left Side Plane	142
Step 9: Machine The Left Side Slot	143
1. Select The Toolpath	143
2. Set Tool	143
3. Set Cut Parameters	143
4. Set Depth Cuts	143
5. Set Linking Parameters	143
6. Verify The Toolpaths	144
Step 10: Setup The Front Plane	144
Step 11: Machine The Front Boss	145
1. Select The Toolpath	145

2. Set Tool	147
3. Set Cut Parameters	147
4. Set Entry Motion	147
5. Set Linking Parameters	147
6. Verify The Toolpaths	148
Step 12: Machine The Front Pocket	148
1. Select The Toolpath	148
2. Set Toolpath Type	148
3. Set Tool	148
4. Set Cut Parameters	148
5. Set Linking Parameters	149
6. Verify The Toolpaths	149
7. Drill The 1/4" Holes To 0.625" Depth	149
8. Following The Same Steps As Shown And Machine The Back Face.	150
Legacy Multiaxis Introduction	151
Introduction:	152
Legacy 5-Axis Toolpaths	160
Curve - 5 Axis	160
Drill & Circle Mill - 5 Axis	160
Swarf 5 Axis Toolpath	160
Flow - 5 Axis Toolpath	160
Multisurface	160
Rotary	161
Introduction	162
Instructor Demonstration	165
Exercise 1: Rotary Toolpaths	166
1. Open File	166
Step 1: Machine The Cam Using A 4 Axis Rotary Toolpath With Rotary Cut	166

1. Select The Toolpath	166
2. Set Tool	166
3. Set Cut Pattern	167
4. Set Tool Axis Control	167
5. Set Linking Parameters	167
6. Backplot The Toolpath	168
Step 2: Machine The Cam Using A 4 Axis Rotary Toolpath WITH Axial Cut	168
1. Set Cut Pattern	169
2. Set Tool Axis Control	169
3. Backplot The Toolpath	170
4. Regenerate The Toolpath	170
5. Backplot The Toolpath Again	170
Exercise 2: Axis Rotary Toolpath - Axial Dampening	171
Step 1: Locate Part Geometry	171
1. Open File	171
Step 2: Axis Dampening Length = 0.002.	171
1. Select The Toolpath	171
2. Set Tool	171
3. Set Cut Pattern	172
4. Set Tool Axis Control	172
5. Set Linking Parameters	172
6. Backplot The Toolpath In The Right Side View And Zoom In On The Sharp Corner	172
7. Copy The Operation And Change The Axis Dampening Length To 0.2	173
8. Regenerate The Toolpath	173
9. Backplot The Toolpath From The Right Side View And Zoom In On The Sharp Corner	173
10. Copy The Last Operation And Change The Axis Dampening Length To 2.0	173
11. Regenerate The Toolpath	173

12. Backplot The Toolpath From The Right Side View And Zoom In On The Sharp Corner	173
Curve 5-Axis	175
Introduction:	176
Instructor Demonstration Preview:	177
Exercise 1: Curve Type - 3D Curves	178
1. Open File	178
Step 1: Create A Curve Toolpath Selecting A 3D Curve	178
Exercise 2: Curve Type - Surface Edge Single	184
1. Open File	184
Step 1: Create A Curve Toolpath Selecting An Edge	184
Exercise 3: Curve Type - Surface Edge All	188
1. Open File	188
Step 1: Create A Curve Toolpath At All Edges Of A Surface	188
Exercise 4: Tool Axis Control - Lines	191
1. Open File	191
Step 1: Curve Toolpath With Tool Axis Control To Lines	191
Exercise 5: Tool Axis Control - Plane	195
1. Open File	195
Step 1: Curve Toolpath Tool Axis Control Towards A Plane	195
Exercise 6: Tool Axis Control - From Point	197
1. Open File	197
Step 1: Curve Toolpath With Tool Axis Control From A Point	197
Exercise 7: Tool Axis Control - To Point	200
1. Open File	200
Step 1: Curve Toolpath With Tool Axis Control Set To A Point	200
Exercise 8: Tool Axis Control - Chain	208
1. Open File	208
Step 1: Curve Toolpath With Tool Axis Control Set From A Chain	208

2. Regenerate The Toolpath	212
3. Backplot The Toolpath	212
Exercise 9: Curve 5 Axis - Output Format	213
1. Open File	213
Step 1: Output Format Set To 3 Axis	213
Step 2: Output Format Set To 4 Axis	215
Step 3: Output Format Set To 5 Axis	216
Exercise 10: Curve - Tip Control	217
1. Open File	217
Step 1: Tip Control On Selected Curve	217
Step 2: Tip Control Set To Comp To Surface	218
Exercise 11: Curve 5 Axis - Projection Type	219
1. Open File	219
Step 1: Projection Set To Normal To Plane	219
Step 2: Projection Set To Normal To Surface	221
Exercise 12: Curve 5 Axis - Review	222
1. Open File	222
Step 1: Create A Stock Model	222
Step 2: Curve And Tool Axis Control Lines	222
Step 3: Curve Tool Axis Control Surface & 4 Axis Output Format	224
Step 4: Curve Tool Axis Control Plane	224
Step 5: Curve Tool Axis Control From Point	225
Step 6: Curve Surface Edge Using Tool Axis Control To Point	226
Drill 5-Axis	229
Introduction	230
Instructor Demonstration:	231
Exercise 1: Drill - Entity Type Points - Tool Axis Control - Surface	232

1. Open File	232
Step 1: Drill 5 Axis By Selecting The Geometry As Points	232
Excercise 2: Drill 5 Axis - Entity Type Lines & Holes	234
1. Open File	234
Step 1: Create The Lines For Drilling From Surfaces	234
Step 2: Drill The Through Holes Using The Lines As Geometry	237
Step 3: Circle Mill 5 Axis - Geometry Type Hole	239
Exercise 3: Drill 5 Axis - Geometry	242
1. Open File	242
Step 1: Create The Lines And The Points For Tool Axis Control	242
Step 2: Drill The Holes	244
Exercise 4: Drill 5 Axis - Tool Axis Control - Plane	247
1. Open File	247
Step 1: Drill The 0.25" Diameter Holes With The Tool Axis Control Towards A Plane	247
Step 2: Drill The 1.5" Diameter Hole Tool Axis Control Plane	249
Exercise 5: Circle Mill 5 Axis - Tool Axis Control To Plane	252
Step 1: Circle Mill With The Tool Axis Control Plane	252
Swarf 5-Axis	257
Introduction	258
Instructor Demonstration	259
Exercise 1: Swarf 5 Axis - Walls Defined By Surfaces; Output Format 4 Axis	260
1. Open File	260
Step 1: Swarf 5 Axis With The Output Format Set To 4 Axis	260
Exercise 2: Swarf 5 Axis - Walls Defined By Chains	265
1. Open File	265
Step 1: Swarf 5 Axis With The Output Format Set To 5 Axis	265
Exercise 3: Swarf - Surface Walls; Output Format 5 Axis	269
1. Open File	269

Step 1: Swarf 5 Axis With Output Format Set To 5 Axis	270
Step 2: Using Multi Passes To Machine The Walls	272
Exercise 4: Swarf 5 Axis - Walls Defined By Chains	273
1. Open File	273
Step 1: Create The Chains	273
Step 2: Swarf Toolpath With Walls Defined By Two Chains	276
Exercise 5: Swarf - Tip Control To The Lower Rail	279
1. Open File	279
Step 1: Swarf 5 Axis With Tip Control Set To Lower Rail	279
Flow 5-Axis	283
Introduction	284
Instructor Demonstration:	285
Exercise: Flow 5 Axis - Tool Axis Control Limits	286
Step 1: Without Axis Limits	286
Step 2: USE Axis Limits And Delete Motion That Exceeds Limits	290
Step 3: USE Axis Limits And Modify Motion That Exceeds Limits	291
Step 4: Flow 5 Axis - Tool Axis Control Boundary	293
Multisurface	295
Introduction	296
Instructor Demonstration:	298
Exercise: Multisurface - Cut Pattern	299
1. Open File	299
Step 1: Finish The Part Using MultiSurface	299
Step 2: Rough Out The Part Using MULTISurFACE	303
Step 3: Define The Stock In The Stock Setup Using The Solid From Level 11	304
Deburr	305
Introduction	306

Instructor Demonstration:	307
Exercise: Deburr	308
1. Open File	308
Step 1: Select The Machine And Set Up The Stock	308
Step 2: 3 Axis Deburr	309
Step 3: 3 + 2 Deburr Toolpath	316
Step 4: 5-Axis Deburr Toolpath	320
Advanced Multiaxis Intro	325
Advanced 5-Axis Toolpaths	326
Swarf Milling	326
Parallel	326
Along Curve	326
Morph	327
Triangular Mesh	327
Rotary Advanced	327
Project Curves	327
Exercise 1: Cut Patterns	329
Step 1: Parallel To Angle Pattern	330
Step 2: Parallel To Surfaces Pattern	332
Step 3: Parallel To Curves Pattern	333
Step 4: Morph Between 2 Surfaces Pattern	334
Step 5: Morph Between 2 Curves Toolpath	337
Exercise 2: Area Settings	340
Step 1: Parallel Toolpath	341
Step 2: Round Corners	342
Step 3: Extend / Trim	343
Step 4: Containment	345
Step 6: Angle Range	346

Exercise 3: Sorting	348
Step 1: Machine By Region	349
Step 2: Flip Step Over	351
Step 3: Machine By Lanes	352
Step 4: Cut Order - From Center Away	353
Step 5: Cut Order - From Outside To Center	354
Exercise 4: Tool Axis Control - Side Tilt Definition	355
Step 1: Follow Surface Iso	356
Step 2: Ortho To Lower Edge Curves	358
Step 3: Ortho To Cut Direction At Each Position	359
Step 4: Ortho To Cut Direction At Each Contour	360
Step 5: Use Spindle Main Direction	361
Step 6: Use User Defined Direction	362
Step 7: Use Tilt Line Definition	363
Exercise 5: Collision Control	364
Step 1: No Collision Control	365
Step 2: Retracting Tool Along Tool Axis	367
Step 3: Retract Tool Along Surface Normal	368
Step 4: Tilt Tool Using Side Tilt Angle	369
Step 5: Trim And Relink Toolpath	370
Projection	373
Introduction	374
Instructor Demonstration	375
Exercise 1: Projection Toolpath	376
1. Open File	376
Step 1: Engrave The Letters Using Project Curve	376
Parallel To Cuts	381

Introduction	382
Instructor Demonstration	383
Exercise 2: Parallel To Angle Toolpath	384
Step 1: Finish The Camshaft Using A Parallel Cuts Toolpath	384
Swarf Milling	391
Introduction	392
Instructor Demonstration	393
Exercise 1: Swarf Milling	394
Step 1: Setup The Stock	394
Step 2: Use Pocket Toolpath To Machine The Inside Cutout	395
Step 3: Use Pocket Toolpath To Machine The Open Cutout	397
Step 4: Machine The Walls Using Swarf Milling	401
Exercise 2: Swarf Milling	406
Step 1: Create A Stock Model Toolpath	406
Step 2: Machine The Walls Using Swarf Milling	408
Parallel To Curves Toolpath	412
Step 3: Finish The Fillet Surfaces Using Parallel To Curves Toolpath	412
Create An Stl File In Verify	416
Step 4: Machine Simulation	417
Parallel To Curve & Morph To Curves	423
Introduction	424
Instructor Demonstration	425
Exercise 5: Parallel Cuts Toolpath	426
Step 1: Finish The Blade Surfaces Using Parallel To Angle	426
Morph Between 2 Curves Toolpath	430
Step 2: Finish The Blade Surfaces Using Morph Between 2 Curves	430
Step 3: Spiral Cutting Method And Set The Margins	434
Step 4: Output Format To 5 Axis & Gradual Side Tilt Angle	436

Parallel To Curves Review	437
Step 5: Finish The Left Side Using Parallel To Curves	437
1. Set Tool Axis Control	439
Step 6: Finish The Right Side End Of The Blade	441
Propeller & Morph Two Curves	443
Introduction	444
Instructor Demonstration	445
Exercise 6: Machine The Propeller -Swarf Milling & Morph	446
Step 1: Setup Stock	446
Step 2: Rough Out The Part Using 2D HS Dynamic	447
Step 3: Machine The Walls Using Swarf Milling	450
Morph Between 2 Curves Toolpath	454
Step 4: Finish The Blade Surfaces Using Morph Between 2 Curves	454
Advanced Rough	459
Introduction	460
Instructor Demonstration	461
Exercise: Advanced Rough	462
Step 1: Rough Out The Part Using Rotary Advanced Toolpath	462
Finish The Floor Using Morph Between 2 Curves	467
Step 2: Finish The Floor Using Morph With Pattern From Curves	467
Machine The Fillet Surfaces Using Parallel To Curves	471
Step 3: Parallel To Curves To Machine The Left Fillet Surface	471
Step 4: Parallel To Curves To Machine The Right Fillet Surface	474
Step 5: Simulator Settings	475
Surface High Speed Scallop	476
Step 6: Cleaning The End Of The Helical Ridge Using Surface High Speed Scallop	476
Gouge Check	479

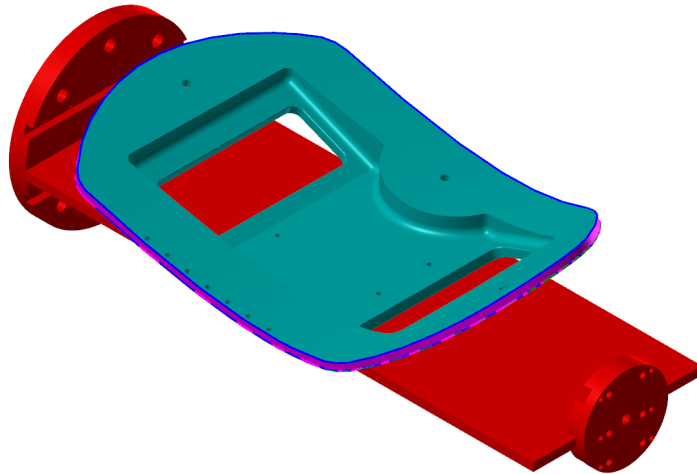
Introduction	480
Instructor Demonstration	481
Exercise: Gouge Check Exercise	482
Step 1: Create The Parallel To Curves Toolpath Without Collision Control	482
Step 2: Tilt Tool Away With Max Angle	486
Step 3: Smooth The Transition At The Sharp Edge	488
Step 4: Set The Linking Parameters To Keep The Tool Down Along The Toolpath	489
Step 5: Collision Control - Retract Tool Along Tool Axis	490
Step 6: Retract Tool Along +Z	491
Step 7: Machine The Entire Surface	492
Worm Gear	495
Introduction	496
Instructor Demonstration	497
Exercise: WORM GEAR	498
1. Open File	498
Morph To Curves With No Tilt Axis	498
Step 1: Rough The Area Between Two Blades	498
Step 2: Finish The Area Between Two Blades Using Morph To Curves With No Tilt Axis	503
Parallel To Curves With Tilt Set To Lines	504
Step 3: Semifinish The Blade In A Swarf Manner Using Parallel To Curves	504
Morph To Curves With Tilt Angle	510
Step 4: Finish The Blade Using Morph Between 2 Curves	510
Parallel To Surface Toolpath	514
Step 5: Finish The The Filletusing Parallel To Surface	514
Surface High Speed Scallop	519
Step 6: Clean The Back Of The Blade	519
Step 7: Clean The Front Of The Blade	521
Machine The Entire Part	523

Step 8: Use Transform - Rotate To Complete The Entire Part	523
Port Expert	529
Introduction	530
Instructor Demonstration	531
Exercise 10: Port Expert Toolpath	532
1. Open File	532
Step 1: Instructions On How To Create A Spine Curve	532
Step 2: Rough Out The Port Using A Port Expert Toolpath	535
Step 3: Finish The Port Using A Port Expert Toolpath	539
3 Axis To 5 Axis Toolpath	541
Introduction	542
Instructor Demonstration	543
Exercise 11: 3 Axis To 5 Axis Toolpath	544
Step 1: Surface High Speed Waterline Toolpath With Trim To Avoid Gouge	544
Step 2: Surface High Speed Waterline Toolpath With Tilt To Avoid Gouge	548
Multiaxis Rough	549
Introduction	550
Instructor Demonstration	551
Multiaxis Roughing Toolpath	552
Step 1: Setup The Stock Using The Solid On Level 55	552
Step 2: Rough Out The Part Using A Roughing Toolpath	553
Step 3: Rest Roughing The Part Using Multiaxis Roughing	557
Step 4: Finish The Part Floor Using Multiaxis Roughing	559
Step 5: Finish The Part Walls Using Swarf Milling	561
Use Surface High Speed Scallop To Clean The Island	564
Step 6: Clean The Island Top With SHS Scallop Toolpath	564
Multiaxis Review	569

Introduction	570
Instructor Demonstration	571
Exercise: Multiaxis - Review	572
1. Open File	572
Step 1: Use Transform Dynamic To Orient The Part	573
Step 2: Create A Stock Using Model Prep Options	574
Step 3: Setup The Tool Settings And The Stock Setup	577
Step 4: Create Pocket Surfaces Using From Solid Command	578
Step 5: Create Curves At The Top Edges Of The Pocket	579
Step 6: Rough The Pocket Using Multiaxis Roughing	580
Step 7: Finish The Pocket Floor Using 2D HS Area Mill	582
Step 8: Machine The Pocket Walls Using Swarf 5 Axis	585
Step 9: Machine The Rest Of The Pockets Using Transform - Mirror	592
Step 10: Drill The 0.3975 Diameter Holes	596
Step 11: Circle Mill The 0.8125 Diameter Holes	601
Step 12: Rough The Channel Using Morph Between 2 Curves	606
Step 13: Finish The Channel Floor Using Morph Between 2 Curves	611
Step 14: Machine The Upper ChaNnel Wall Using Swarf Milling	611
Step 15: Machine The Lower ChaNnel Wall Using Swarf Milling	614
Step 16: Machine The Lower Fillet Surface Using Parallel To Curves	616
Step 17: Machine The Upper Fillet Surface Using Parallel To Curves	618
Step 18: Create A Stock Model	619
Accelerated Finish	623
Introduction	624
Instructor Demonstration	626
Exercise: Accelerated Finish Using Barrel Tools	627
Step 1: Create A Stock Model For A Casting Part	627
Step 2: Surface High Speed Horizontal	629

Step 3: Parallel To Curve	631
Step 4: Parallel To Surface	638
Morph Between Two Curves	640
Step 5: Finish The Walls Using Morph Between 2 Curves	640
Step 6: Morph Between Two Surface	644
Impeller Parallel Surf	647
Introduction	648
Instructor Demonstration	649
Exercise 7: Machine The Impeller Floor With A MorPh Toolpath	650
1. Open File	650
Step 1: Rough Out The Area Between Two Blades Using Morph Between 2 Surfaces	650
Step 2: Finish The Impeller Floor	657
Machine The Impeller Blade Using A Parallel To Curves	659
Step 1: Parallel To Curves	659
2. Set Tool Axis Control	662
Parallel To SurfaceS Toolpath	664
Step 3: Finish The Area Between The Floor And The Fillet	664
Step 4: Transform - Rotate	668
Step 5: Transform Rotate The Second And Third Toolpaths (finish Floor And Sides Of Blade)	670
Step 6: Transform Rotate Last Two Toolpaths (Finish Floor And Fillet)	672

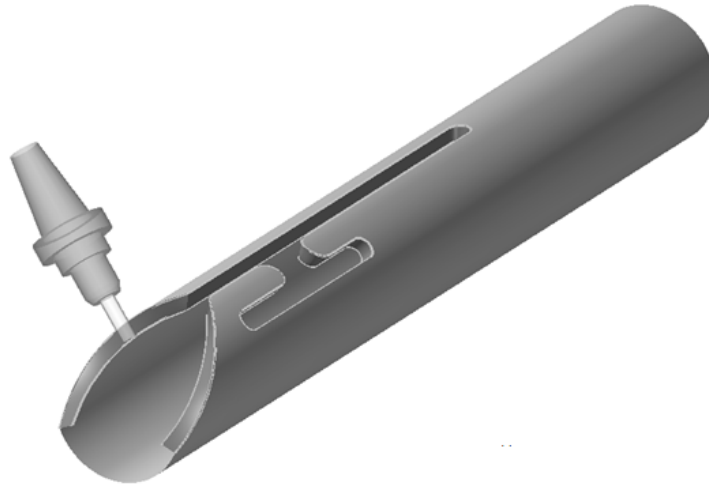
Swarf 5-Axis



INTRODUCTION

The purpose of this section is to introduce you to Swarf Milling machining; machining walls along curves with the side of the cutter.

Swarf (Side Wall Axial Relief Feed) toolpaths allows you to machine the wall surfaces with the side of the tool. This type of milling is common in the aerospace industry where part walls are tapered for increased strength and low weight as shown.



Some parts that can be machined using three axes mill and surface toolpaths can be machined much more efficiently using Swarf toolpaths since the Swarf toolpath can reduce the number of machining setups and cut passes.

OVERVIEW OF EXERCISE:

In this lesson you will machine the part shown by first using the Contour Toolpath with multiple passes to machine the two steps. You will compare this toolpath with the Peel Mill Toolpath.

You will machine the slots using Contour - Ramp Toolpath.

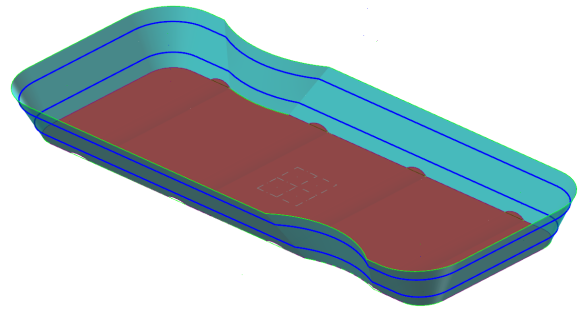
NEW CONCEPTS COVERED IN THIS TUTORIAL:

- ◆ Swarf 5 axis - Walls defined by surfaces; floor defined by surfaces; output format 4 axis.
- ◆ Swarf 5 axis - Walls defined by surfaces; floor defined by surfaces; output format 5 axis.
- ◆ Swarf - Walls defined by chains; Tip control to lower rail; output format 4 axis.

INSTRUCTOR DEMONSTRATION

Topics:

- ◆ Swarf 5 axis - Walls set to surfaces; floor defined by surfaces; output format 4 axis.
- ◆ Swarf 5 axis - Walls set to surfaces; floor defined by surfaces; output format 5 axis.
- ◆ Swarf - Walls set to chains; floor defined by surfaces; output format 5 axis.
- ◆ Swarf - Walls set to chains; floor defined by lower rail; output format 4 axis.



NOTES:

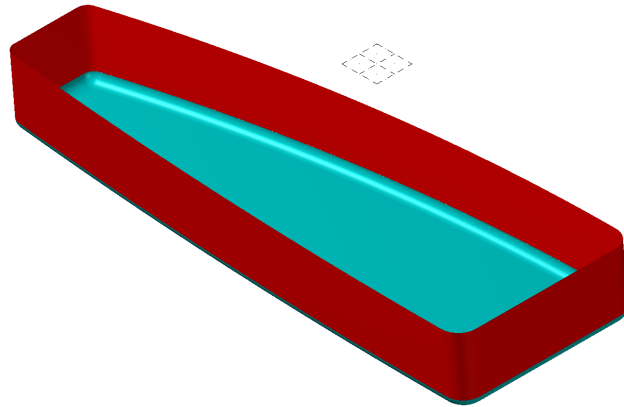
EXERCISE 1: SWARF 5 AXIS - WALLS DEFINED BY SURFACES; OUTPUT FORMAT 4 AXIS

Swarf 5-axis can create a 4-axis or 5-axis toolpaths along a wall defined by surfaces or two chains.

Resources -Download the file from <http://www.emastercam.com/trainingfiles>

1. Open File

- ◆ From the **QAT**, select the **Open** icon.
- ◆ Select **SWARF OUTPUT FORMAT 4 AXIS.MCAM**.

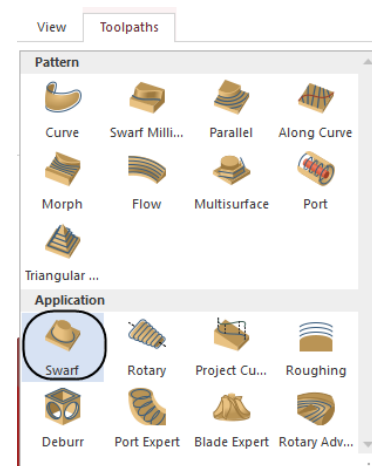


STEP 1: SWARF 5 AXIS WITH THE OUTPUT FORMAT SET TO 4 AXIS

1.1 Select The Toolpath

Toolpaths

- ◆ From the **Multiaxis** group, select the **Expand gallery** arrow and from the **Application** family select **Swarf**.



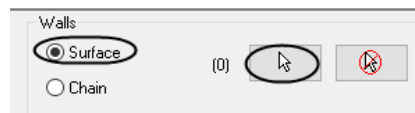
1.2 Tool

- ◆ Select the **1.0" Bull Endmill** with a **Corner radius** of **0.25"**.

1.3 Cut Pattern

The **Cut Pattern** page allows you to select the wall geometry using Surface or Chains. It also allows you to set the compensation type and direction, maximum step, cut tolerance and starting location for closed walls.

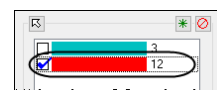
- ◆ **Walls** set to **Surface**.
- ◆ Click on the **Select** button.



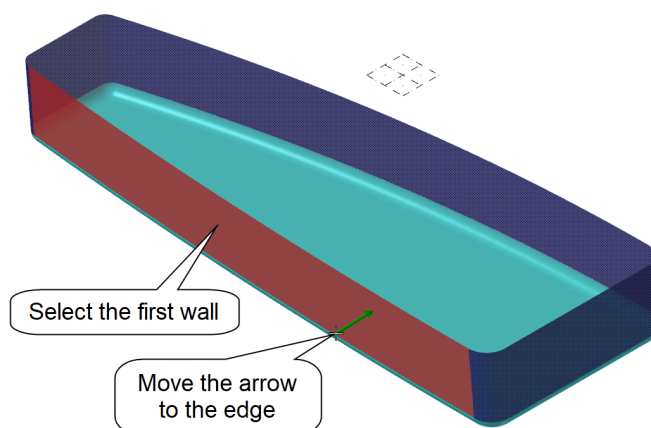
- ◆ From the **QM** buttons, click on the left half of the **Select all entities by color** button.



- ◆ Select the red color.



- ◆ Select the **first wall** and move the arrow to the lower edge of the wall.
- ◆ The **chain direction** should be **CW**, otherwise **Reverse Direction**.



- ◆ **Cutting method** set to **One Way**.
- ◆ **Compensation type** set to **Computer**.
- ◆ **Compensation direction** set to **Right**.
- ◆ **Stock to leave on walls** = **0.0**.
- ◆ **Distance** = **0.1**.
- ◆ **Cut tolerance** = **0.001**.
- ◆ **Enable Enter at middle of first wall**.

1.4 Tool Axis Control

Tool Axis Control settings determine the tool's orientation in relation to the geometry being cut.

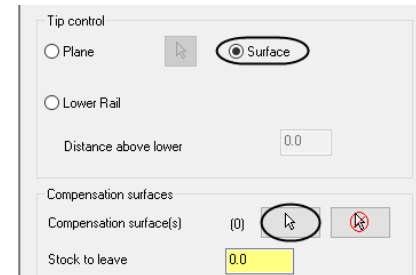
They allow you to set the output format, fanning, angle increment, and minimize the tool movement when cutting corners.

- ◆ **Output format** set to **4 axis**.
- ◆ **Rotary axis** set to **X axis**.
- ◆ **Enable Minimize corners in toolpath** to remove vectors immediately before and after any corner in the toolpath.

1.5 Collision Control

The **Collision Control** page allows you to set the collision control parameters for the **Swarf** toolpath. Collision control settings determine the tip compensation, establish the check and compensation surface behavior, and set the gouge process settings. The tip compensation can be set to a plane, to surfaces or to the lower rail.

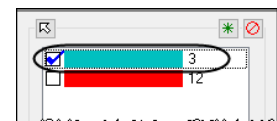
- ◆ **Tip control** set to **Surface**.
- ◆ From the **Compensation surfaces** area, click on the **Select** button.



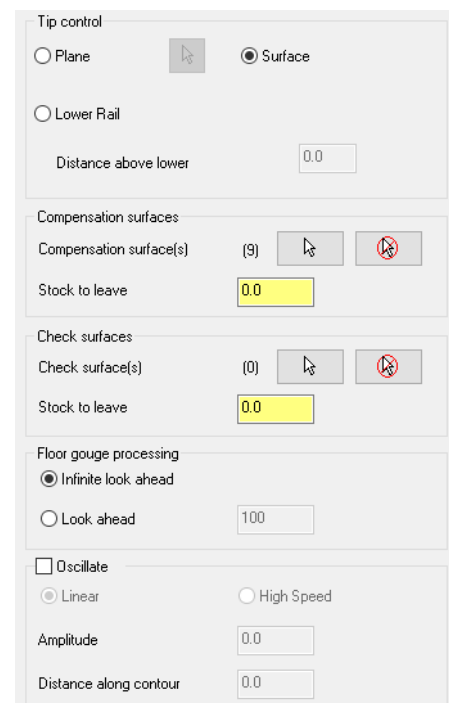
- ◆ From the **QM** buttons click on the **Select all entities by color** left half button.



- ◆ Select all blue colored surfaces.



- ◆ No check surfaces are required.
- ◆ Enable **Look ahead 100** to evaluate ahead of the tool position.



1.6 Linking

Linking sets the links between the cutting passes. In general, you can think of linking moves as air moves when the tool is not in contact with the part.

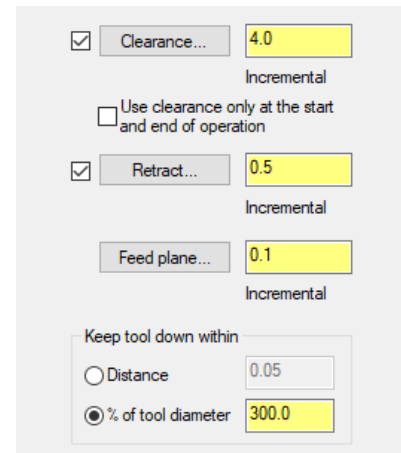
Clearance sets the height at which the tool moves to and from the part.

Retract sets the height that the tool moves up to before the next tool pass.

Feed plane sets the height that the tool rapids to before changing to the plunge rate to enter the part. The tool also moves to this height between operations if you do not enter both the clearance height and the retract height.

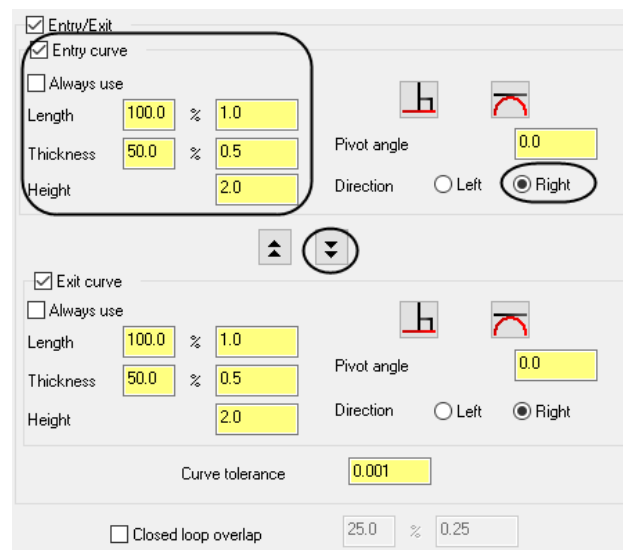
Keep tool down instructs Mastercam not to create a retract move if the distance from the end of one pass to the start of the next pass is less than this value. The tool will move directly between the passes at the feed rate.

- ◆ Clearance = 4.0.
- ◆ Retract = 0.5.
- ◆ Feed plane = 0.1.
- ◆ Keep tool down within = 300.



1.7 Entry/Exit

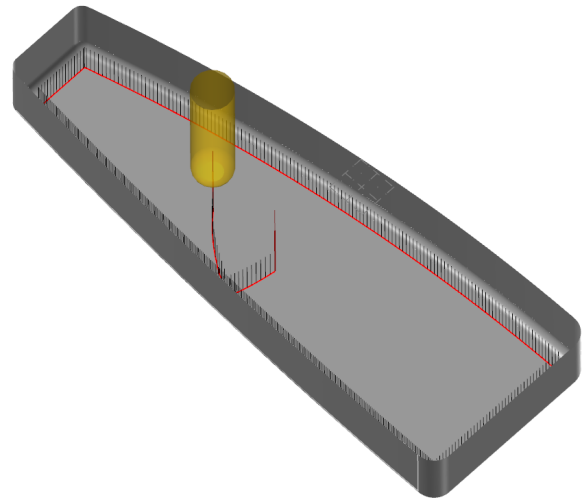
- ◆ Enable **Entry/Exit curve** and set the **Length** to 1.0, **Thickness** to 0.5, and **Height** to 2.0.
- ◆ Set the **Direction** to **Right**.



1.8 Roughing Disabled

- ◆ Select the **OK** button to generate the toolpath.

1.9 Backplot The Toolpath

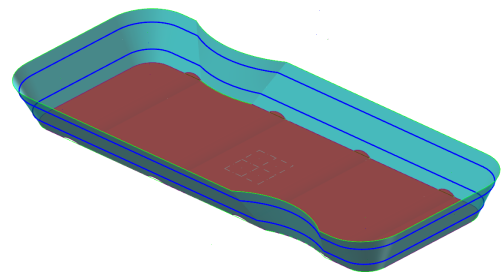


EXERCISE 2: SWARF 5 AXIS - WALLS DEFINED BY CHAINS

Resources -Download the file from <http://www.emastercam.com/trainingfiles>

1. Open File

- ◆ From the **QAT**, select the **Open** icon.
- ◆ Select **SWARF1.MCAM**.



STEP 1: SWARF 5 AXIS WITH THE OUTPUT FORMAT SET TO 5 AXIS

1.1 Select The Toolpath

Toolpaths

- ◆ From the **Multiaxis** group, select the **Expand gallery** arrow and from the **Application** family select **Swarf**.

1.2 Tool

- ◆ Select the **0.25" Bull Endmill** with a **Corner radius** of **0.03125"**.

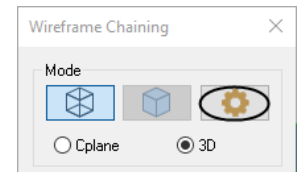
1.3 Cut Pattern

The **Cut Pattern** page allows you to select the wall geometry using Surface or Chains. It also allows you to set the compensation type and direction, maximum step, cut tolerance and starting location for closed walls.

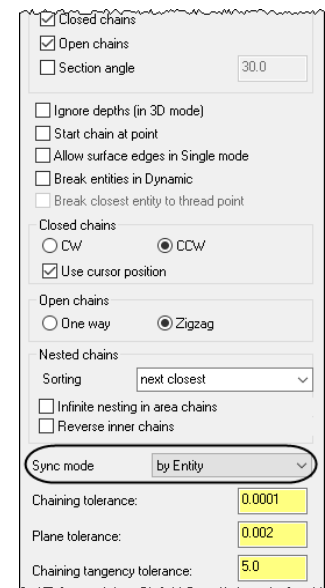
- ◆ **Walls** set to **Chain**.
- ◆ Click on the **Select** button.



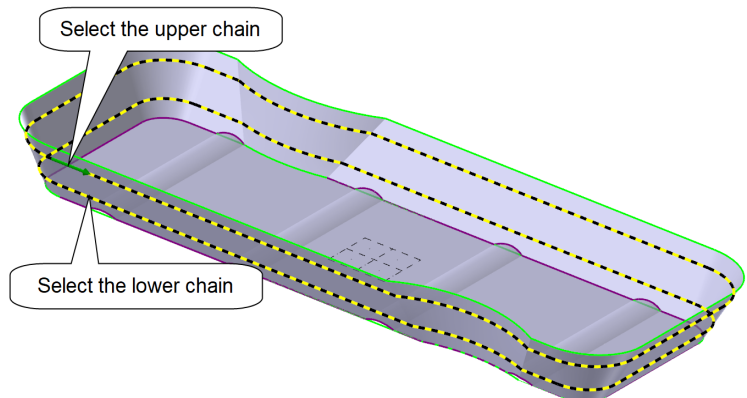
- ◆ In the **Wireframe Chaining** dialog box, click on the **Option** button.



- ◆ Set the **Sync mode** to **by Entity**.



- ◆ Select the lower contour in the **CCW** direction, otherwise **Reverse Direction**.
- ◆ Select the upper contour in the **CCW** direction. Make sure that the start point is aligned with the lower contour.



- ◆ **Cutting method** set to **One Way**.
- ◆ **Compensation type** set to **Computer**.
- ◆ **Compensation direction** set to **Left**.
- ◆ **Stock to leave on walls** = **0.0**.
- ◆ **Distance** = **0.1**.
- ◆ **Cut tolerance** = **0.001**.
- ◆ Enable **Enter at middle of first wall**.

Walls

☐ Surface (2) ☒ Chain

Cutting Method: One way

Compensation type: Computer

Compensation direction: Left

Tip compensation: Tip

Stock to leave on walls: 0.0

Diameter for simulation: 0.25

☐ Distance increment: 0.1

Wall following method

☒ Distance: 0.1

Cut tolerance: 0.001

Maximum step: 0.1

Closed walls

☒ Enter at middle of first wall

☐ Enter at start of first wall

☐ Use wall surface rulings

1.4 Tool Axis Control

Tool Axis Control settings determine the tool's orientation in relation to the geometry being cut.

They allow you to set the output format, fanning, angle increment, and minimize the tool movement when cutting corners.

- ◆ **Output format** set to **5 axis**.
- ◆ Enable **Minimize corners in toolpath** to remove vectors immediately before and after any corner in the toolpath.

1.5 Collision Control

The **Collision Control** page allows you to set the collision control parameters for the multiaxis swarf toolpath. Collision control settings determine the tip compensation, establish the check and compensation surface behavior, and set the gouge process settings. The tip compensation can be set to a plane, to surfaces or to the lower rail.

- ◆ **Tip control** set to **Surface**.
- ◆ From the **Compensation surfaces** area, click on the **Select** button.
- ◆ From the **QM** buttons click on the **Select all entities by color** left half button.
- ◆ Select the brown color.
- ◆ No check surfaces are required.
- ◆ Enable **Look ahead 100** to evaluate ahead of the tool position.



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Mastercam for SOLIDWORKS

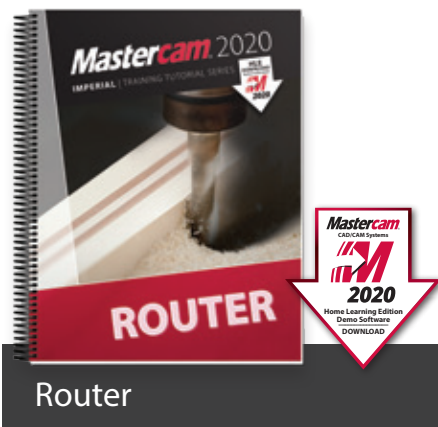
The Mastercam 2020 for SOLIDWORKS Programming Exercises book provides a comprehensive "hands on" method of learning Mastercam for SOLIDWORKS. You will learn how to program a variety of different parts that require most of the toolpath types available in Mastercam for SOLIDWORKS. Extensive emphasis is put on making parametric changes and toolpath updates to match the SOLIDWORKS model changes. Primary focus is on toolpath creation on SOLIDWORKS models.

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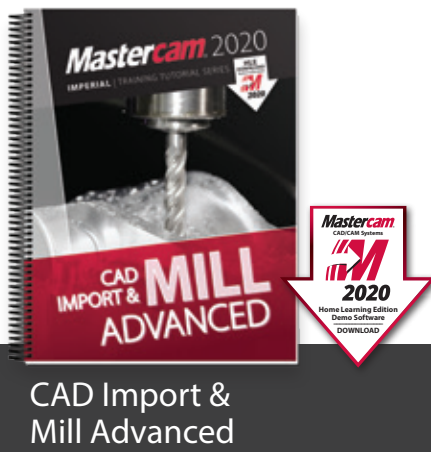
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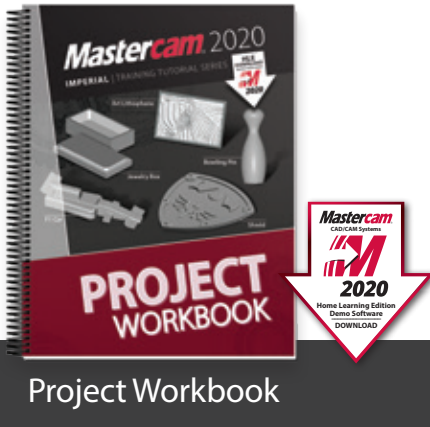
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Approximate completion time ranges from 7.5 to 15 hours depending on the eCourse, making it possible for employees or students to gain new skills outside of work or studies.

Highlights:

- Online previews with table of contents including the time it takes to complete each session.
- Mastercam 2020 Home Learning Edition Demo Software download is included so you can follow along with our instructors.
- Corresponding eBook is provided.
- Quizzes follow each tutorial.
- Personalized certificate of completion for each successfully completed eCourse.
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Mill Essentials eCourse

The Mill Essentials eCourse introduces students to 2D CAD and milling toolpaths. It covers wireframe and solids creation as well as 2D mill toolpaths such as contour, drilling, blend, peel, dynamic area, transform, Feature Based Drilling, and more. This course serves as an excellent introduction to Mastercam.



Mill Advanced eCourse

The Mill Advanced eCourse builds on what students have learned in the Mill Essentials eCourse. It moves into more advanced CAD and demonstrated 3D wireframe, solid, and surface creation commands. 3 axis toolpaths such as Area Roughing, Dynamic OptiRough, Scallop, Pencil, Waterline, Radial, Hybrid, and more are covered.



Lathe eCourse

The Mastercam Lathe eCourse covers wireframe creation, working with imported part files, stock setup, facing, roughing, finishing, grooving, drilling, and cutoff toolpaths. Stock operations such as advance, flip, and tailstock are also covered. You will also learn how to program parts in a VTL.



Multiaxis Essentials eCourse

The Multiaxis Essentials eCourse covers 4 & 5 axis toolpaths. Toolpaths include contour with axis substitution, drilling with axis substitution, drilling with rotary axis positioning, rotary 4-axis, curve 5-axis, swarf 5-axis, drill 5-axis, circle mill 5-axis, flow 5-axis, and multisurface 5-axis. This course skips most CAD in favor of focusing on toolpaths.

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PROFESSIONAL COURSEWARE

The Mastercam Professional Courseware titles are intended for industrial training settings. Instead of step-by-step instructions, these books introduce concepts through sequences of specialized training exercises followed by parts the users are expected to produce with minimal guidelines.



Professional Courseware Mill Essentials

The Mastercam 2020 Mill Essentials Professional Courseware provides in-depth coverage of 2D wireframes and solids geometry, as well as contour, pocket, drilling, circle milling and slot milling toolpaths. More advanced exercises explain the use of the Work Coordinate System (WCS), 2D high speed toolpaths, Feature Based Machining (FBM) and more.

Price \$60 (eBook)

ISBN: 978-1-77146-896-1

Price \$70 (Print)

ISBN: 978-1-77146-858-9



Professional Courseware Mill Advanced

The Mastercam 2020 Mill Advanced Professional Courseware covers a multitude of features that teach a user to create 3D wireframes, surfaces and solids for 3D modeling and toolpaths. Interactive training exercises introduce 3D geometry functionality, while newer surface high speed toolpaths are thoroughly investigated along with their various parameter settings.

Price \$50 (eBook)

ISBN: 978-1-77146-897-8

Price \$60 (Print)

ISBN: 978-1-77146-859-6



Professional Courseware Lathe

The Mastercam 2020 Lathe Professional Courseware offers an in-depth look at Mastercam Lathe geometry and toolpath creation. Advanced toolpaths such as Misc Ops and C-Axis toolpaths are also described. Additional Mastercam files are provided along with guidelines for creating the toolpaths to machine each part.

Price \$55 (eBook)

ISBN: 978-1-77146-898-5

Price \$65 (Print)

ISBN: 978-1-77146-860-2



Professional Courseware Multiaxis

The Mastercam 2020 Multiaxis Professional Courseware details numerous toolpaths that allow a user to successfully machine 4-axis and 5-axis parts. Multiaxis Advanced toolpaths have been included with more complex parts along with instructions on how to machine them. Machine Simulation is used to check for any collisions between the part, the tool and any of the machine's components.

Price \$65 (eBook)

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Price \$75 (Print)

ISBN: 978-1-77146-861-9

Join the eMastercam community!

eMastercam is one of the largest and oldest online forums for swapping knowledge of CNC machines, tools, manufacturing processes and technology. After hours, eMastercam continues to be a place for Machinists, Engineers and others in the manufacturing industry to connect, share stories, opinions and get to know each other beyond the parts we make and the tools we use.

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