

Gear Housing Tutorial

Table of Contents

Getting Started	1-2
Create the Contours	3
Step 1 - Create three circles	4-5
Step 2 - Create offsets	6
Step 3 - Create line	7-8
Step 4 - Create line	9-10
Step 5 - Create fillet	12-13
Step 6 - Create line	14-15
Step 7 - Create line	16-18
Step 8 - Create fillet	19-20
Step 9 - Create offsets	21-22
Step 10 - Create two circles	23-24
Step 11 - Create fillets	25-26
Step 12 - Trim contours	27-29
Step 13 - Connect contours	30-31
Step 14 - Create circle	32
Step 15 - Rotate circle	33-34
Step 16 - Trim contours	35-37
Step 17 - Connect contours	38-39
Step 18 - Rotate contour	40-41
Step 19 - Create circles	42-43
Step 20 - Create circles	44
Create the Toolpaths	45
Step 1 - Process plan	46
Step 2 - Set start point	47-48
Step 3 - Prepare for roughing	49-50
Step 4 - Rough outside profile	51-59
Step 5 - Rough counterbore	60-63
Step 6 - Rough bores	64-66
Step 7 - Rough inside	67-70
Step 8 - Finish outside profile	71-77
Step 9 - Finish bores	78-84
Step 10 - Finish counterbore	85-88

Step 11 - Finish inside	89-92
Step 12 - Machine radial slots	93-99
Step 13 - Spot drill holes	100-104
Step 14 - Drill holes	105-108
Step 15 - Drill holes	109-111
Step 16 - Create Material Stock	112-114
Step 17 - Solid Simulation	115-116
Step 18 - Output Nc code	117
Gear Housing Drawing	118

Gear Housing Tutorial

Getting Started

Getting Started

Before starting this Gear Housing tutorial you should print the accompanying drawing from the Learning Centre (<http://www.sharpcam.co.uk/Training-Centre.aspx>). Alternatively the drawing is also located at end of this tutorial.

Open a New Part

Create a new Part, depending on your settings SharpCam may have created a new Part on launch.

Menu: File -> New Part

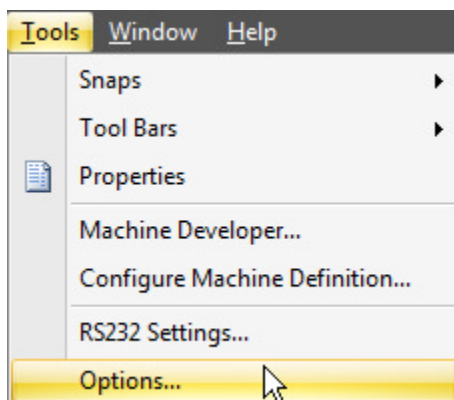
Toolbar button: 

Shortcut: Ctrl + N

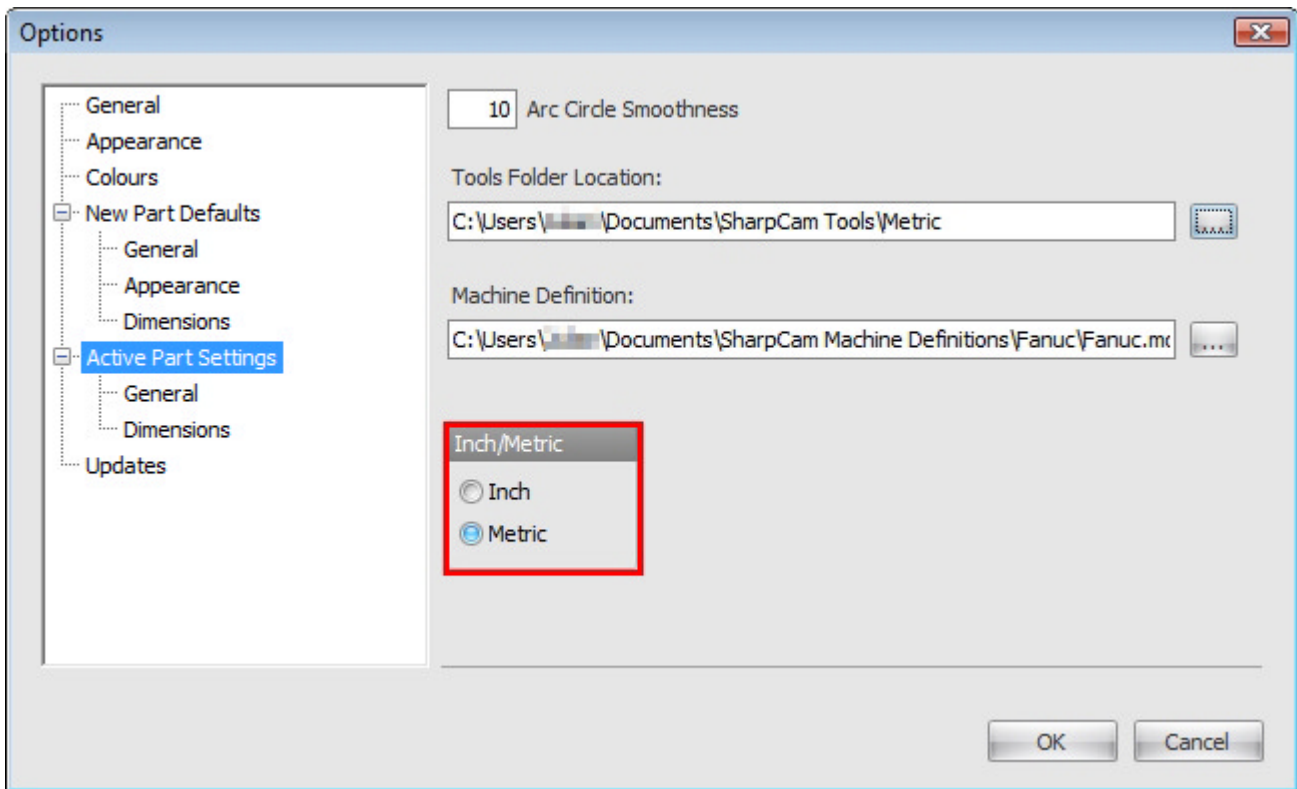
Units

Before starting it is important that the units are correct for the Part. When SharpCam was installed the default units would have been set for a new Part. It is also possible to set the units for an active Part. First check that the units are correct for the active Part:

Choose the Options... command from the Tools menu:



Select the Active Part Settings node and make sure that the Metric radio button is selected and click the OK button:



A confirmation message box will be shown if the units are changed, click OK to accept.

Other Settings

For this tutorial it is assumed that *Connection Markers* are displayed and *Axis Icon at Origin* is not active:



Snap Orthogonal and *Multi Snap* are being used:





Gear Housing Tutorial

Create the Contours


Step 1 - Create three circles

Before starting decide the origin for the Part. In SharpCam the origin is not actually set, the decision must be made where X0, Y0 is going to be located on the Part and create the Contours around this point.

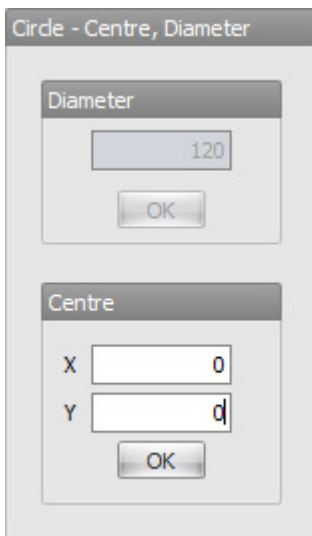
A logical place for X0, Y0 is the centre of the Ø120 circle.

Create three circles using Circle - Centre, Diameter

Menu: Draw -> Circle - Centre, Diameter

Toolbar button: 

Choose the command and create a Ø120 circle, centred at X0, Y0:



Circle - Centre, Diameter

Diameter

120

OK

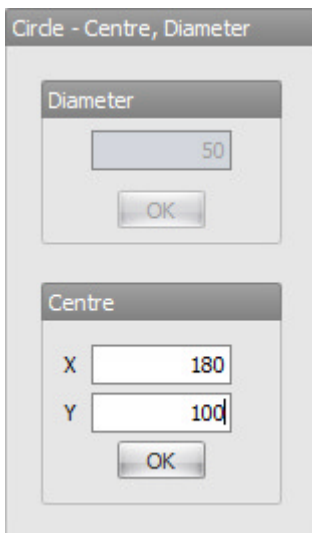
Centre

X 0

Y 0

OK

Create another circle Ø50 centred at X180, Y100:



Circle - Centre, Diameter

Diameter

50

OK

Centre

X 180

Y 100

OK

Create another circle Ø70 centred at X180, Y-45:

Gear Housing Tutorial

Circle - Centre, Diameter

Diameter

OK

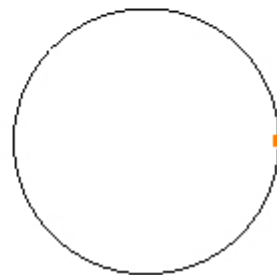
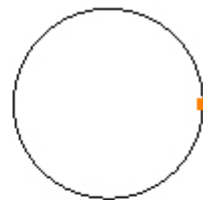
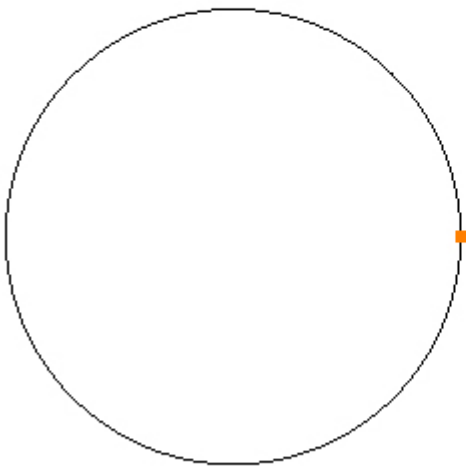
Centre

X

Y

OK


The Part should now look like this:



Step 2 - Create offsets

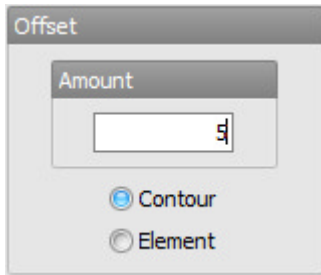
Create a 5mm offset on the outside of the 3 circles using Offset

Menu: Modify -> Offset

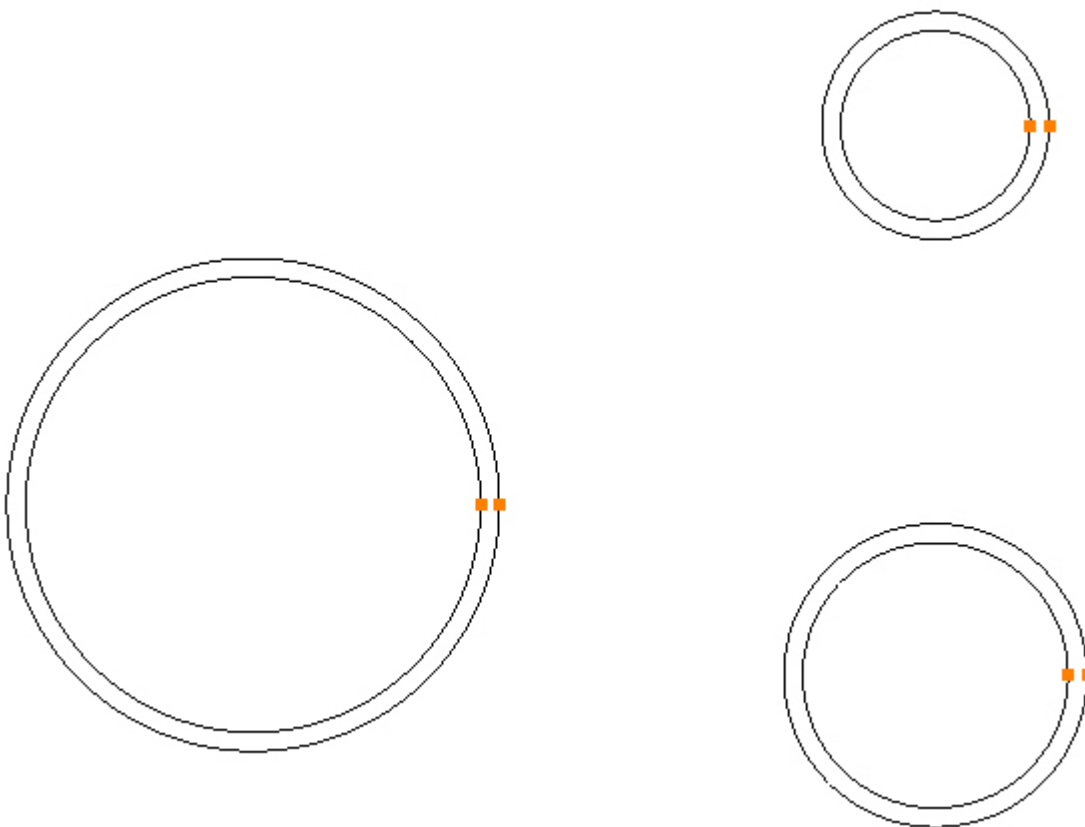
Toolbar button: 

Looking at the drawing it can be seen that there is a 5mm typical offset that applies to the circles previously created.

Select the command and enter 5 into the Amount box. It does not matter if *Contour* or *Element* is selected when offsetting from a circle:



Move the cursor over the $\varnothing 120$ circle and left mouse click to indicate that the offset is to be from this circle, then left click on the outside of the circle to create the offset; repeat for the $\varnothing 50$ and $\varnothing 70$ circles:




Gear Housing Tutorial

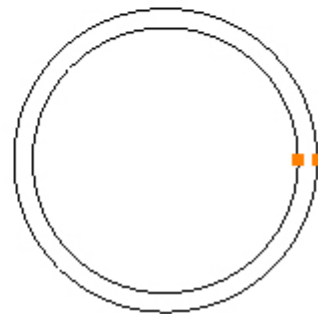
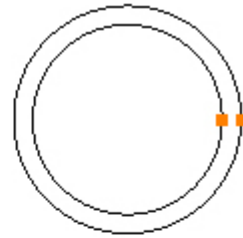
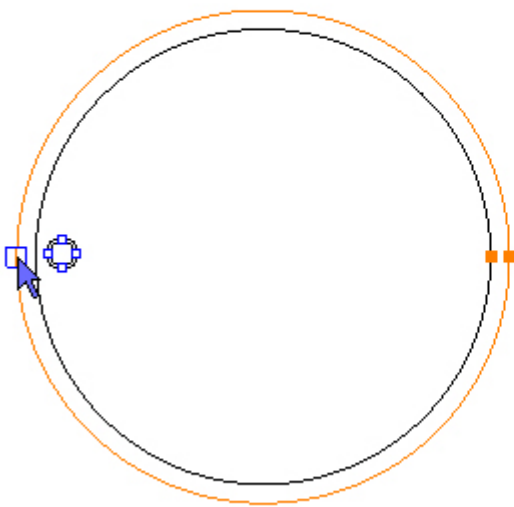
Step 3 - Create line

Create the left edge using Line

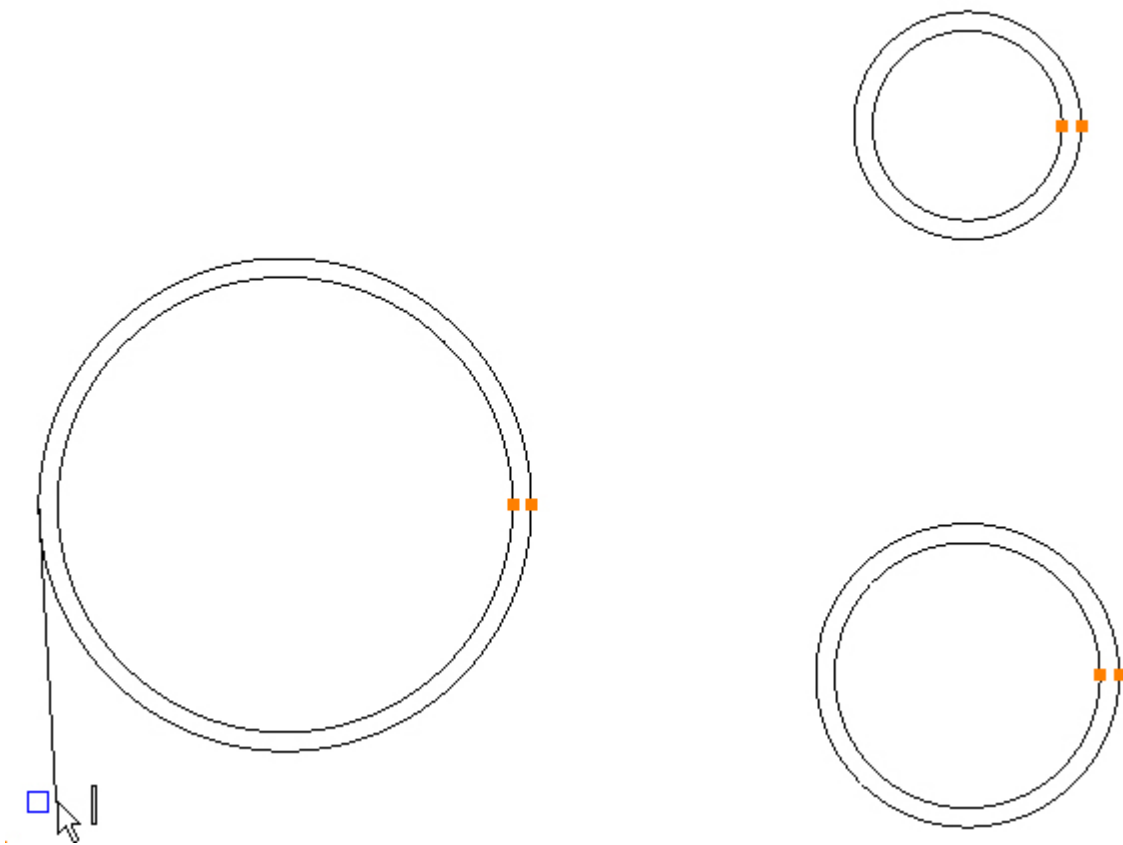
Menu: Draw -> Line

Toolbar button: 

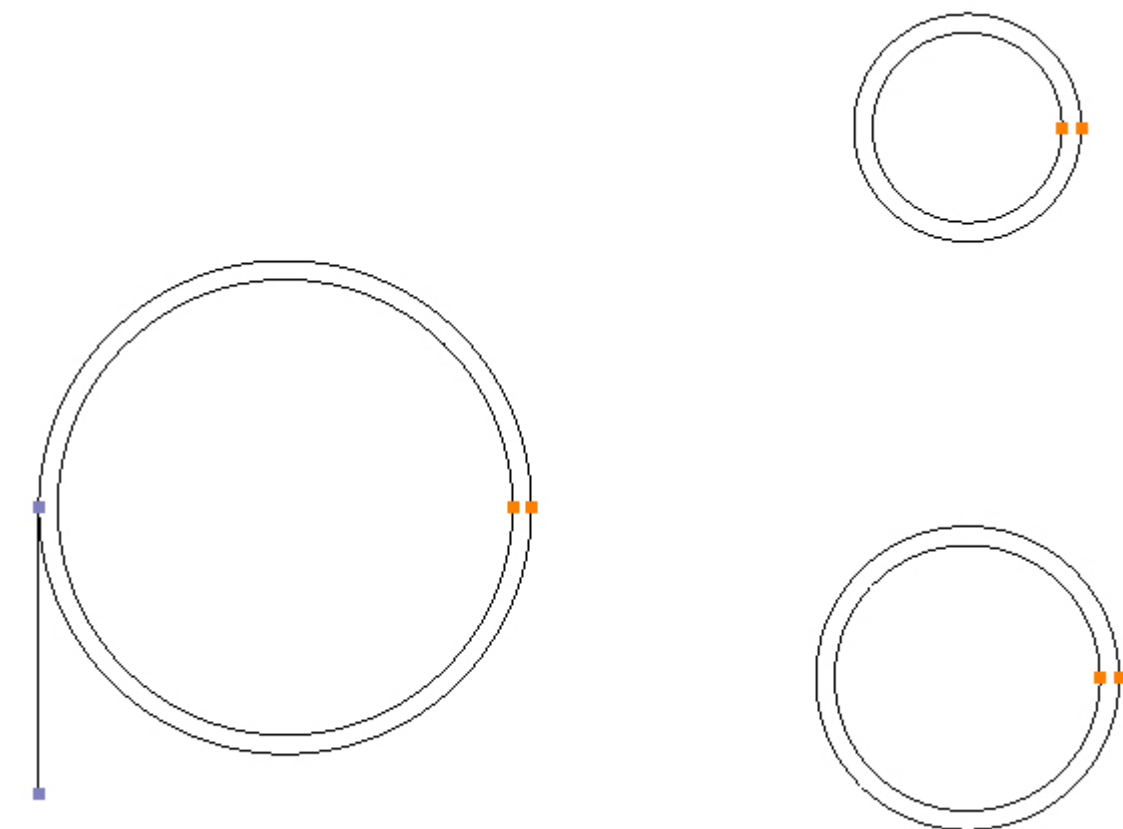
Choose the command and move the cursor near to the 9 o'clock position on the $\varnothing 130$ circle:



Snap the start point of the line to the quadrant point, the cursor is showing the Quadrant snap symbol and a blue Snap Marker indicates the Snap Point. Left click the mouse to accept the Snap Point and create the start of the line:



Move the cursor so it is below the start of the line, the cursor is showing the Vertical Orthogonal snap symbol and a blue Snap Marker indicates the Snap Point. This will ensure that the line is created vertically. Left click the mouse to accept the Snap Point and create the end of the line:




Gear Housing Tutorial

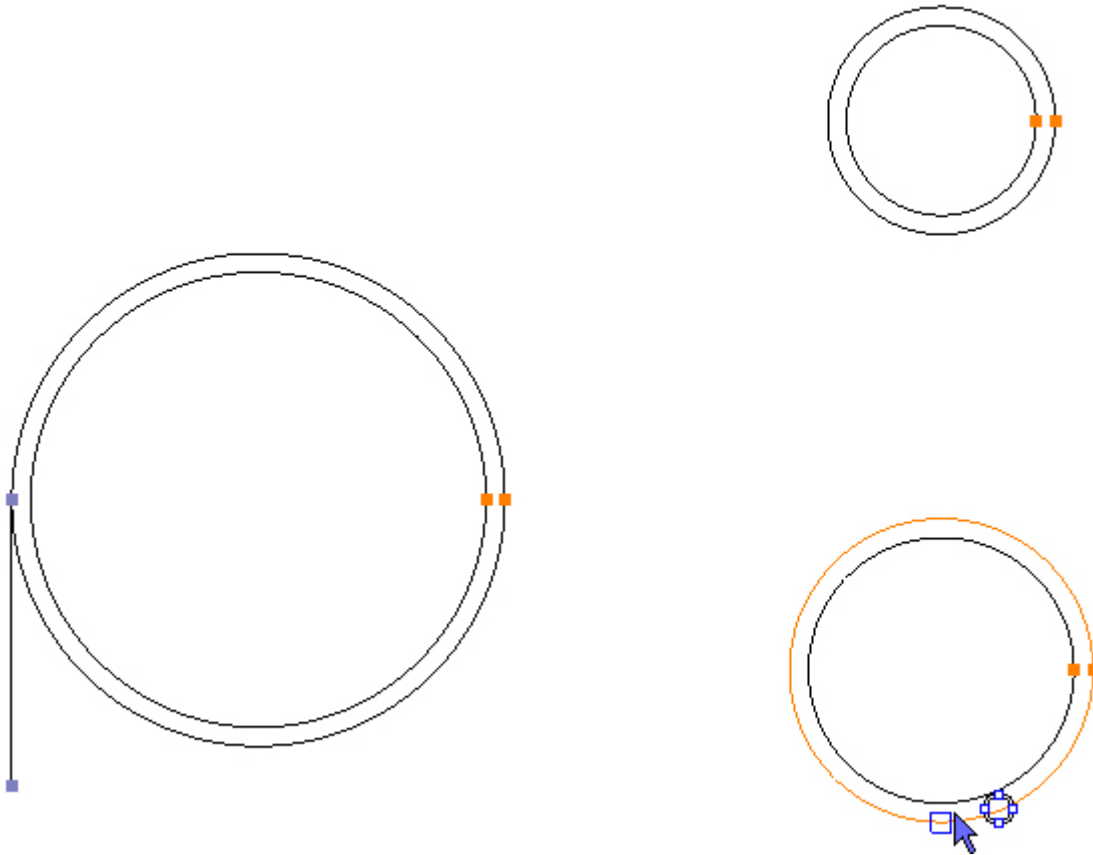
Step 4 - Create line

Create the bottom edge using Line

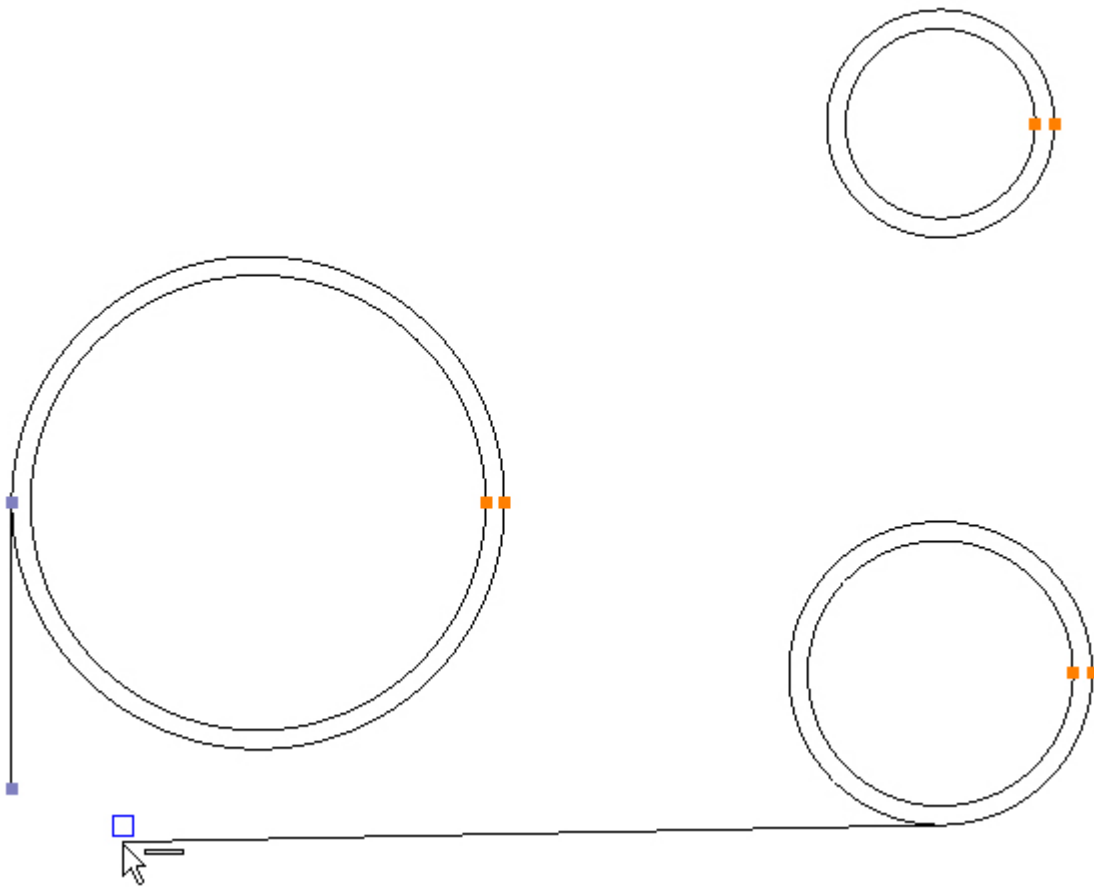
Menu: Draw -> Line

Toolbar button: 

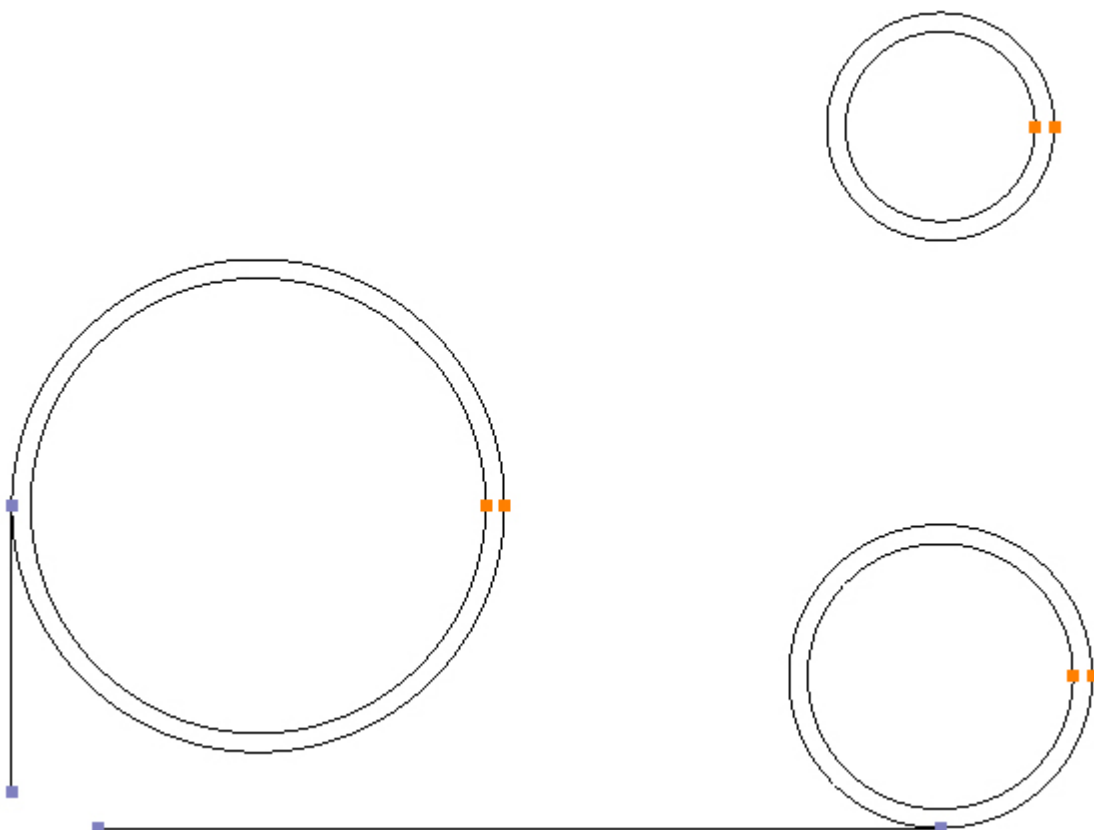
Choose the command and move the cursor near to the 6 o'clock position on the $\varnothing 80$ circle:



Snap the start point of the line to the quadrant point, the cursor is showing the Quadrant snap symbol and a blue Snap Marker indicates the Snap Point. Left click the mouse to accept the Snap Point and create the start of the line:




Move the cursor so it is to the left of the start of the line, the cursor is showing the Horizontal Orthogonal snap symbol and a blue Snap Marker indicates the Snap Point. This will ensure that the line is created horizontally. Left click the mouse to accept the Snap Point and create the end of the line:



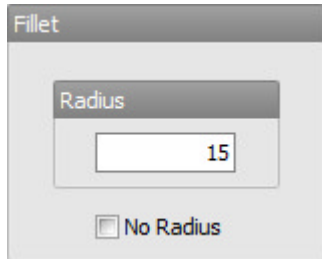
Step 5 - Create fillet

Create the R15 radius at the bottom lefthand corner using Fillet

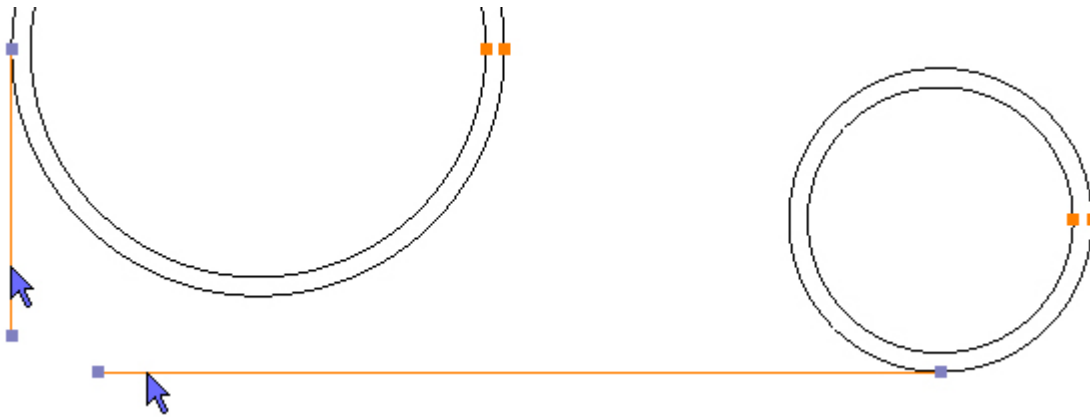
Menu: Modify -> Fillet

Toolbar button: 

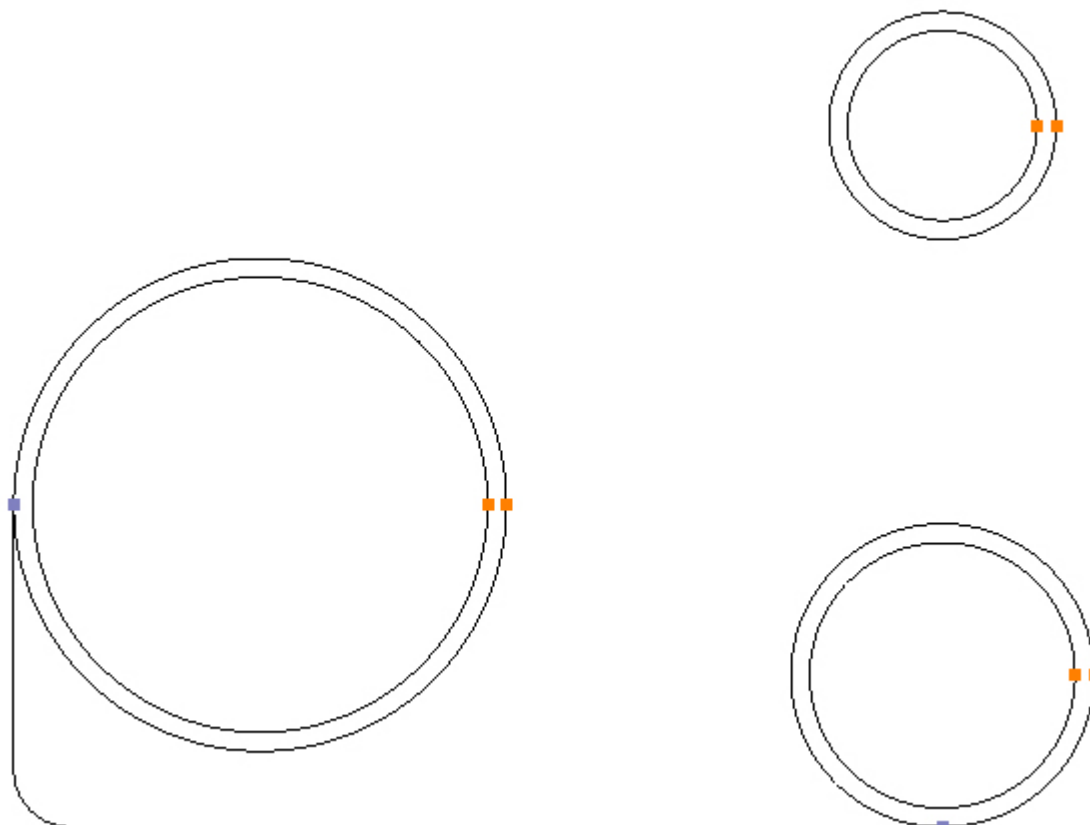
Choose the command and enter 15 in the radius box:



Highlight and left mouse click the two lines:




The fillet is created:



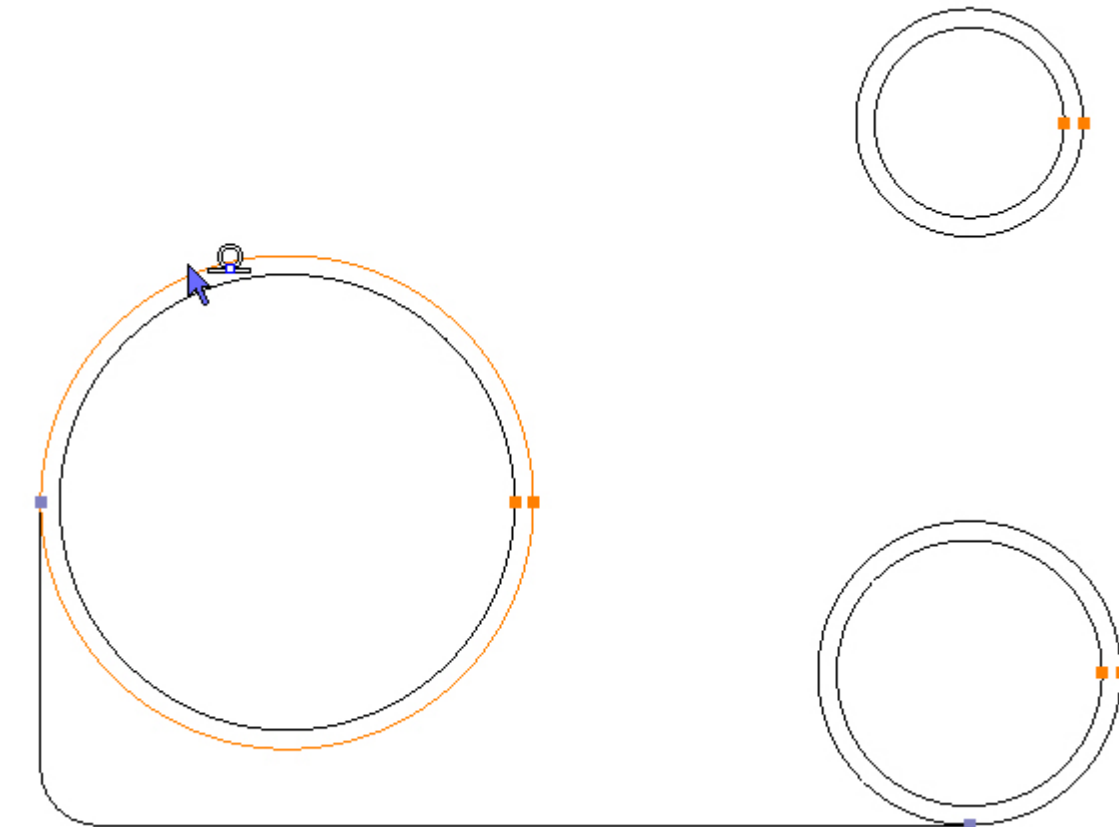
Step 6 - Create line

Create the line tangentially between the $\varnothing 130$ and $\varnothing 60$ circles using Line

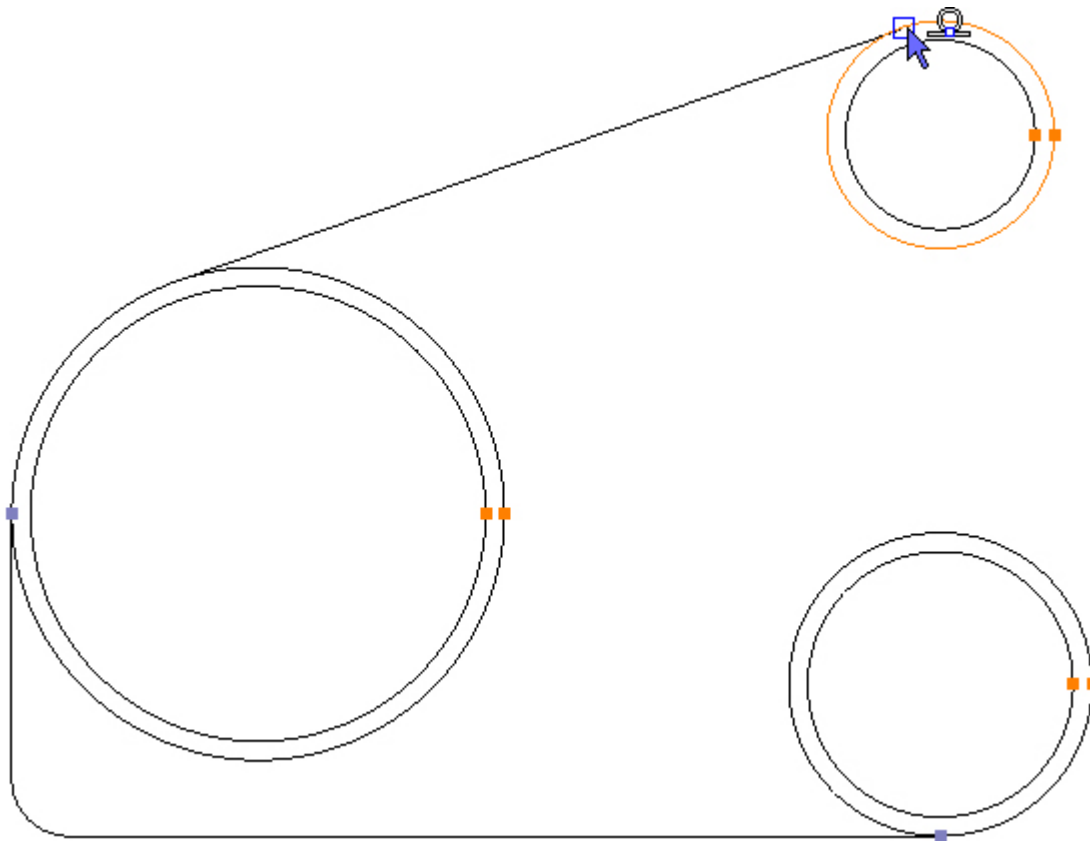
Menu: Draw -> Line

Toolbar button: 

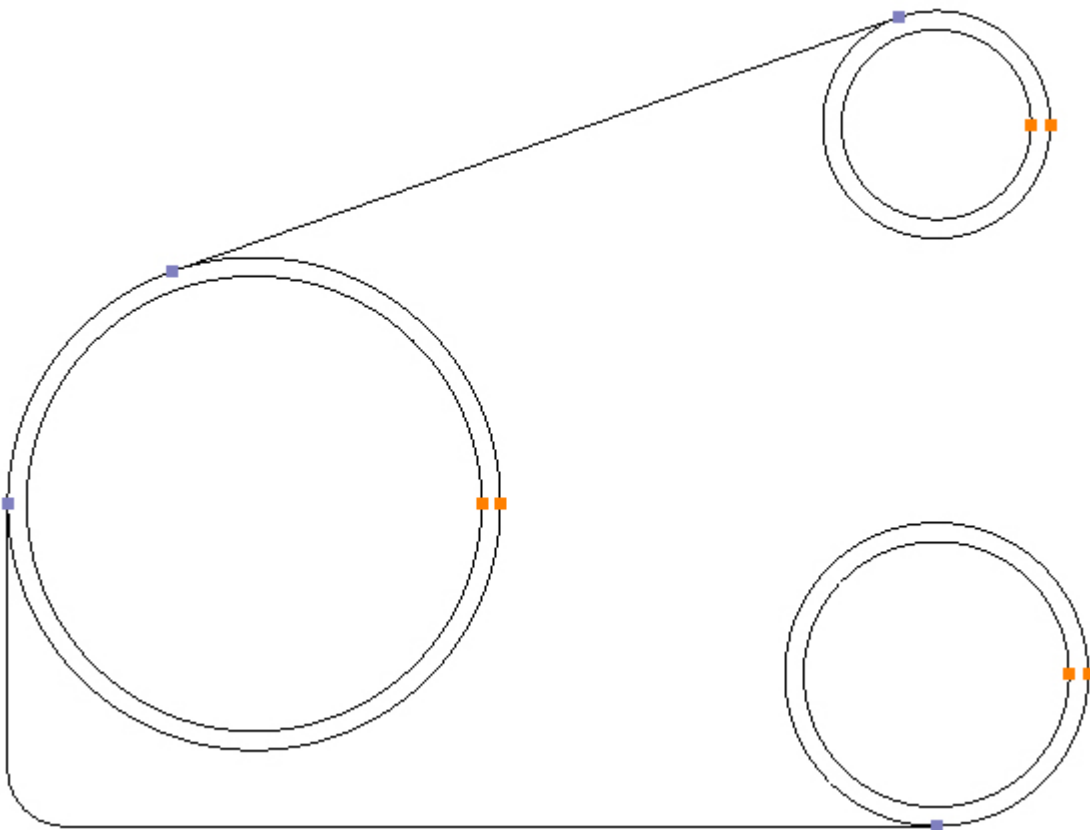
Move the cursor near to the expected start point of the line but on the outside of the circle, the cursor is showing the Tangent symbol. Left click the mouse to accept the Snap Point and create the start of the line:



Move the cursor over the $\varnothing 60$ circle to the expected position of the tangent point, keep moving until the Tangent symbol is shown next to the cursor:




Left mouse click to create the end point of the line tangentially between the two circles:



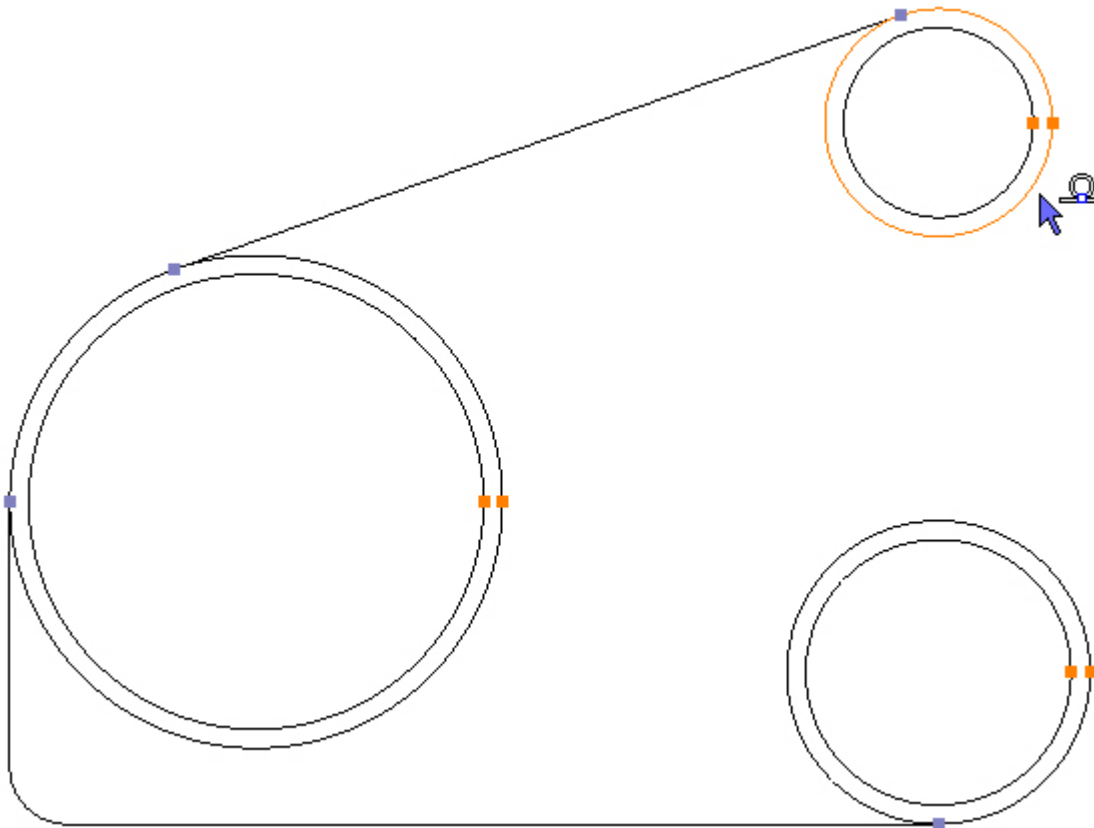
Step 7 - Create line

Create the 60° line tangent to the Ø60 circle using Line

Menu: Draw -> Line

Toolbar button: 

Move the cursor near to the expected start point of the line but on the outside of the circle, the cursor is showing the Tangent symbol. Left click the mouse to accept the Snap Point and create the start of the line:



To create the end point of the line specify an angle and length. Check the Angle/Length check box and enter -120 into the Angle box and 70 in to the length box:

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Line

Start Point

X 205.98076

Y 115

OK

End Point

X 205.98076

Y 115

OK

☒ Angle/Length

A -120

L 70

Click OK to create the end point of the line:

Line

Start Point

X 205.98076

Y 115

OK

End Point

X 205.98076

Y 115

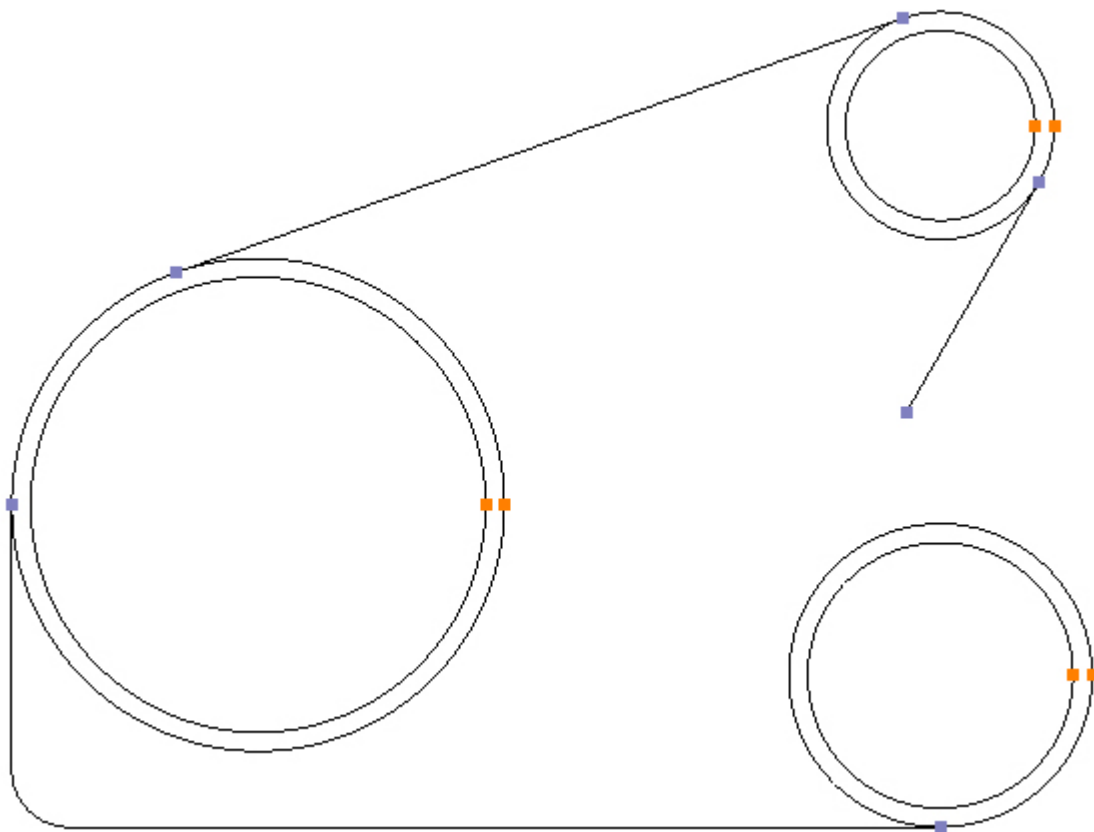
OK

☒ Angle/Length

A -120

L 70

The Part should now look like this:




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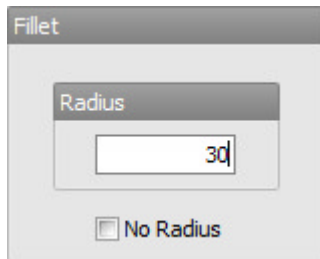
Step 8 - Create fillet

Create the R30 radius using Fillet

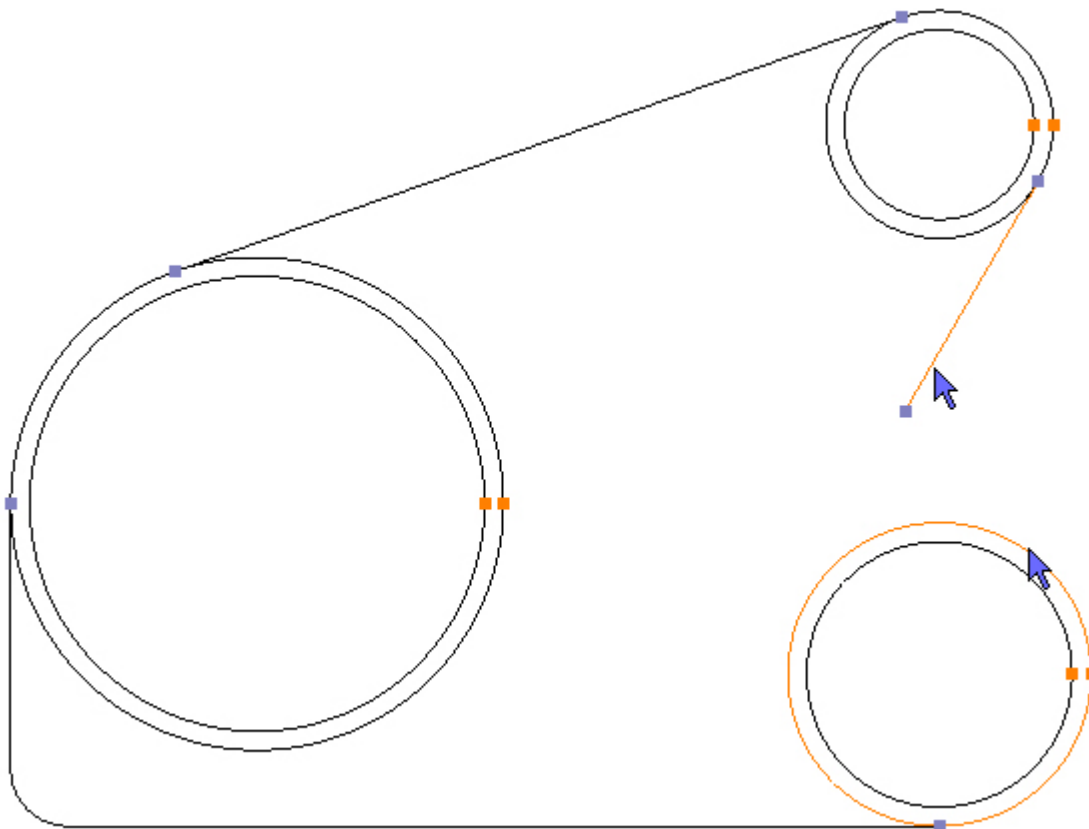
Menu: Modify -> Fillet

Toolbar button: 

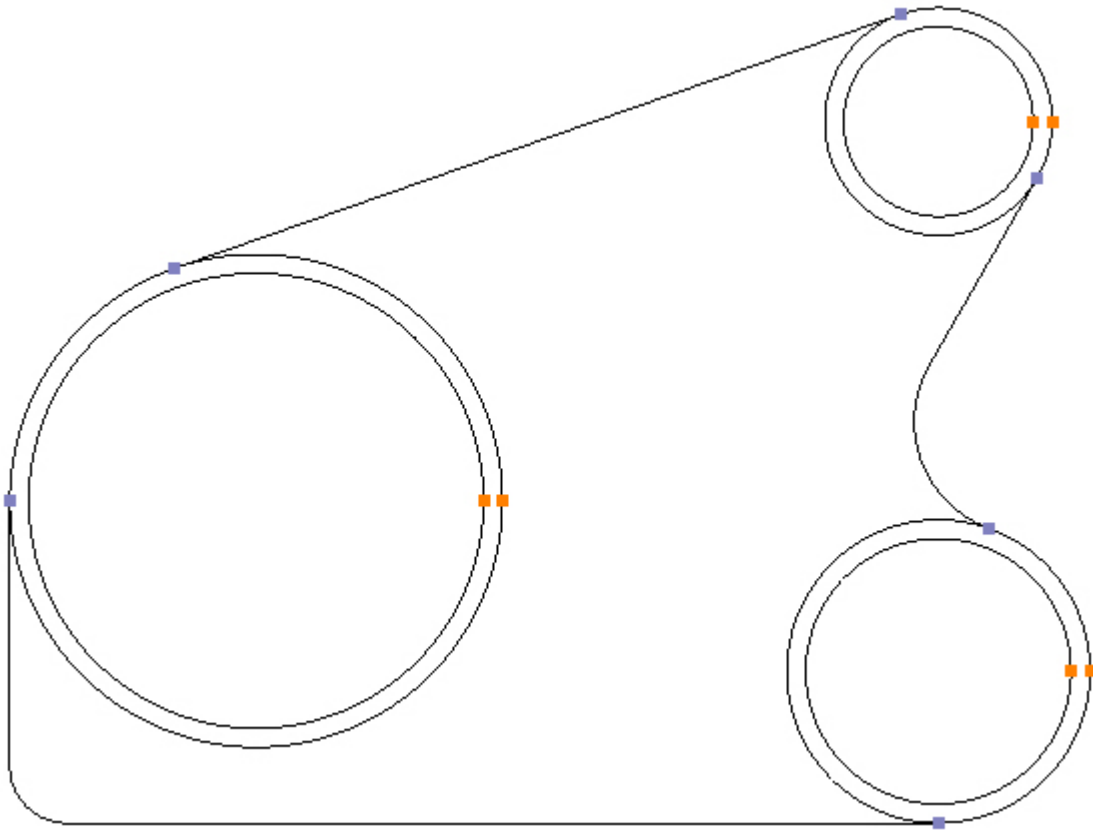
Choose the command and enter 30 in the radius box:



Highlight and left mouse click the Ø80 circle and the 60° line:



The fillet is created:




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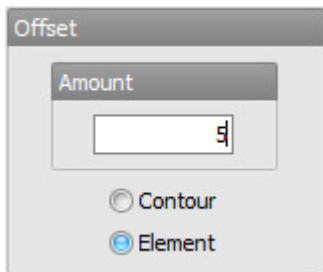
Step 9 - Create offsets

Create 5mm offsets for internal pocket using Offset

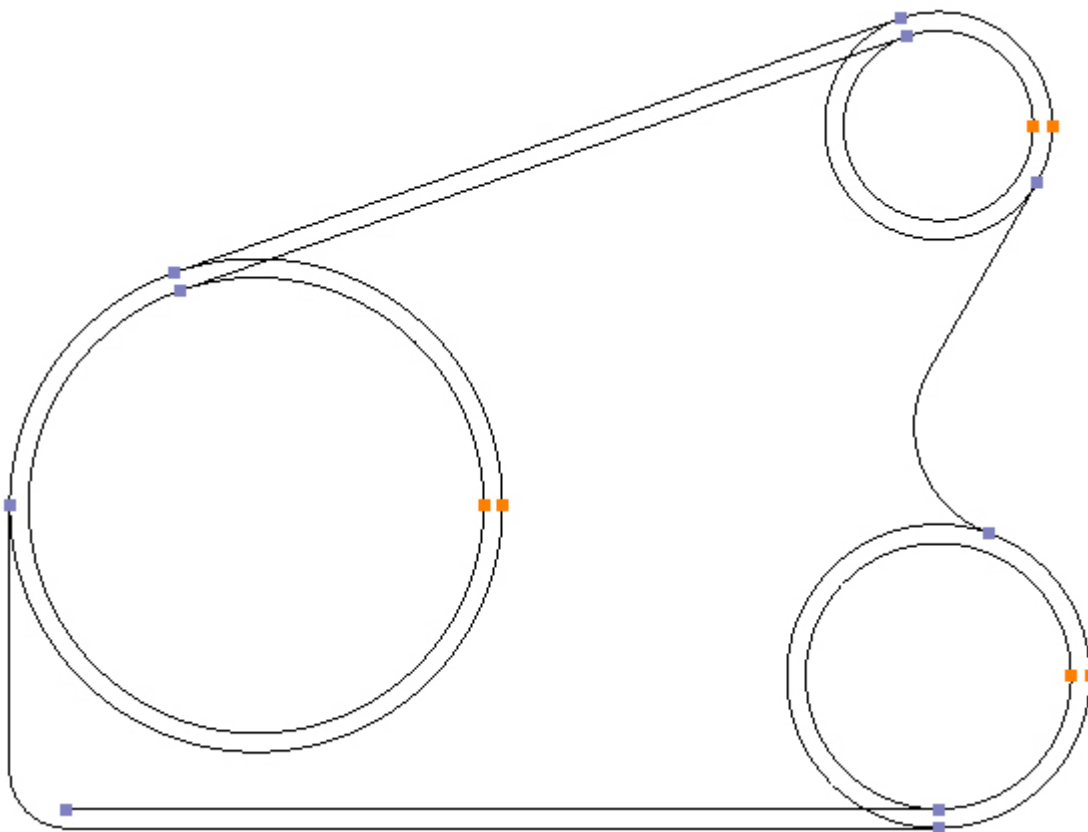
Menu: Modify -> Offset

Toolbar button: 

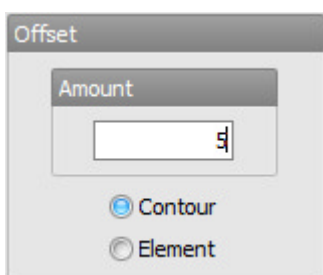
Choose the command and enter 5 into the Amount box, select the *Element* radio button:



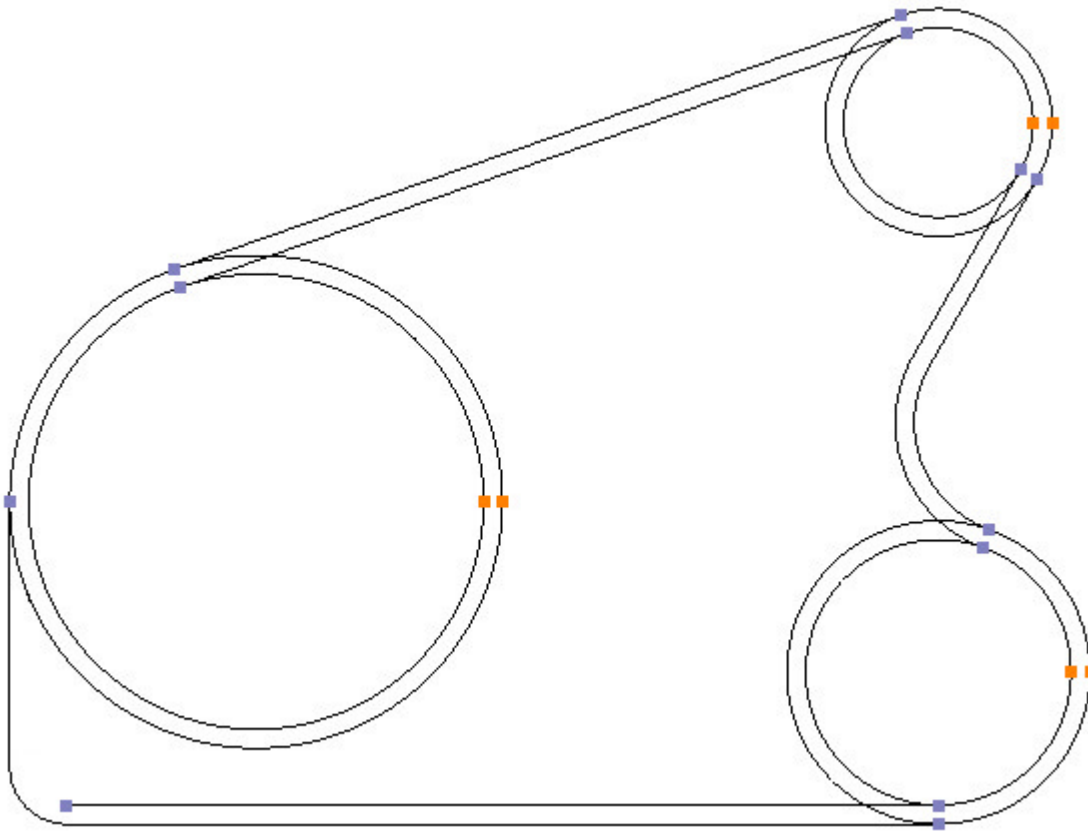
Move the cursor over the line at the bottom edge and left mouse click to indicate that the offset is to be from this line, then left click above the line to create the offset on the inside of the gear housing. Repeat for the line at the top edge to create an offset on the inside as well:



Select the Contour radio button:



Create an offset on the inside from the Contour formed by the 60° line:




Gear Housing Tutorial

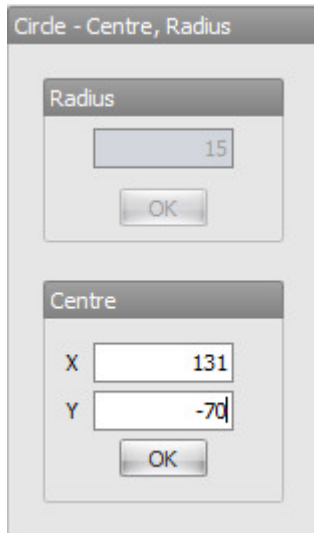
Step 10 - Create two circles

Create two circles using Circle - Centre, Radius

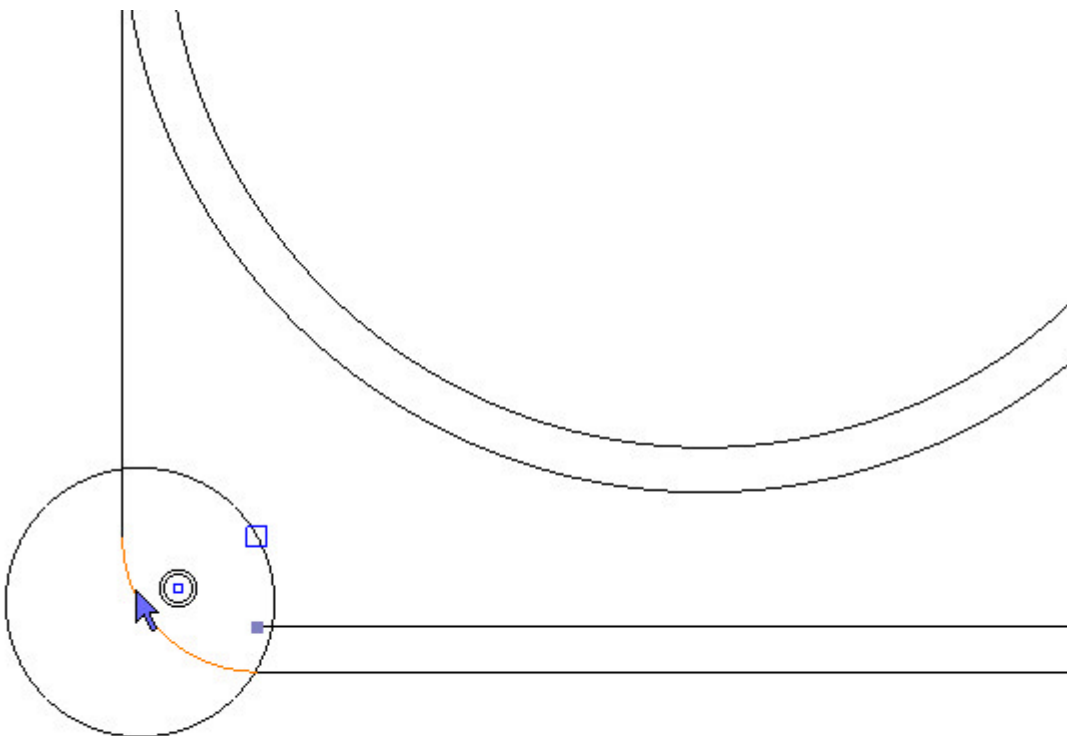
Menu: Draw -> Circle - Centre, Radius

Toolbar button: 

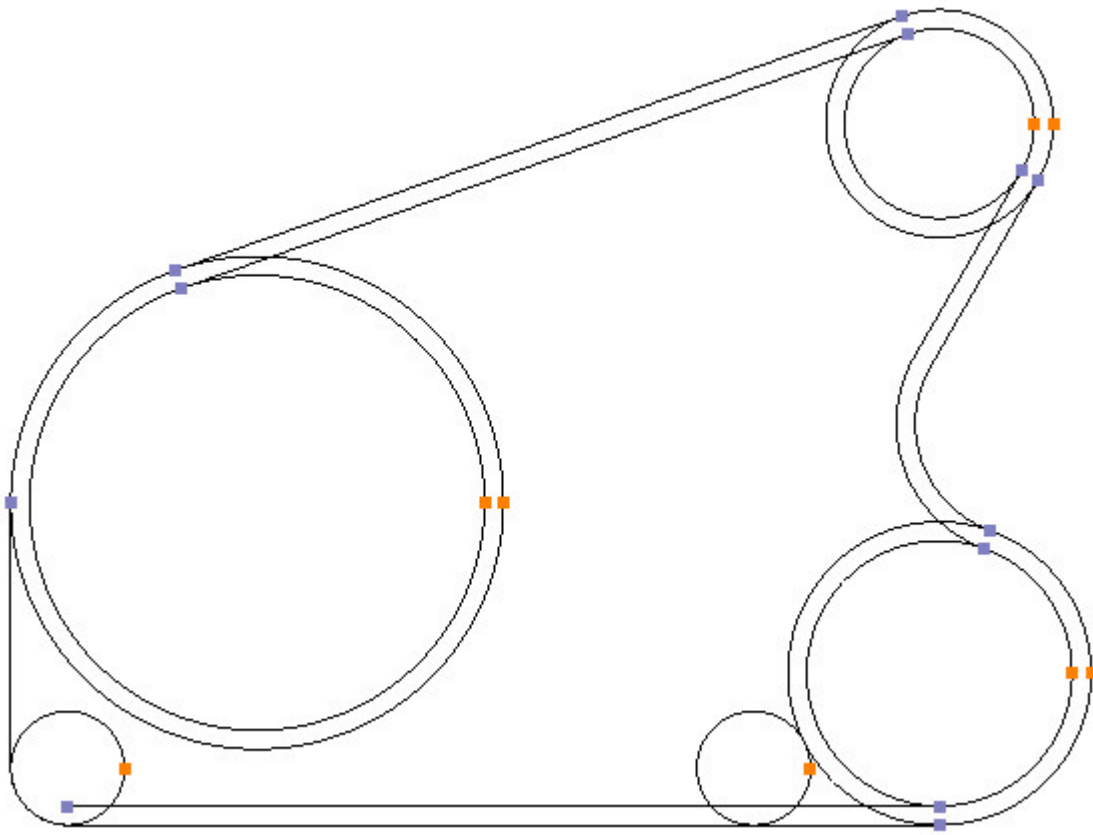
Choose the command and create a 15 radius circle, centred at X131, Y-70:



Create a second circle of the same radius but using snap to centre. Move the cursor over the 15mm radius, not near the end or mid point, until the Center snap symbol is showing and a blue Snap Marker indicates the Snap Point. It may be necessary to zoom in on the 15mm radius by pointing the cursor at it and rotating the middle mouse button:



Left click the mouse to accept the Snap Point and create the circle:




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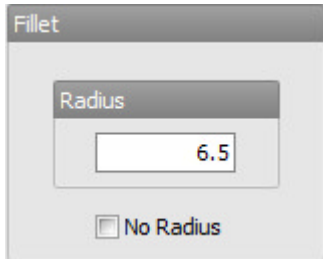
Step 11 - Create fillets

Create 8 off R6.5 Radii using Fillet

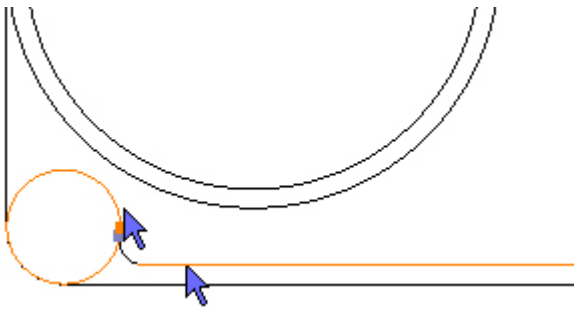
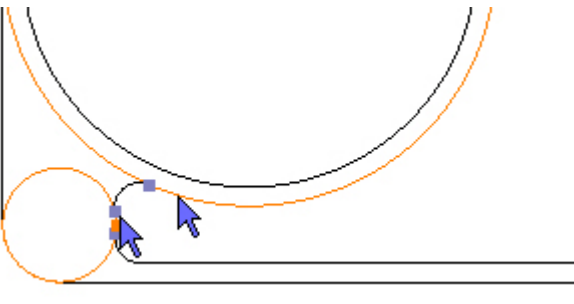
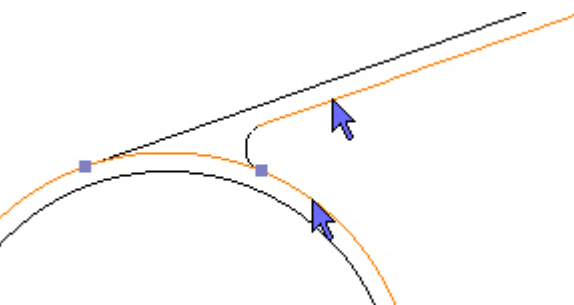
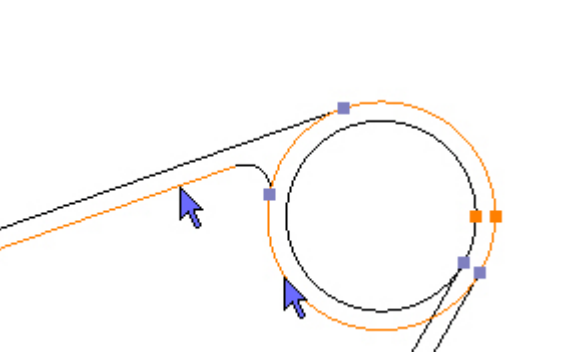
Menu: Modify -> Fillet

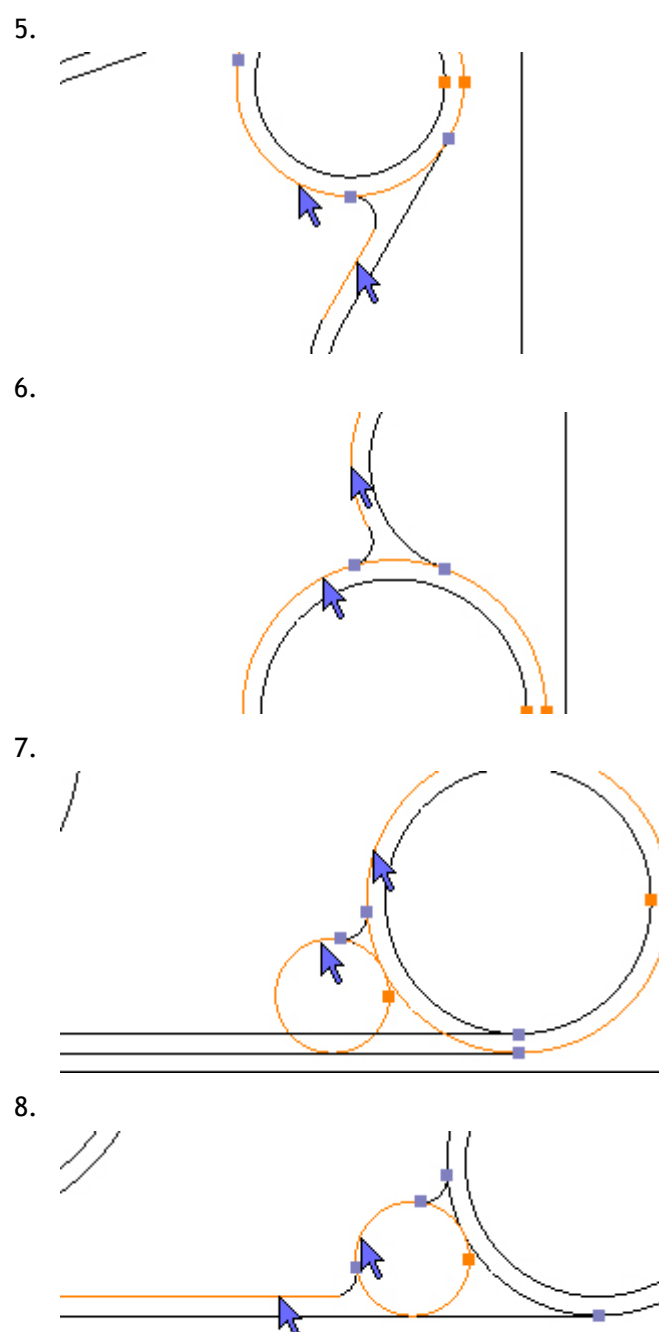
Toolbar button: 

Choose the command and enter 6.5 in the radius box:



Fillet in 8 places, highlight and left mouse click the two elements that form the fillet:

1. Diagram 1 shows the first fillet operation. A blue circle highlights the bottom-left corner where a vertical wall meets a horizontal base. Two blue arrows point to the two entities (the wall and the base) that are selected to create the fillet.
2. Diagram 2 shows the second fillet operation. A blue circle highlights the bottom-right corner. Two blue arrows point to the horizontal base and the vertical wall, indicating the selection of these two entities for the fillet.
3. Diagram 3 shows the third fillet operation. A blue circle highlights the top of a housing. Two blue arrows point to the top horizontal surface and the vertical wall, indicating the selection of these two entities for the fillet.
4. Diagram 4 shows the fourth fillet operation. A blue circle highlights the top of a housing. Two blue arrows point to the top horizontal surface and the vertical wall, indicating the selection of these two entities for the fillet.




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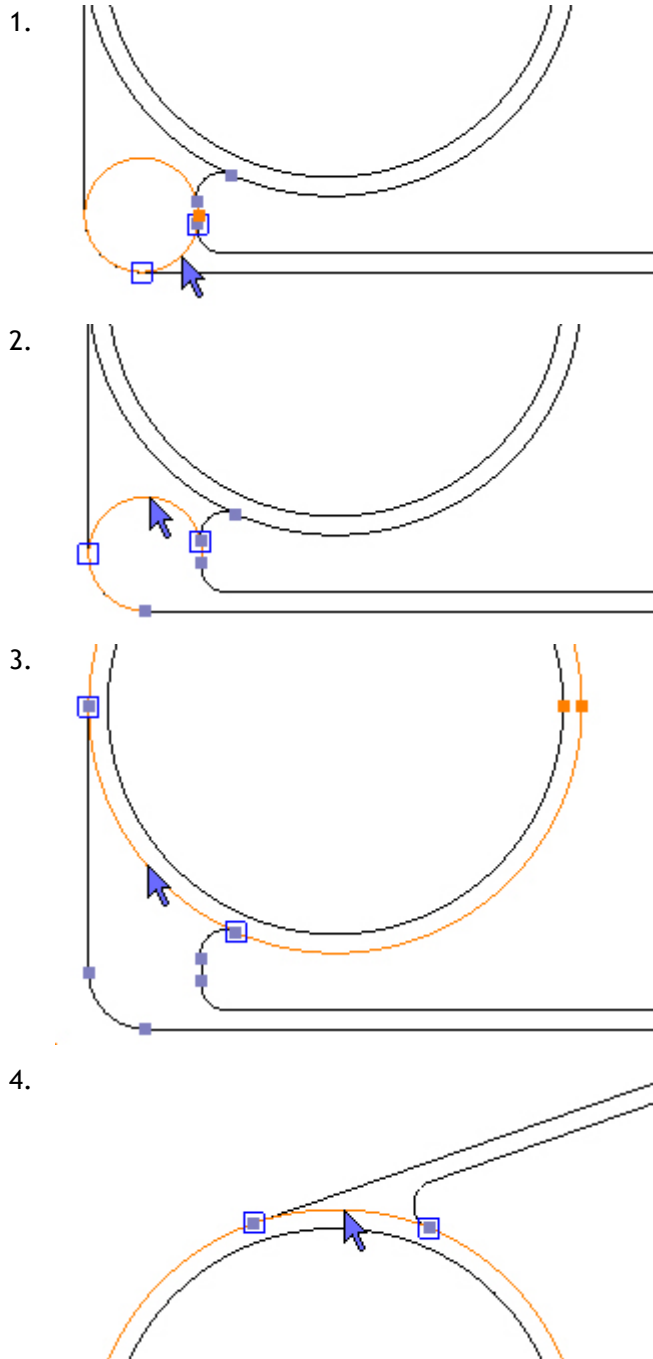
Step 12 - Trim contours

Trim unwanted sections of Contours using Trim

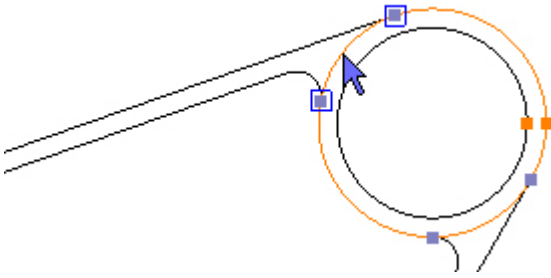
Menu: Modify -> Trim

Toolbar button: 

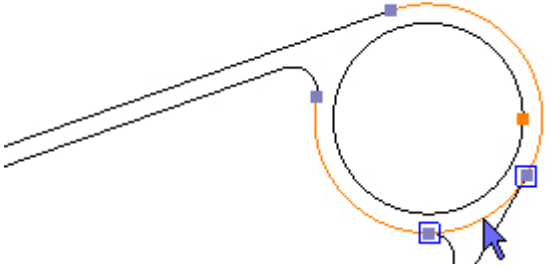
Choose the command and Trim in 10 places, highlight the section of unwanted contours and left mouse click:



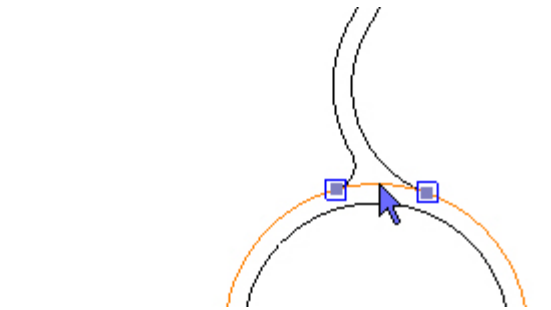
5.



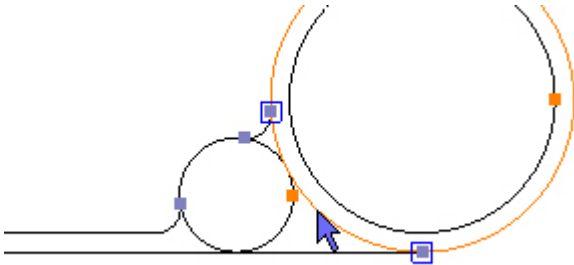
6.



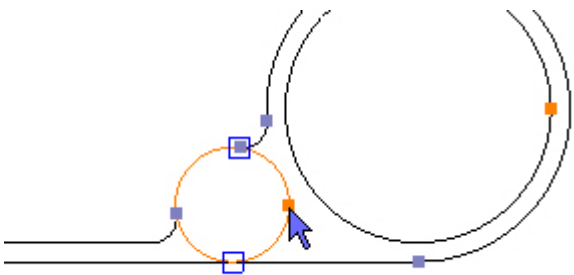
7.



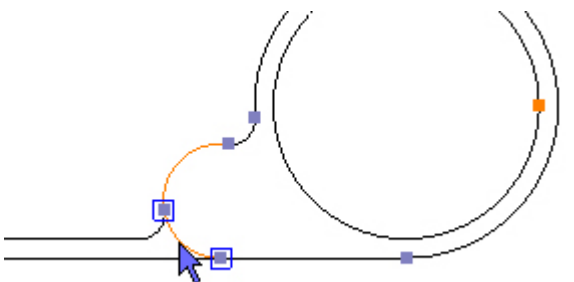
8.



9.

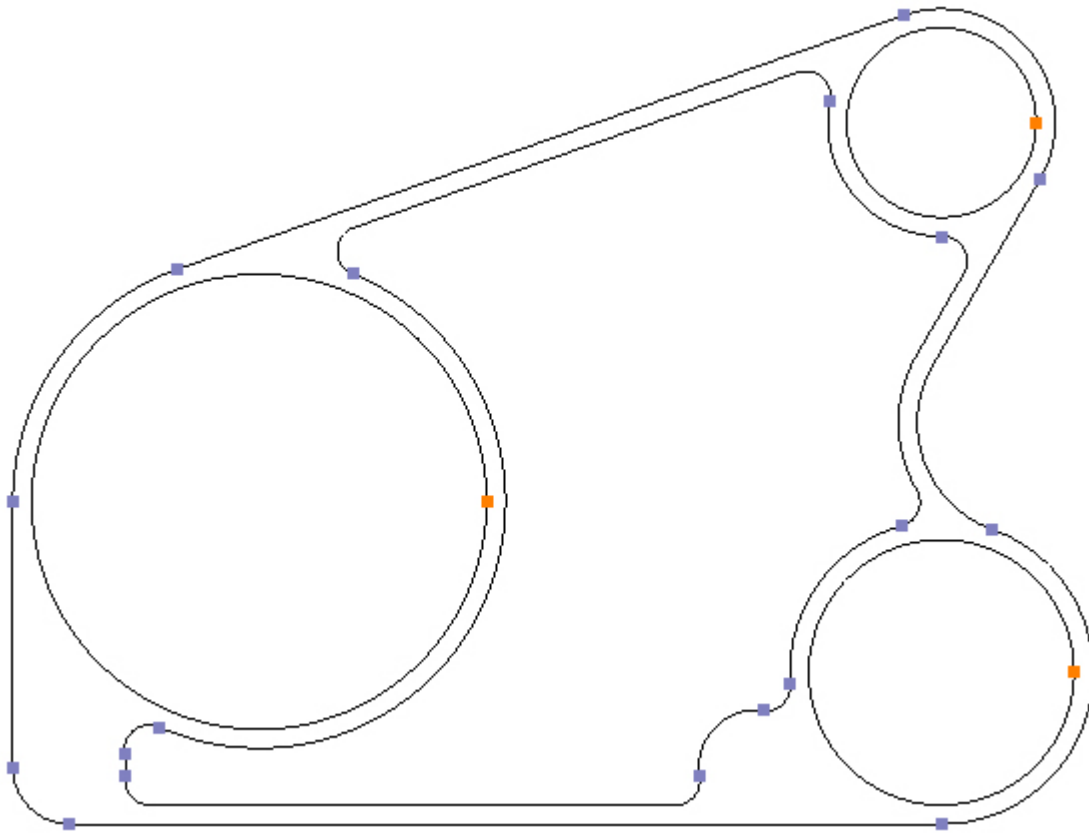


10.



Gear Housing Tutorial


The Part should now look like this:



Step 13 - Connect contours


Connect Contours using Connect

Menu: Modify -> Connect

Toolbar button: 

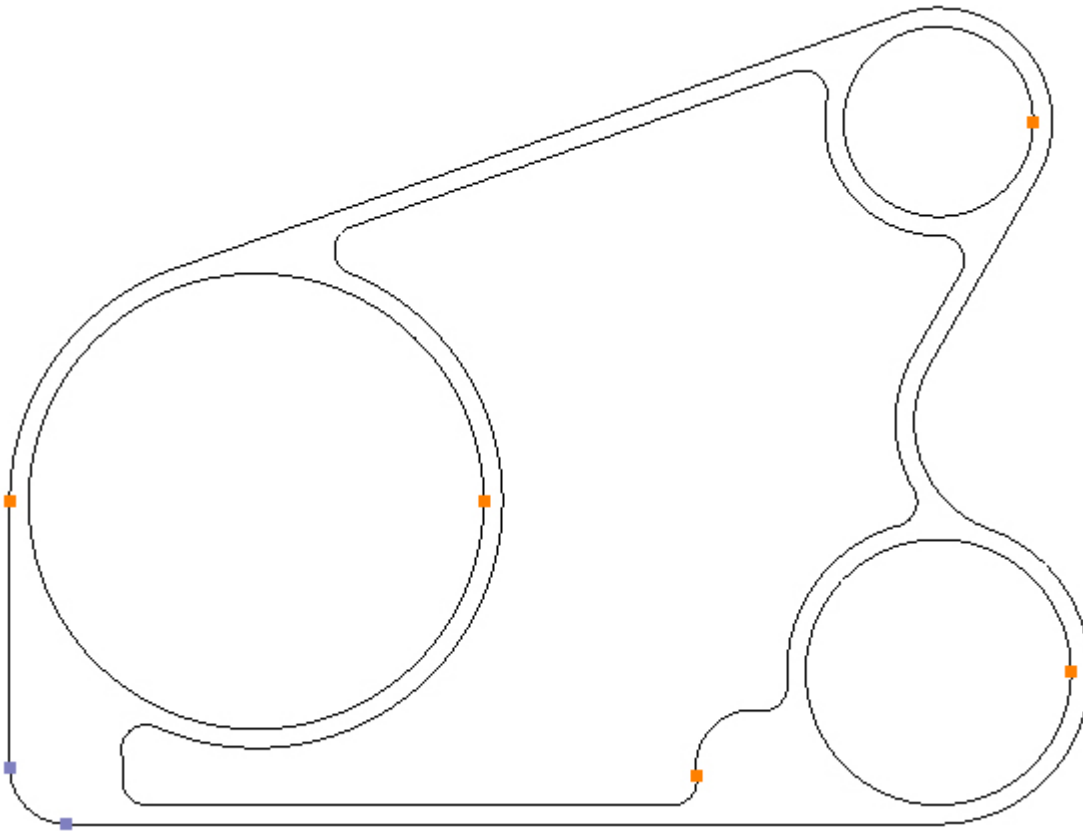
When the Connect command is chosen, it connects all selected Contours. It does not matter if a Contour is selected that does not need to be connected, as long as it cannot be connected. Therefore use the Select All command to select the Contours:

Menu: Edit -> Select All

Toolbar button: 

Shortcut: Ctrl + A

Now all the Contours are selected choose the Connect command, the part should now look like this:

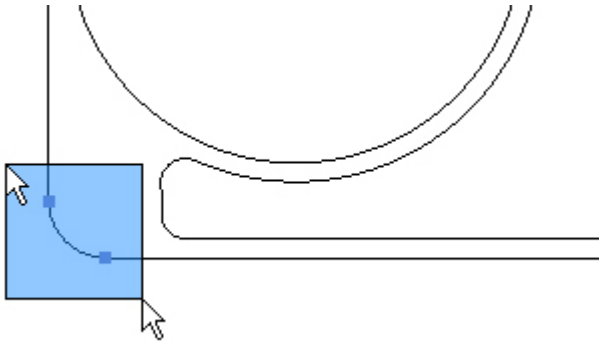


All the Contours are now connected and are closed, as indicated by the orange connection markers. There is still an open Contour in the bottom left hand corner, this is left over from the trimming and needs to be deleted.

Select the Contour. It may not be possible to select the Contour by directly clicking it, the outside Contour may be selected instead, in this case use a selection rectangle.


Right click over the Part to show the context menu and choose 'Select Mode'. Click away from any Contours and drag the rectangle over the open contour:

Gear Housing Tutorial

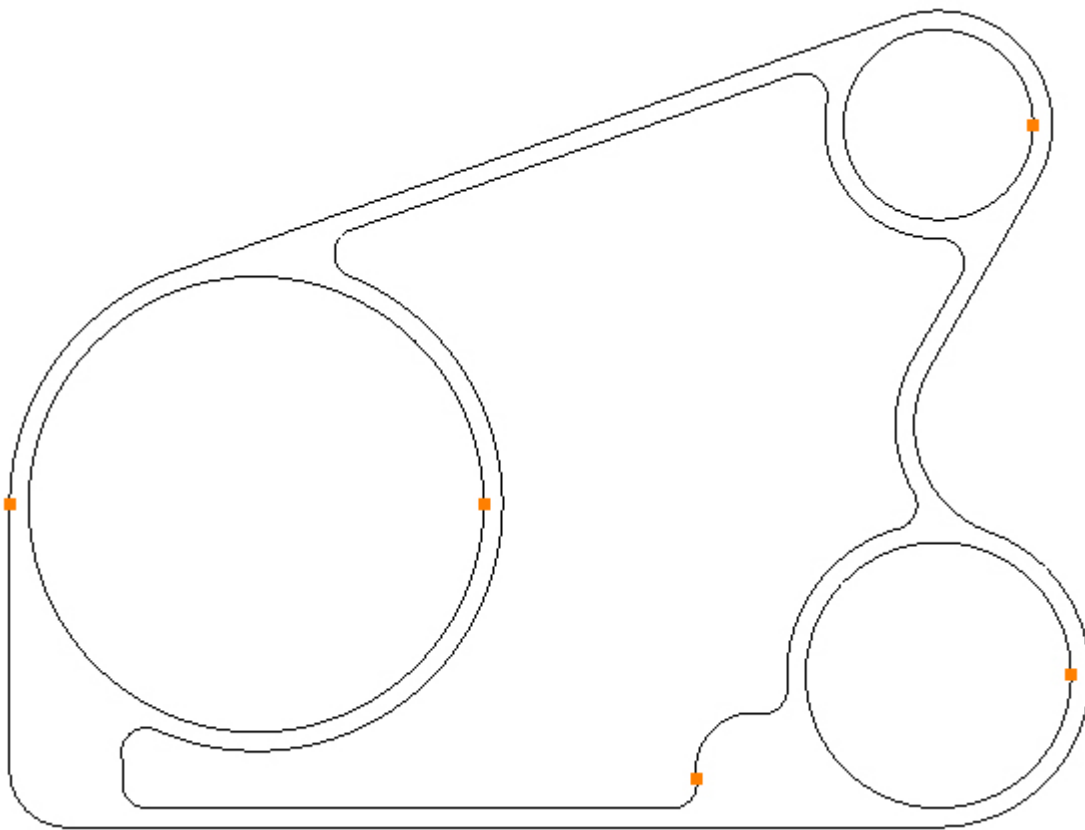


Now the Contour is selected use the Delete command to delete it:

Menu: Edit -> Delete

Toolbar button: 


The Part should now look like this:



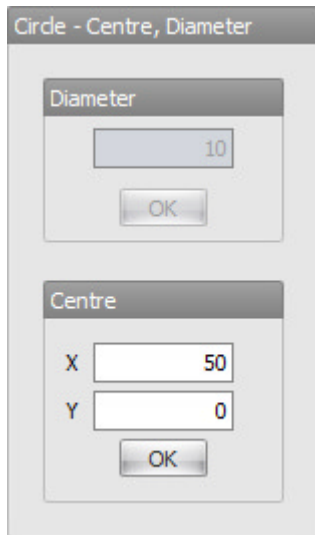
Step 14 - Create circle

Create a circle using Circle - Centre, Diameter

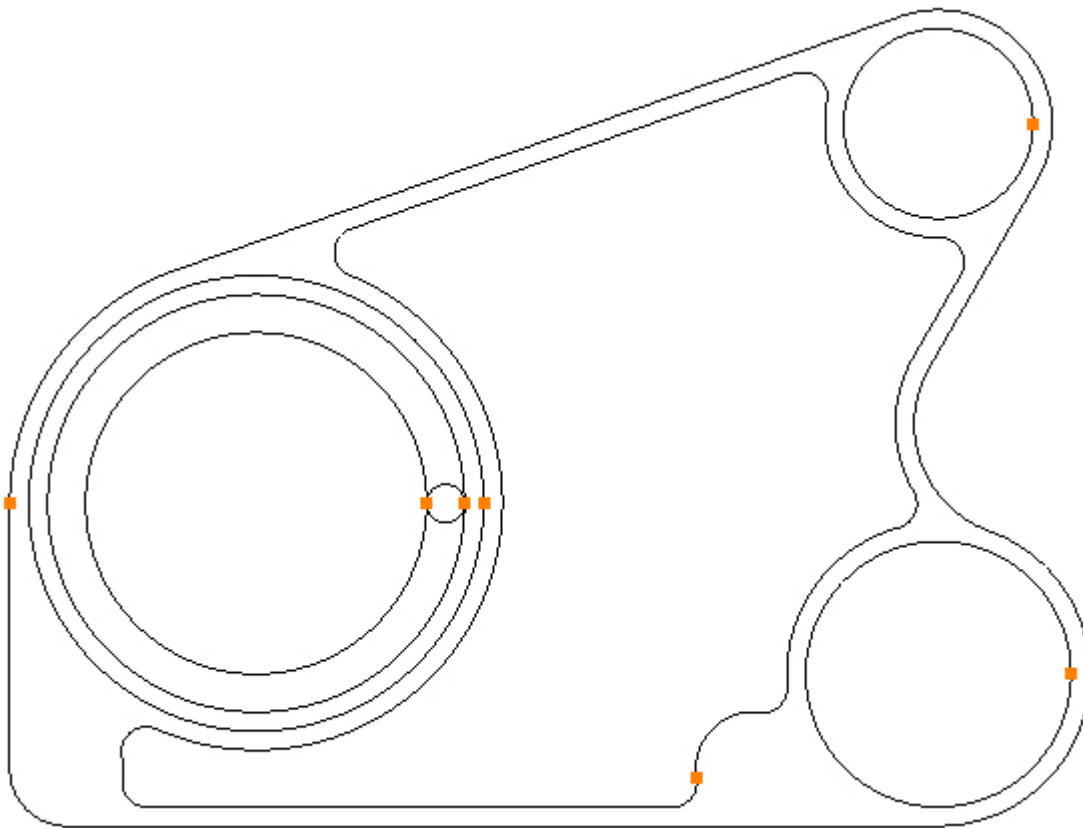
Menu: Draw -> Circle - Centre, Diameter

Toolbar button: 

Choose the command and create a $\varnothing 10$ circle, centred at X50, Y0:



Create another two circles of $\varnothing 90$ and $\varnothing 110$ centred at X0, Y0, the Part should now look like this:




Gear Housing Tutorial

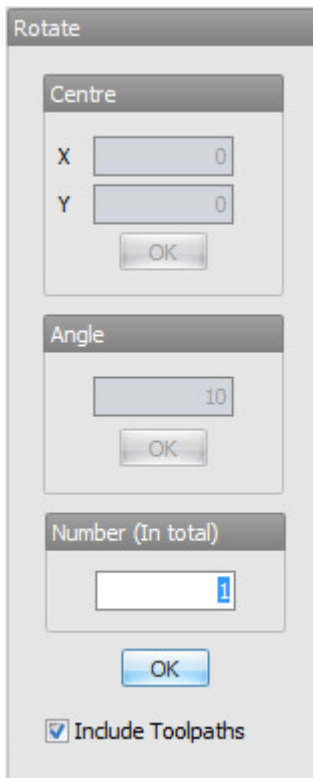
Step 15 - Rotate circle

Rotate the Ø10 circle using Rotate

Menu: Modify -> Rotate

Toolbar button: 

First select the Ø10 circle, right click over the Part to show the context menu and choose 'Select Mode' and directly click the circle. Then choose the Rotate command and rotate around a centre of X0, Y0 by 10°, once:



Leaving the circle selected rotate again by 70°, but keeping the original circle by specifying 2 for the *Number* box:

Rotate

Centre

X

0

Y

0

OK

Angle

70

OK

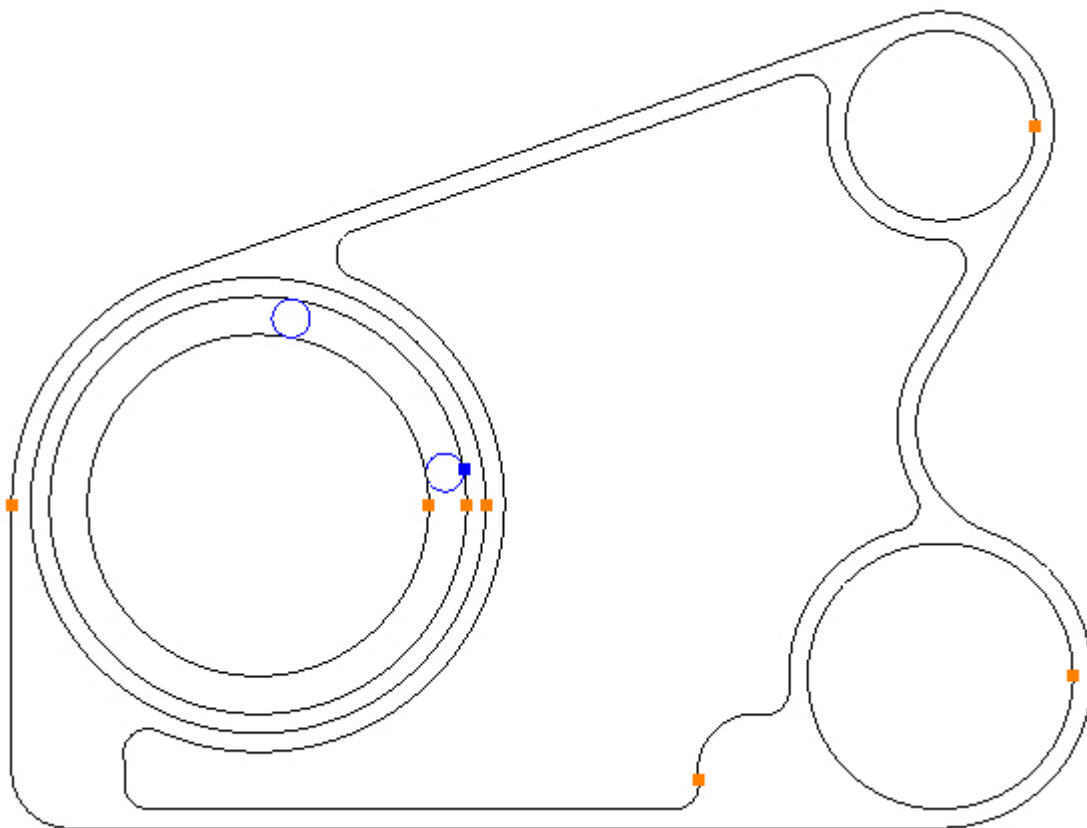
Number (In total)

4

OK

☒ Include Toolpaths

The Part should now look like this:




Gear Housing Tutorial

Step 16 - Trim contours

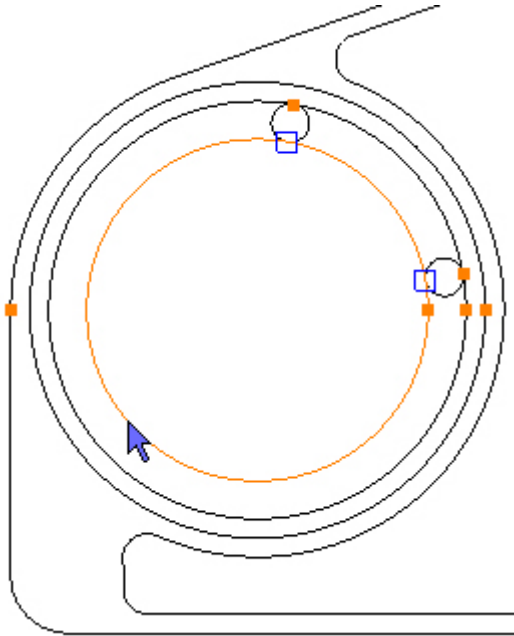
Trim unwanted section of Contours using Trim

Menu: Modify -> Trim

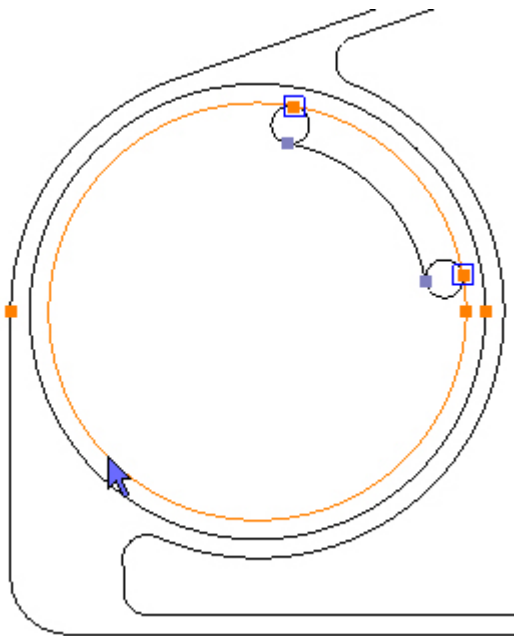
Toolbar button: 

Choose the command and Trim in 4 places, highlight the sections of unwanted contours and left mouse click:

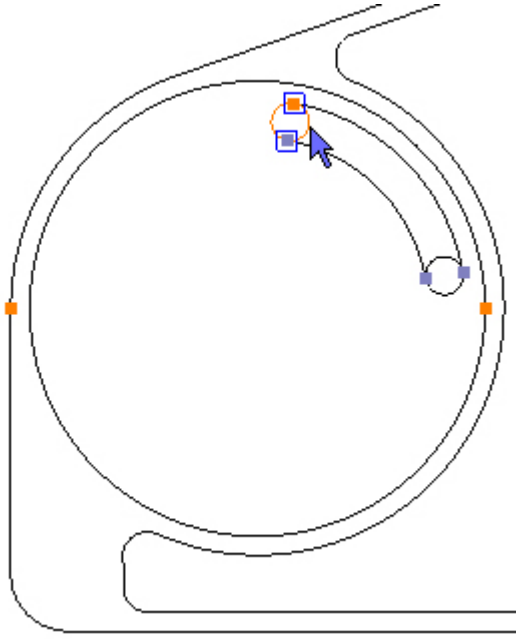
1.



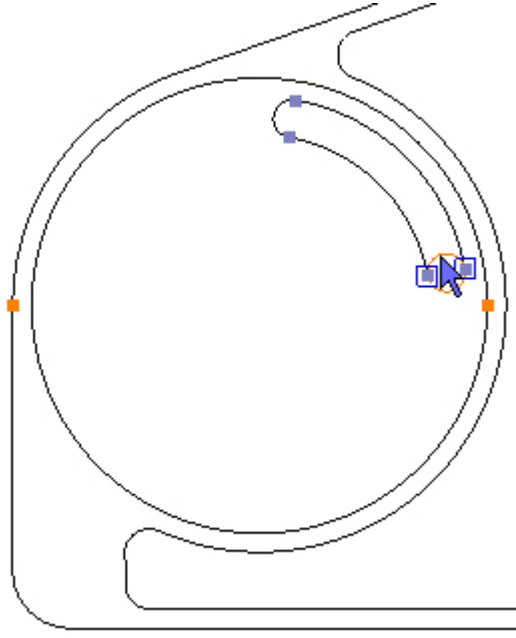
2.



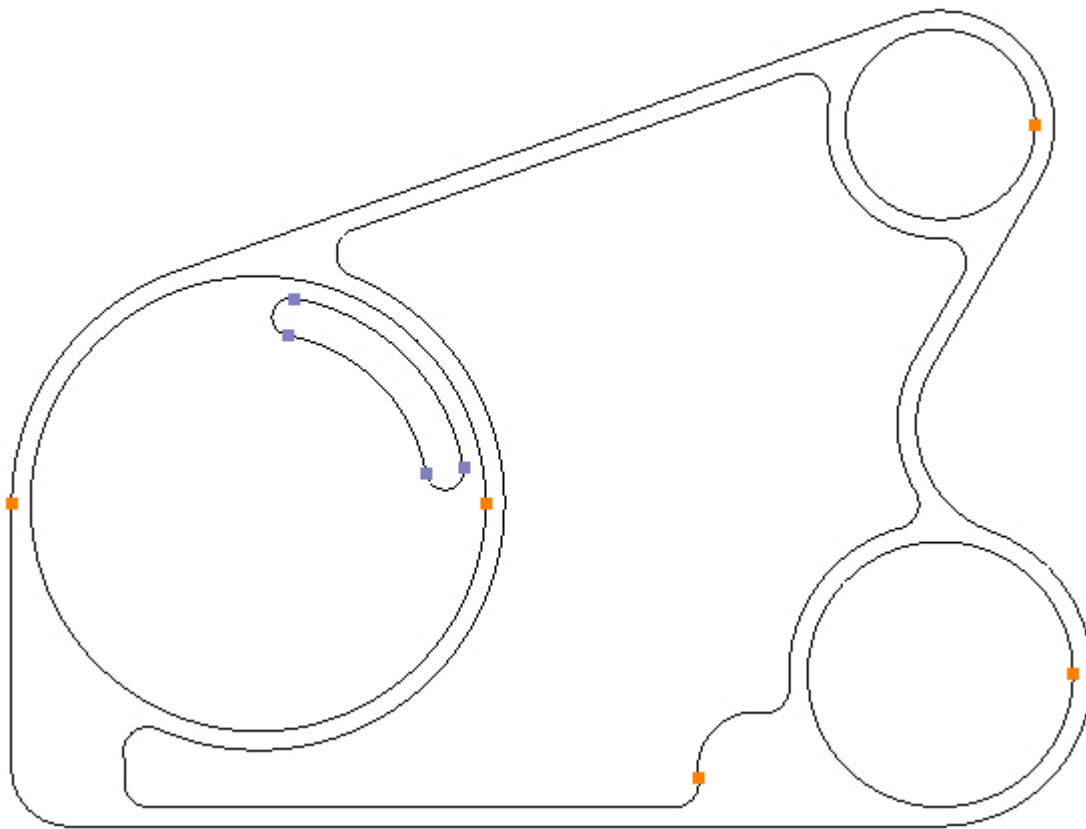
3.



4.




The Part should now look like this:



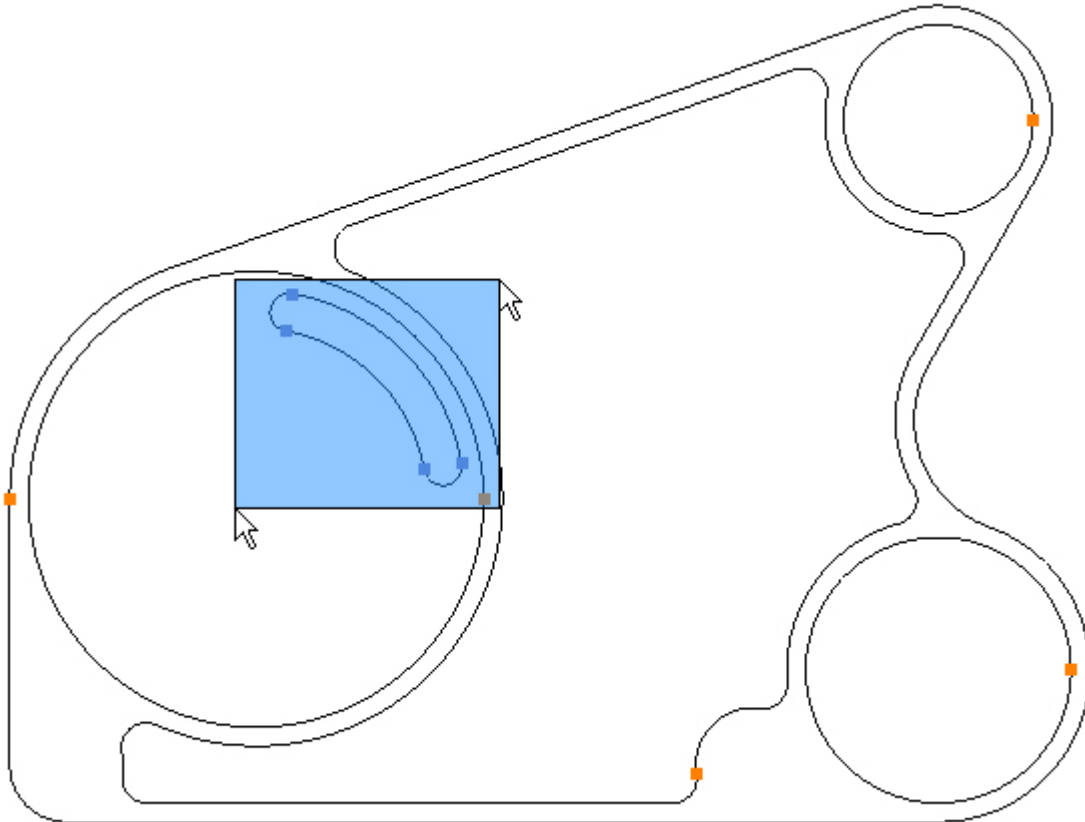
Step 17 - Connect contours

Connect slot using Connect

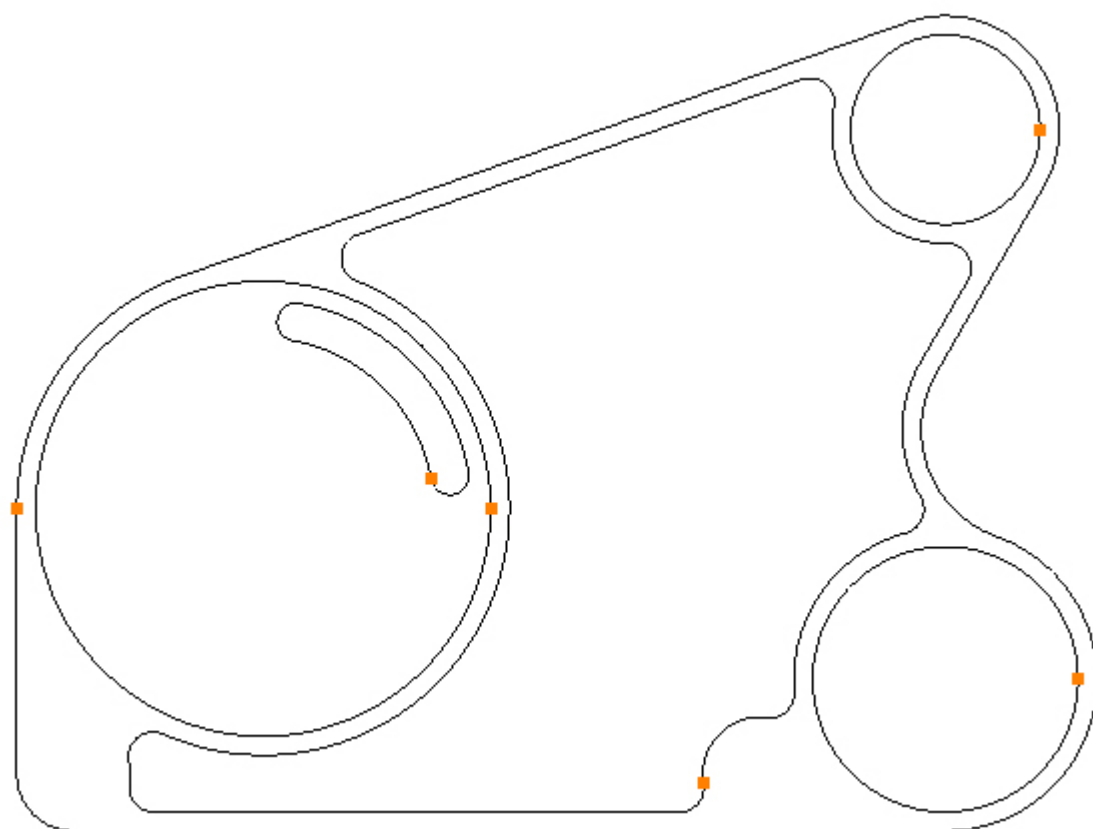
Menu: Modify -> Connect

Toolbar button: 

First select the 4 arcs that make up the slot using a selection rectangle. Right click over the Part to show the context menu and choose 'Select Mode'. Click away from any Contours and drag the rectangle over the open contour:




Choose the Connect command, the Part should now look like this:



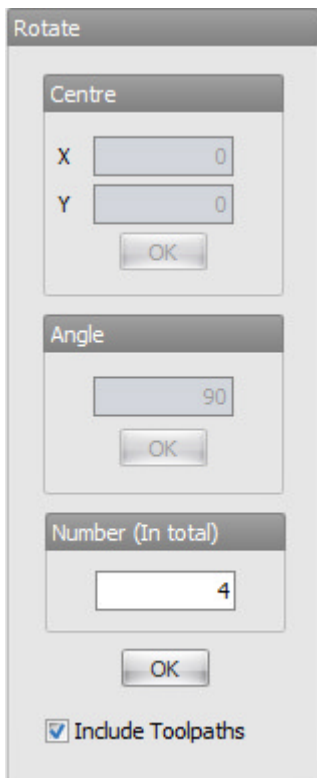
Step 18 - Rotate contour

Rotate the slot using Rotate

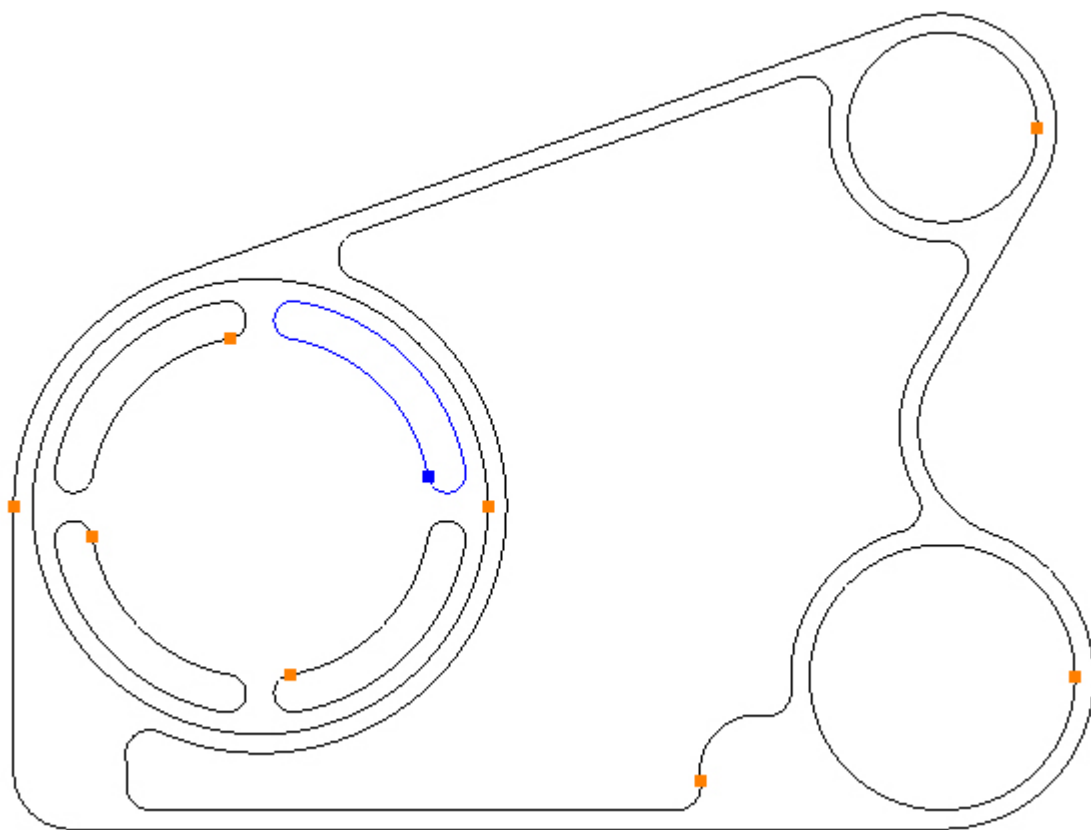
Menu: Modify -> Rotate

Toolbar button: 

First select the slot, right click over the Part to show the context menu and choose 'Select Mode' and directly click the slot. Then choose the Rotate command and rotate around a centre of X0, Y0 by 90°, in 4 places:




The Part should now look like this:



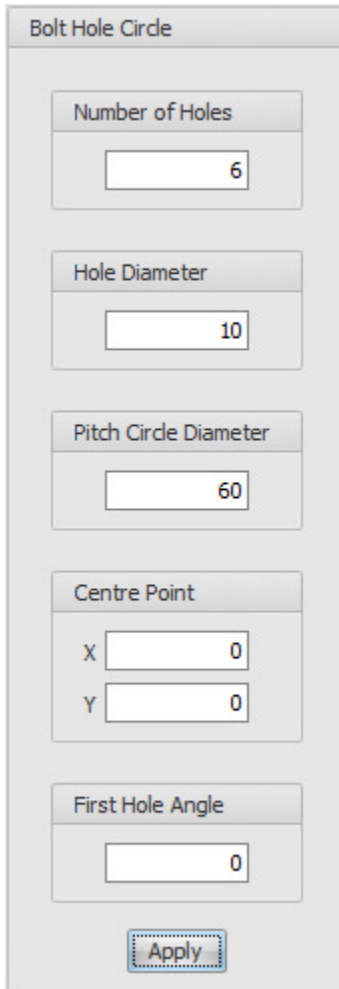
Step 19 - Create circles

Create circle using Bolt Hole Circle

Menu: Draw -> Bolt Hole Circle

Toolbar button: 

Choose the command and enter the following values:

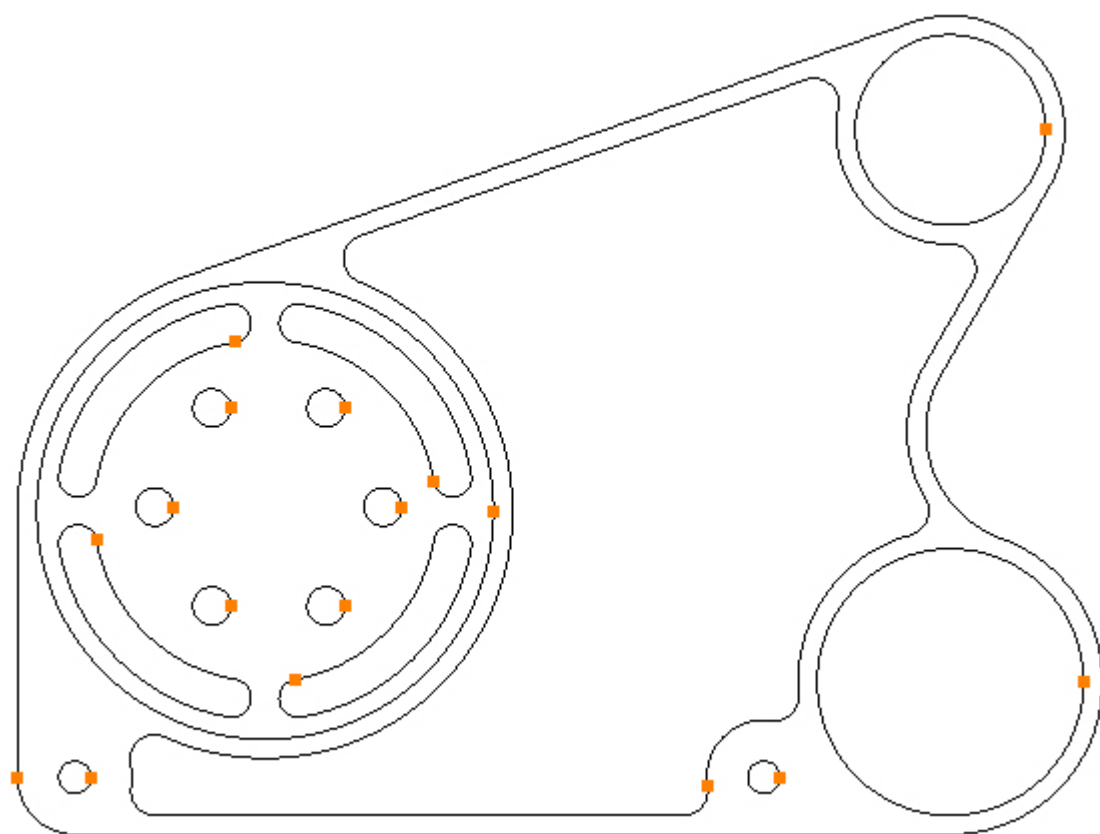


The image shows a software dialog box titled "Bolt Hole Circle". It contains several input fields for configuring a bolt hole circle. The "Number of Holes" field is set to 6. The "Hole Diameter" field is set to 10. The "Pitch Circle Diameter" field is set to 60. The "Centre Point" section has "X" and "Y" coordinates both set to 0. The "First Hole Angle" field is set to 0. At the bottom of the dialog is an "Apply" button.

Parameter	Value
Number of Holes	6
Hole Diameter	10
Pitch Circle Diameter	60
Centre Point X	0
Centre Point Y	0
First Hole Angle	0

Click the Apply button to action the command.


The Part should now look like this:



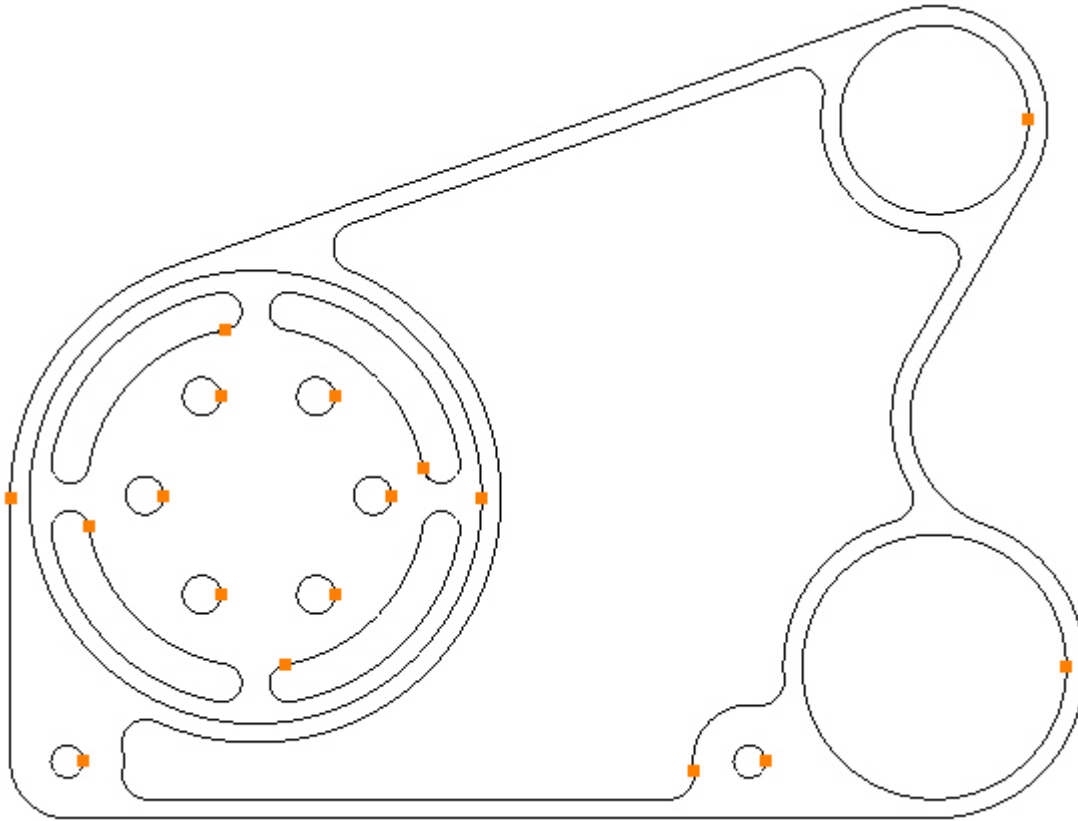
Step 20 - Create circles

Create two circles using Circle - Centre, Diameter


Menu: Draw -> Circle - Centre, Diameter

Toolbar button: 

Choose the command and create two $\varnothing 8.5$ circles, centred at X131, Y-70 and X-50, Y-70:



The creation of the Contours is now complete.



Gear Housing Tutorial

Create the Toolpaths

Step 1 - Process plan

The Gear Housing is to be made from an aluminium rectangular billet 295mm x 225mm x 30mm. The billet is to be held in a machine vice, leaving 27mm protruding above the top of the jaws. The Gear Housing is machined completely, leaving an operation to remove the excess material that it was held with. This operation will not be covered during the tutorial.

For the purpose of this tutorial assume that the top of the billet is at Z0 and does not require facing.

Before starting, a process plan is required:

Operation Description	Operation Type	Tool	Comments
Rough outside profile	Pocket	T01, 20mm End Mill	0.5 finish allowance
Rough Ø120 counterbore	Pocket	T01, 20mm End Mill	0.5 finish allowance
Rough Ø50 and Ø70 bores	Pocket	T01, 20mm End Mill	0.5 finish allowance
Rough inside pocket	Pocket	T02, 12mm End Mill	0.5 finish allowance
Finish outside profile	Profile	T03, 20mm End Mill	
Finish Ø50 and Ø70 bores	Profile	T03, 20mm End Mill	
Finish Ø120 counterbore	Pocket	T03, 20mm End Mill	
Finish inside pocket	Pocket	T04, 12mm End Mill (2mm Corner Rad)	
Machine radial slots	Profile	T05, 8mm Slot Drill	
Spot Drill holes	Drilling	T06, 12mm Spot Drill	
Drill Ø8.5 holes	Drilling	T07, 8.5mm Drill	
Drill Ø10 holes	Drilling	T08, 10mm Drill	


Gear Housing Tutorial

Step 2 - Set start point

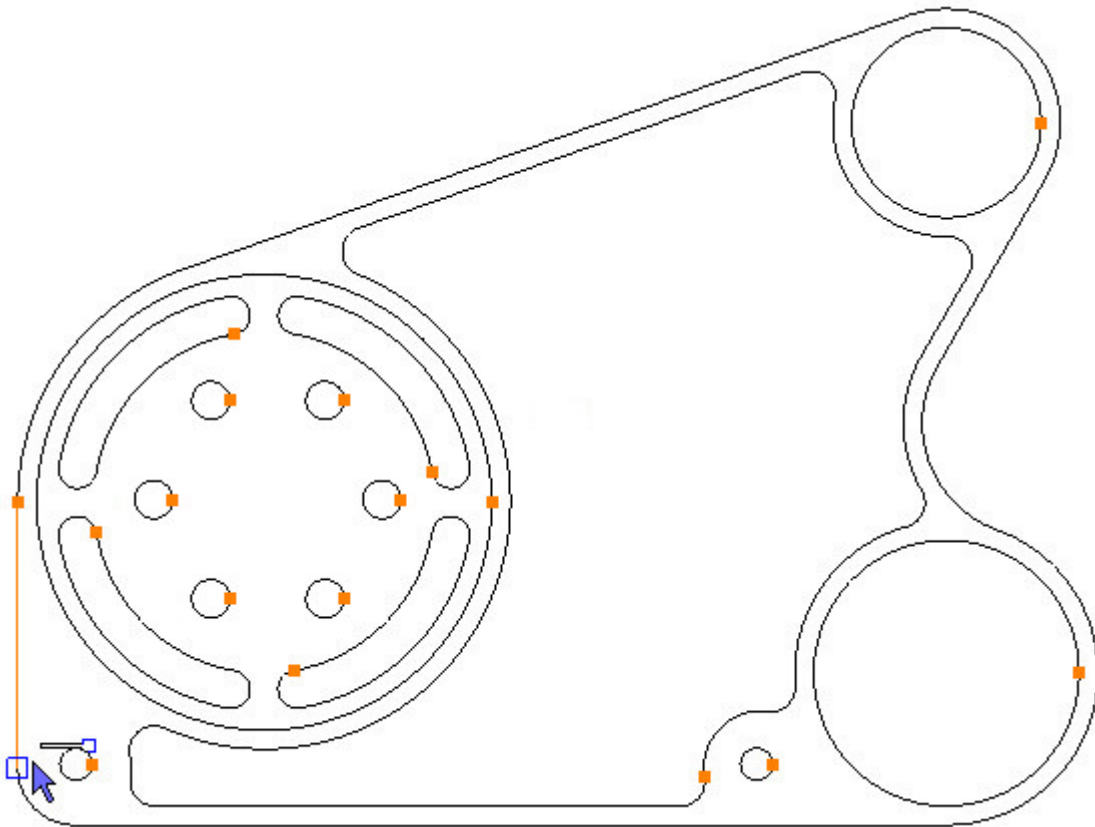
Set start point on closed Contours using Set Start Point

Before creating any operations, it is recommended that the start point on closed contours be set first.

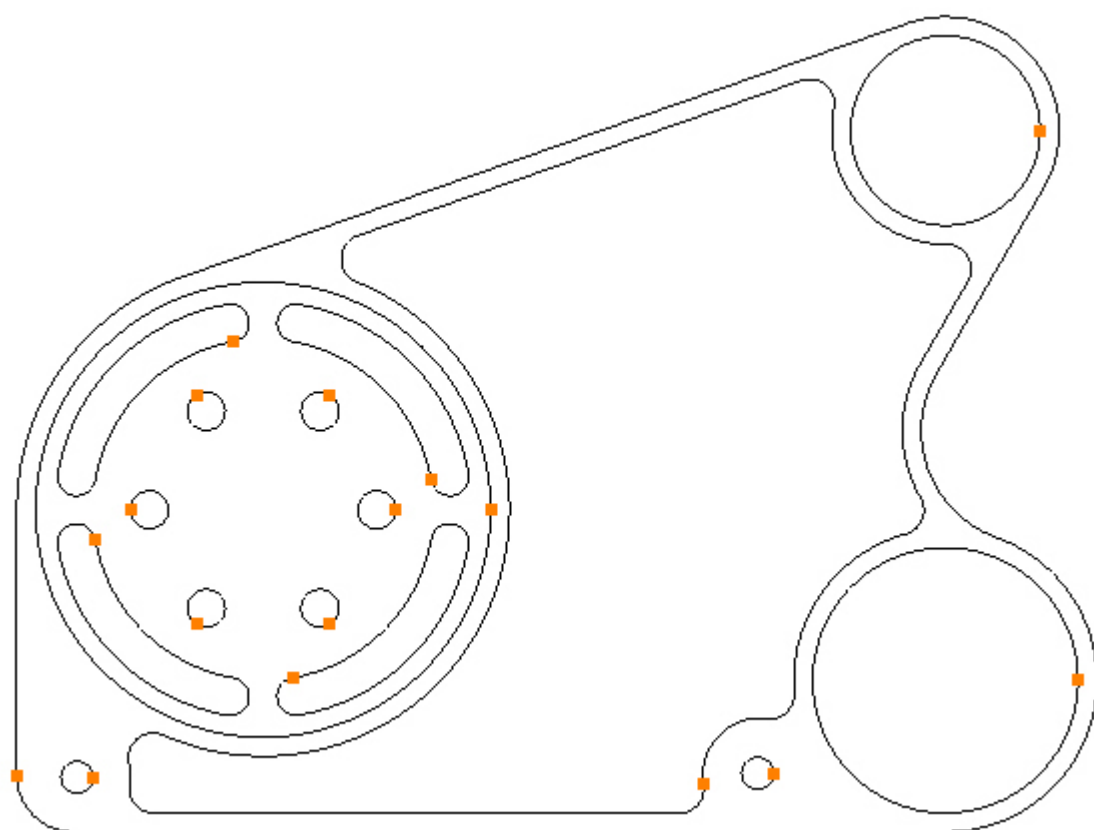
Menu: Modify -> Set Start Point

Toolbar button: 

Choose the command and move the cursor near to the end of the line on the left:



Left mouse click to set the start point:



Gear Housing Tutorial


Step 3 - Prepare for roughing

Prepare for Roughing Outside Profile

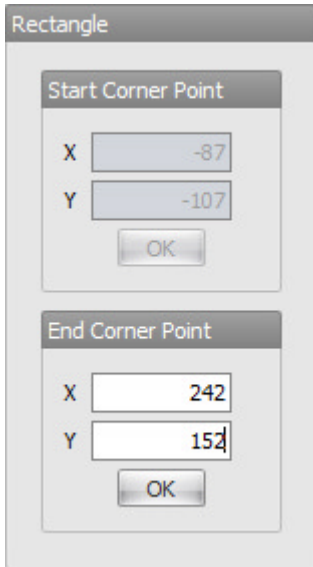
In order to rough the outside using a pocketing operation, a rectangle needs to be created that will contain the toolpaths.

Choose the Rectangle command:

Menu: Draw -> Rectangle

Toolbar button: 

Create a rectangle with a start point value of X-87, Y-107 and an end point value of X242, Y152:



Rectangle

Start Corner Point

X -87

Y -107

OK

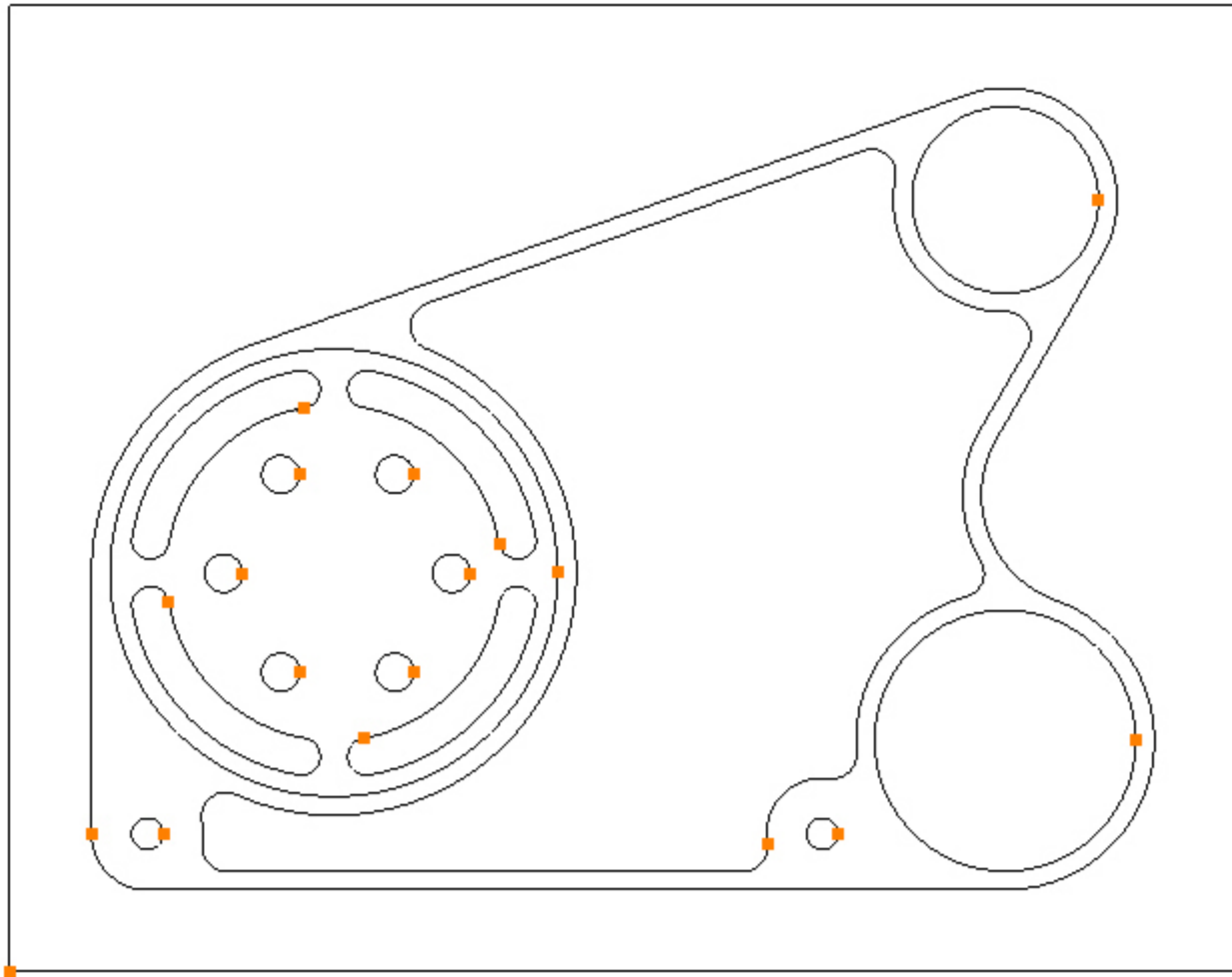
End Corner Point

X 242

Y 152

OK

The Part should now look like this:




Gear Housing Tutorial

Step 4 - Rough outside profile

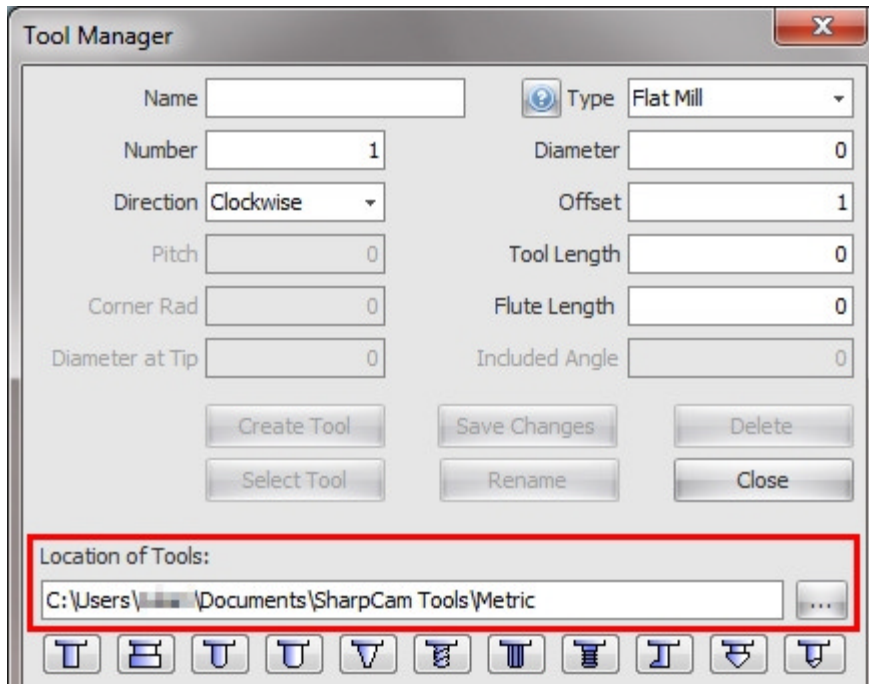
Rough Outside Profile using Pocket


Before choosing the pocket command, first select the cutting tool to be used for the operation. The Tool Manager is used to select a tool:

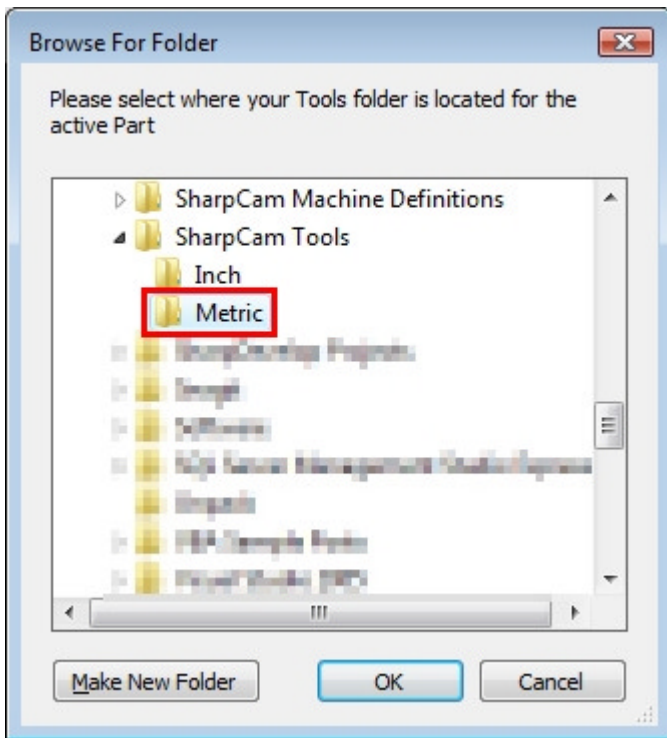
Menu: Machine-> Tool Manger

Toolbar button: 

Before selecting a tool, first check that the Tool Manager is pointing to the correct folder. The folder is indicated by the *Location of Tools* box:



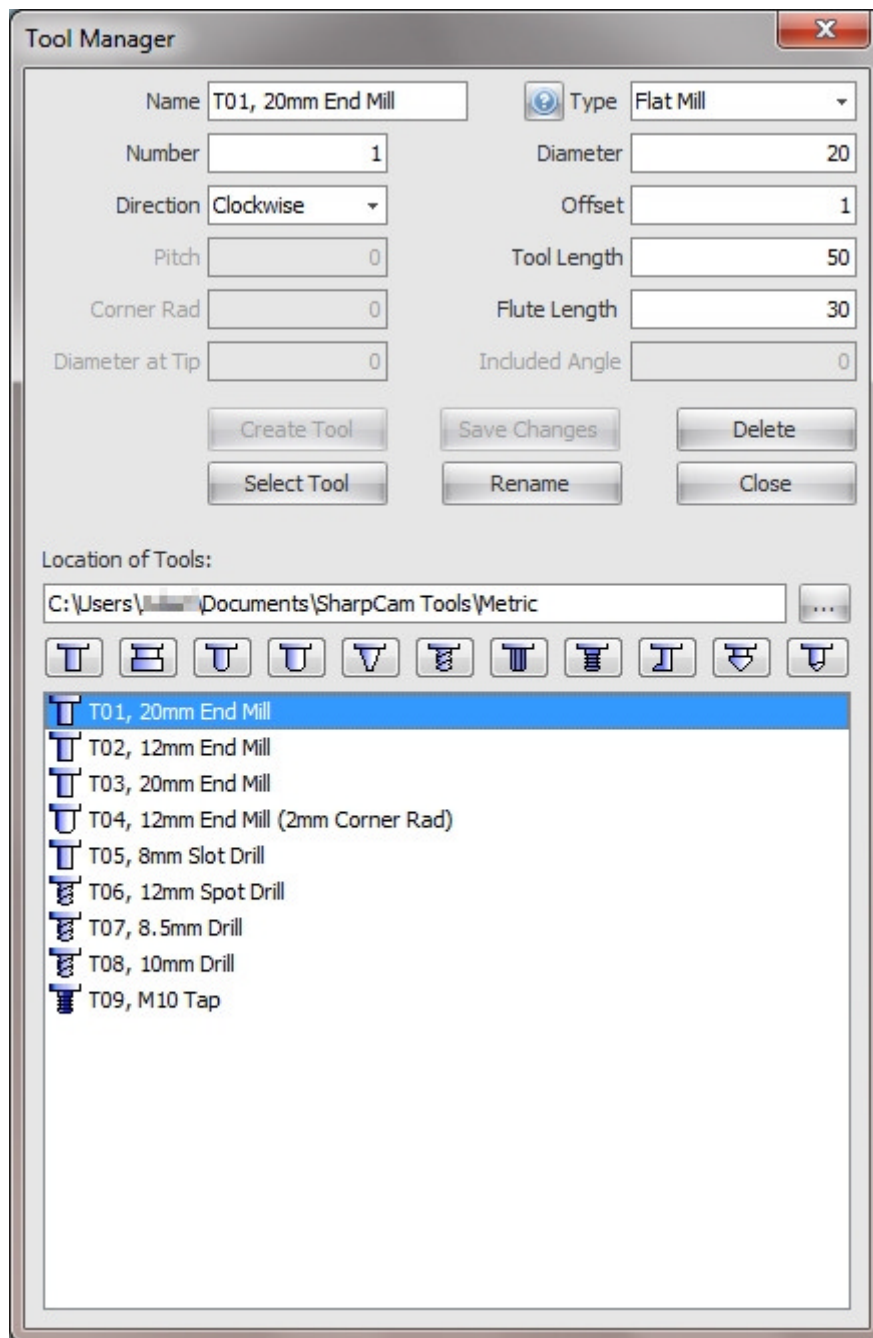
As this is a metric Part the *Metric* tools folder, that was installed at the same time as SharpCam, should be used. This folder is located in My Documents (Windows XP)/Documents (Vista)/Documents Library (Windows 7), inside a folder called *SharpCam Tools*. If the location is wrong, click the browse button  and navigate to '*SharpCam Tools*' folder and select the *Metric* folder and click OK:



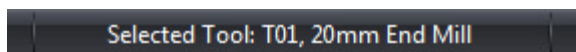
Choose the command to display the Tool Manager, click on 'T01, 20mm End Mill', then click the 'Select Tool' button. Alternatively double click a tool to select it.

 All the tools required for this tutorial were installed when SharpCam was installed for the first time.

Gear Housing Tutorial



The tool currently selected is displayed in the Status Bar at the bottom:



The outside is now ready to pocket, choose the command:

Menu: Machine-> Pocket

Toolbar button: 

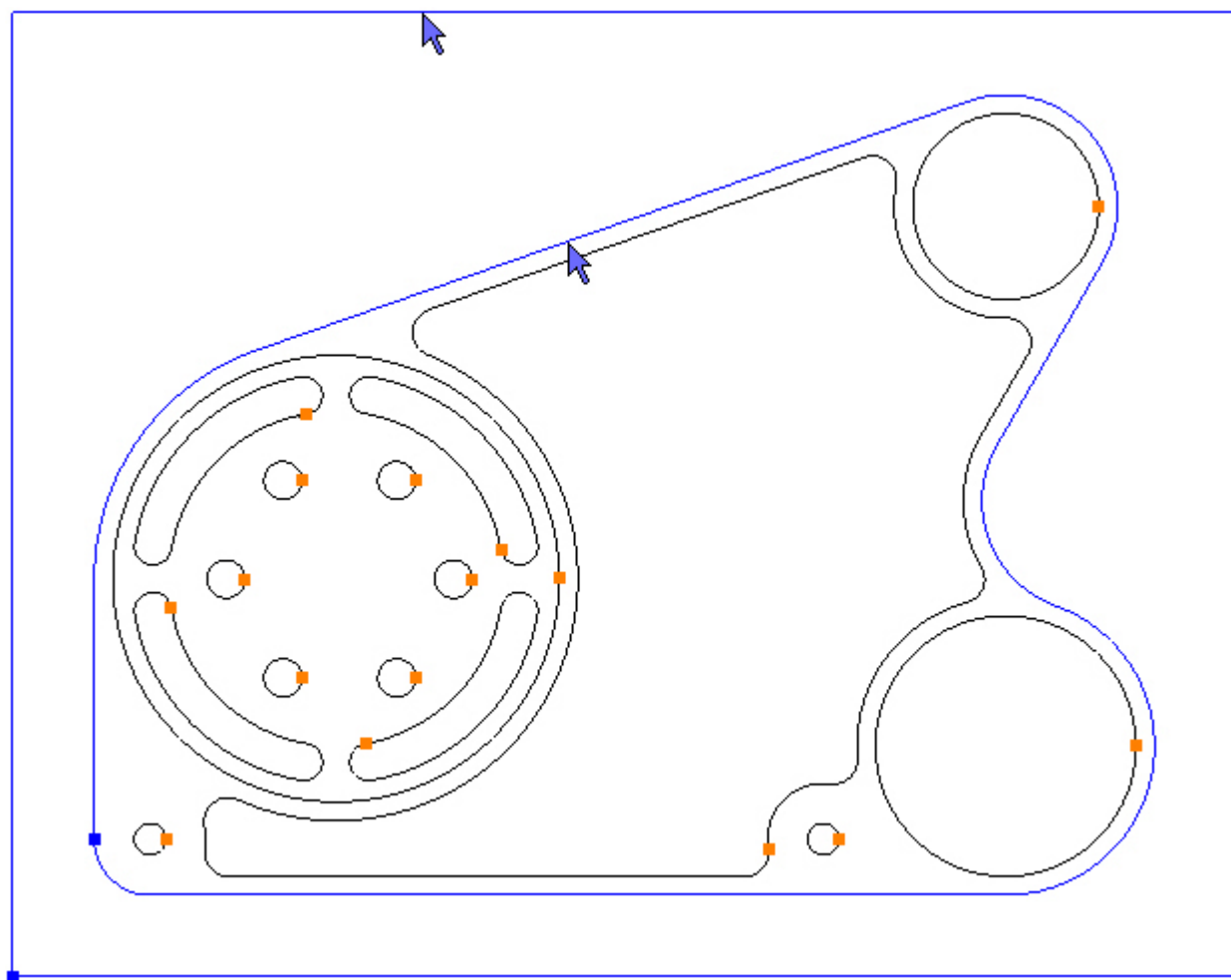
Enter the following values for the Z Positions:


Z Positions	
Initial Rapid	50
Feed From	2
Material Surface	0
Finish Depth	-26
Retract	2
Number of Passes	4
Depth of Cut	6.5

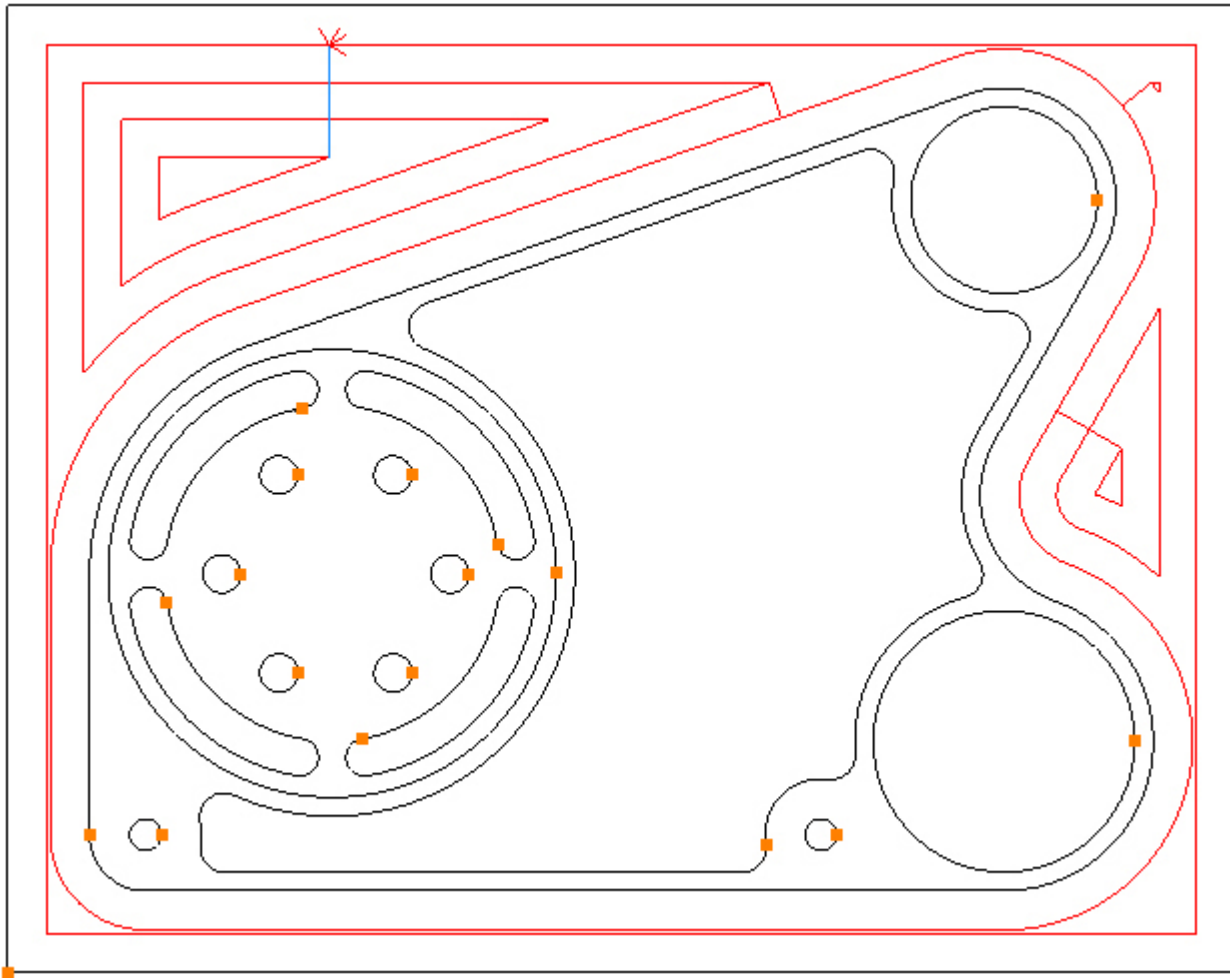
Enter the following values for the Cutting Data:

Cutting Data	
Spindle Speed	8000
Plunge Feed Rate	2000
Cut Feed Rate	1000
Finish Allowance	0.5
Step Over	10
Coolant	Flood

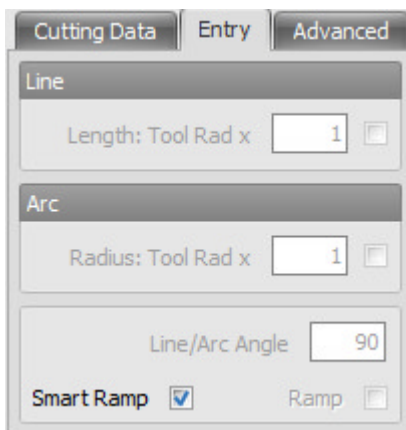
Select the outside profile and the outer rectangle by directly clicking them:



To pocket the selected Contours click the Add button . The toolpaths are created:




Looking at the resulting toolpaths a blue line can be seen in the top left hand corner. Blue indicates an Entry, the entry is configured using the Entry tab:



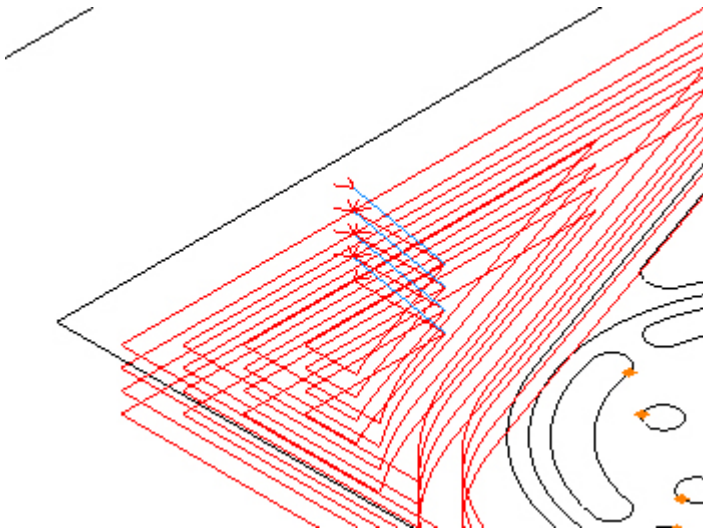
By default Smart Ramp is checked and the blue line is a result of this. To see what Smart Ramp is doing view the Part in an isometric view:

Menu: View -> Standard Views -> Isometric View

Toolbar button: 

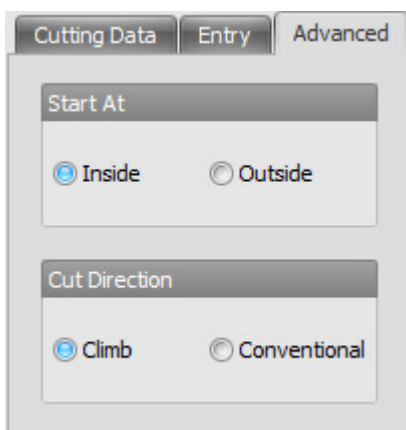
Choose the command and zoom in on the Smart Ramp by pointing the cursor at the Smart Ramp and rotating the middle mouse button:

Gear Housing Tutorial

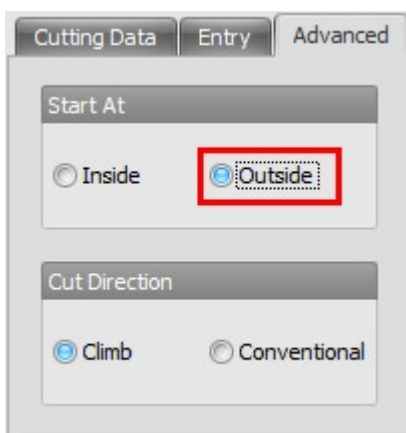


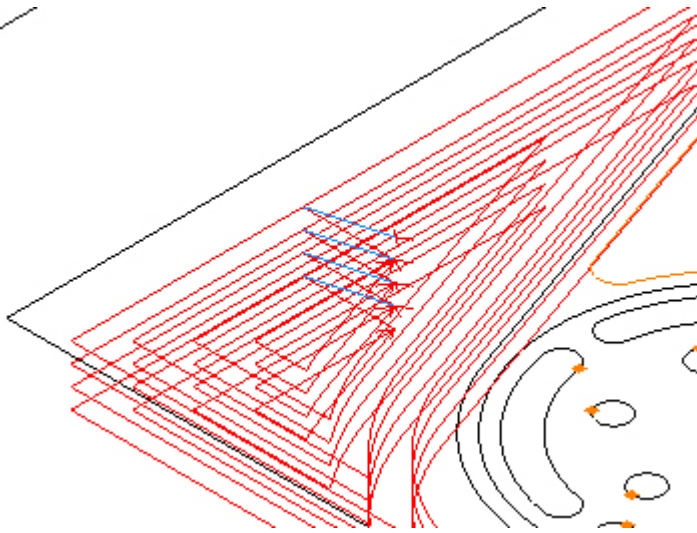
As can be seen the Smart Ramp, as the name implies, automatically ramps to depth at the shallowest angle possible. As it is the outside profile that is being machined Smart Ramp is not needed, because it is possible to plunge to depth outside of the billet.

First start from the outside, click the Advanced tab:

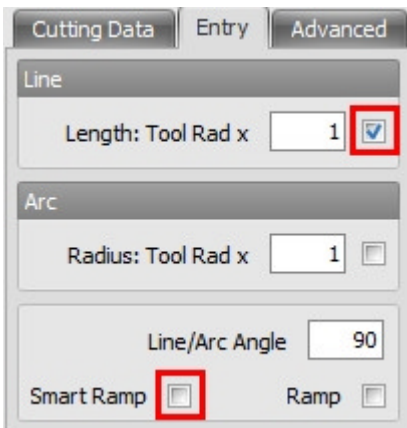


At the moment the pocketing starts from the inside, click the outside radio button and the toolpaths will be recalculated to start from the outside:

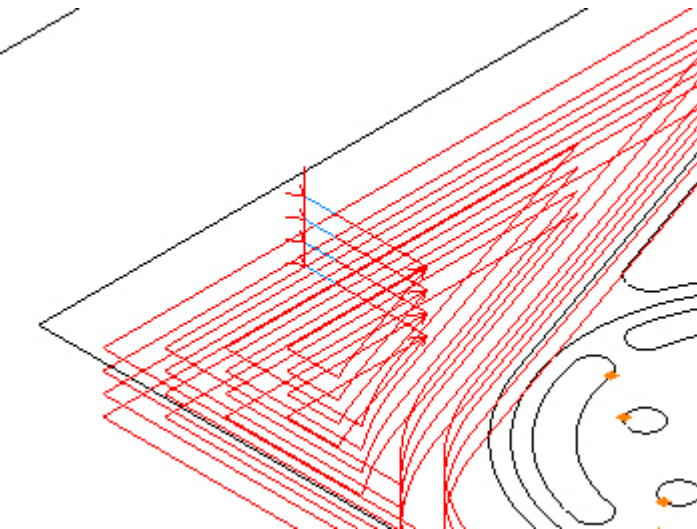




Choose the Entry tab and uncheck the Smart Ramp check box and check the Line check box:



Now the tool is plunging in fresh air:



To start further outside of the billet increase the length of the entry line. Change the entry line length, for example, to 2 (2 x the tool radius = 20):

Gear Housing Tutorial

Cutting Data Entry Advanced

Line

Length: Tool Rad x ☒

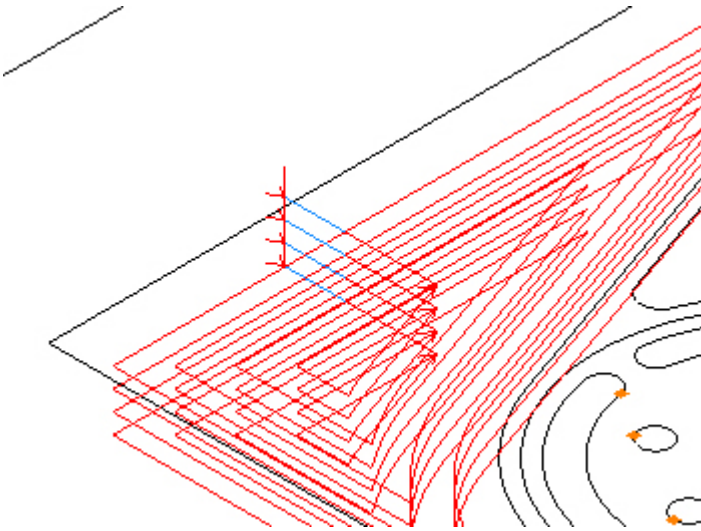
Arc

Radius: Tool Rad x ☐

Line/Arc Angle

Smart Ramp ☐ Ramp ☐

To update this change click the Refresh button :




Changes to any value in a box are updated by clicking the Refresh button.


Step 5 - Rough counterbore

Rough Ø120 counterbore using Pocket

Menu: Machine-> Pocket

Toolbar button: 

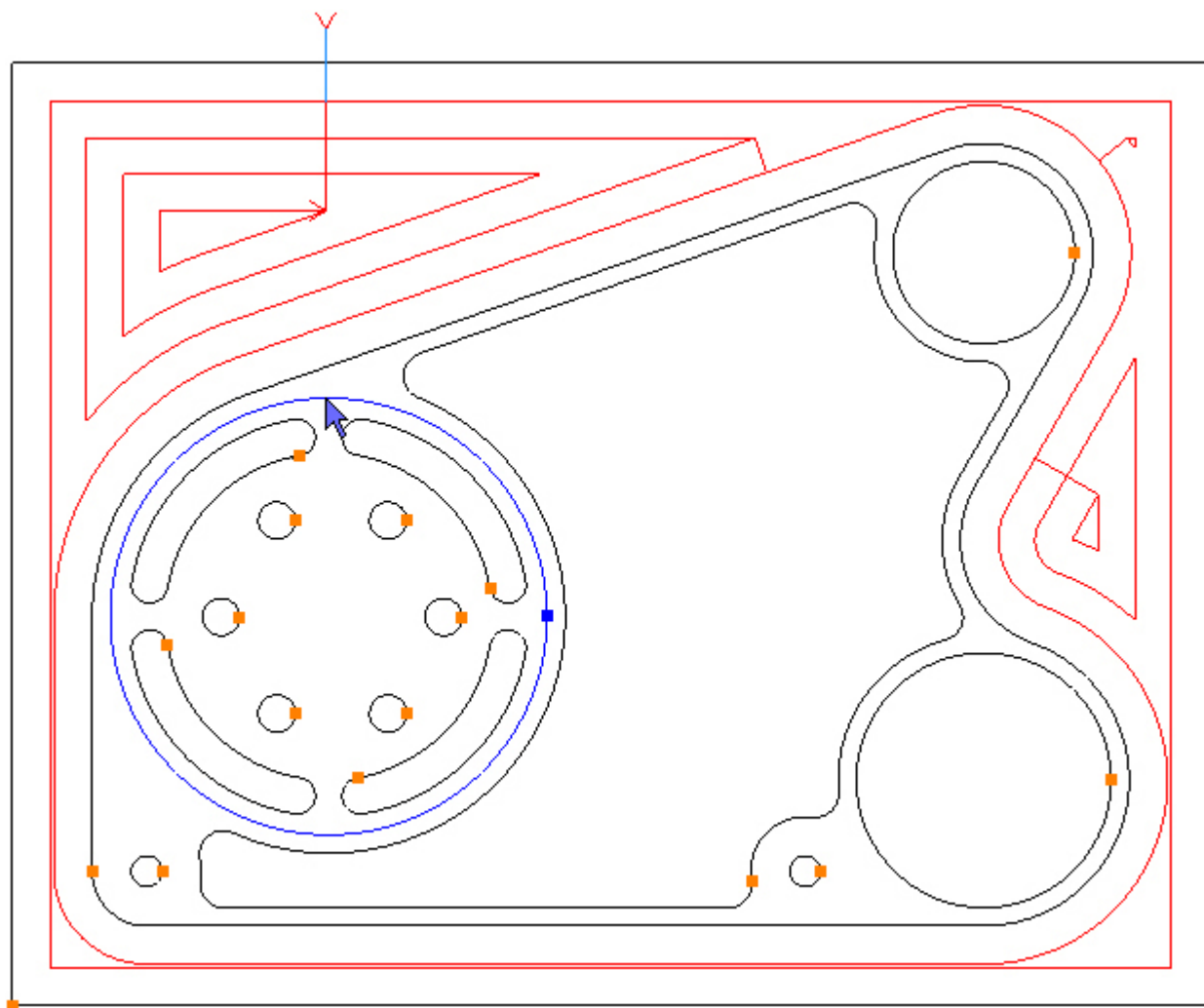
Choose the command and enter the following Z Positions:

Z Positions	
Initial Rapid	<input type="text" value="2"/>
Feed From	<input type="text" value="2"/>
Material Surface	<input type="text" value="0"/>
Finish Depth	<input type="text" value="-14.5"/>
Retract	<input type="text" value="2"/>
Number of Passes	<input type="text" value="2"/>
Depth of Cut	 <input type="text" value="7.25"/>

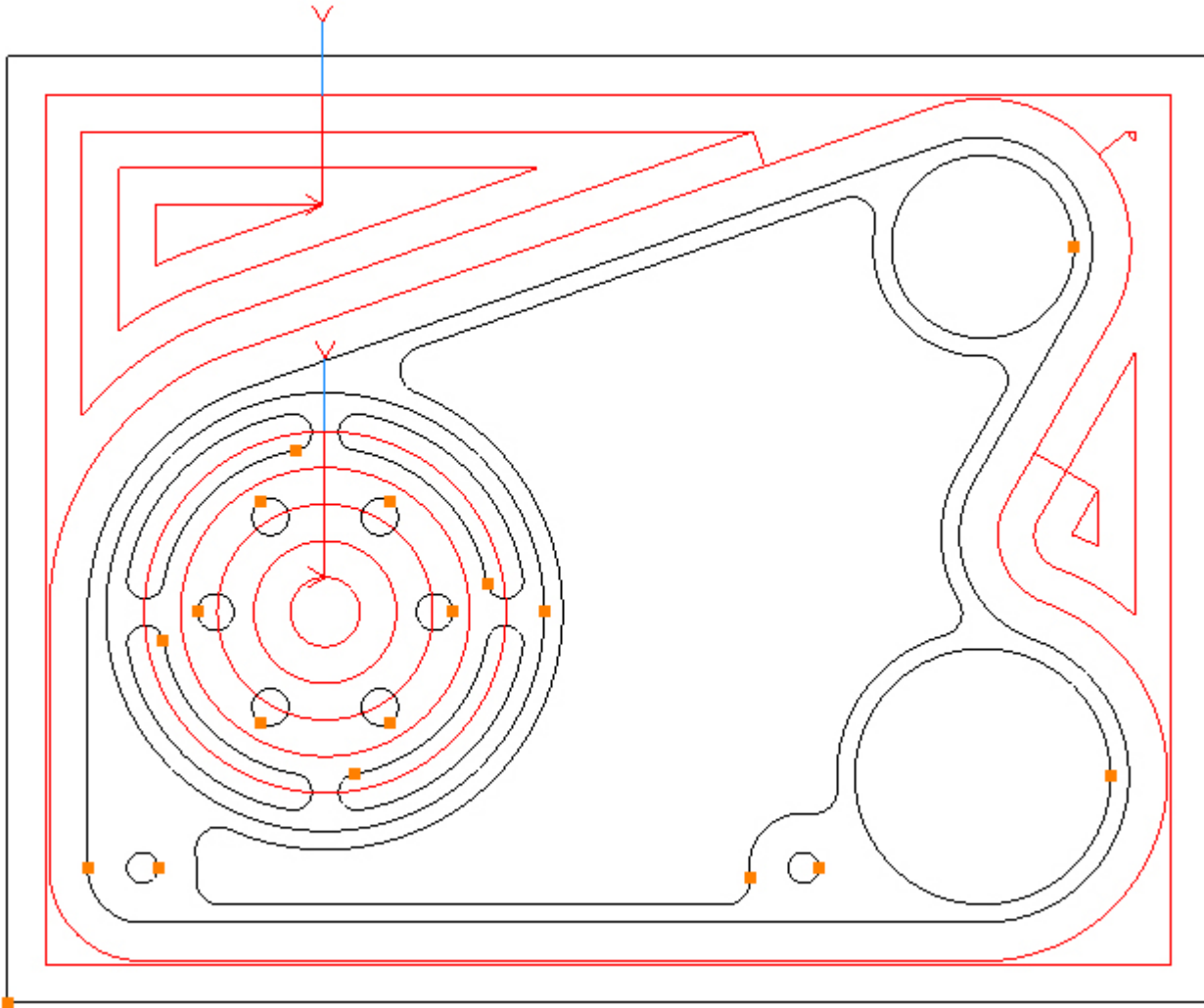
Enter the following values for the Cutting Data:

Cutting Data	
Entry	Advanced
Spindle Speed	<input type="text" value="8000"/>
Plunge Feed Rate	<input type="text" value="500"/>
Cut Feed Rate	<input type="text" value="750"/>
Finish Allowance	<input type="text" value="0.5"/>
Step Over	<input type="text" value="10"/>
Coolant	<input type="text" value="Flood"/>

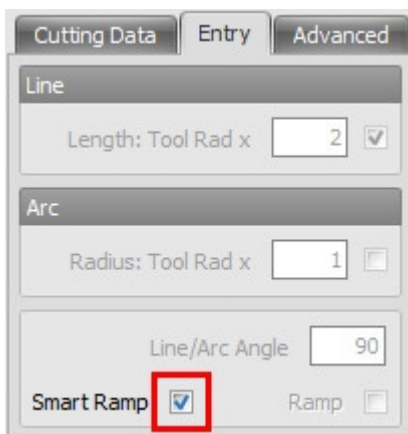
Select the Ø120 circle by directly clicking it:



To pocket the selected Contours click the Add button . The toolpath is created:

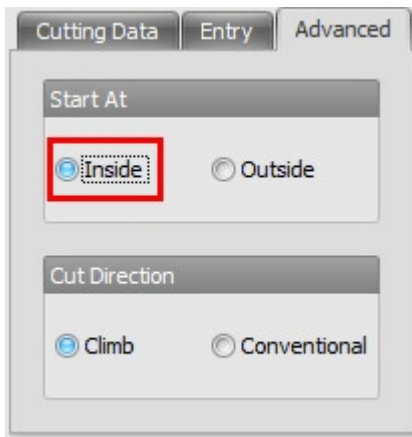


This time Smart Ramp is required, this is still unchecked from the previous pocketing operation. Choose the Entry tab and check Smart Ramp:

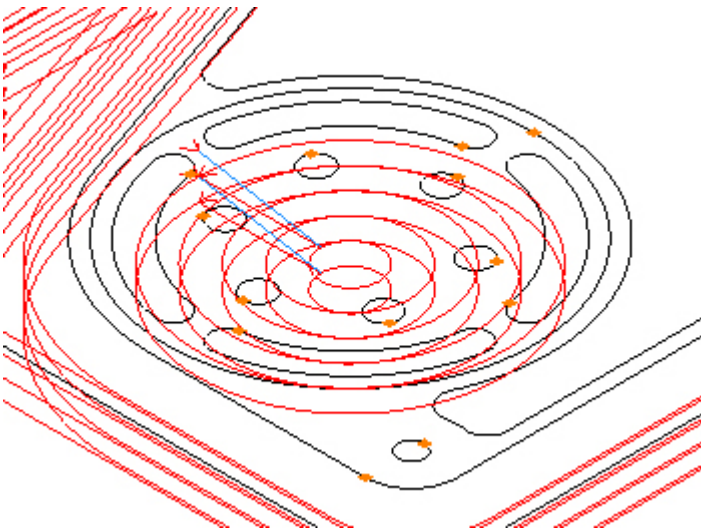


At the moment the pocketing starts from the outside, but it is preferable to start from the inside. Choose the Advanced tab and select the Inside Radio button:

Gear Housing Tutorial




The toolpath should look like this in isometric view:




Step 6 - Rough bores

Rough Ø50 and Ø70 bores using Pocket

Menu: Machine-> Pocket

Toolbar button: 

Choose the command and enter the following Z Positions:

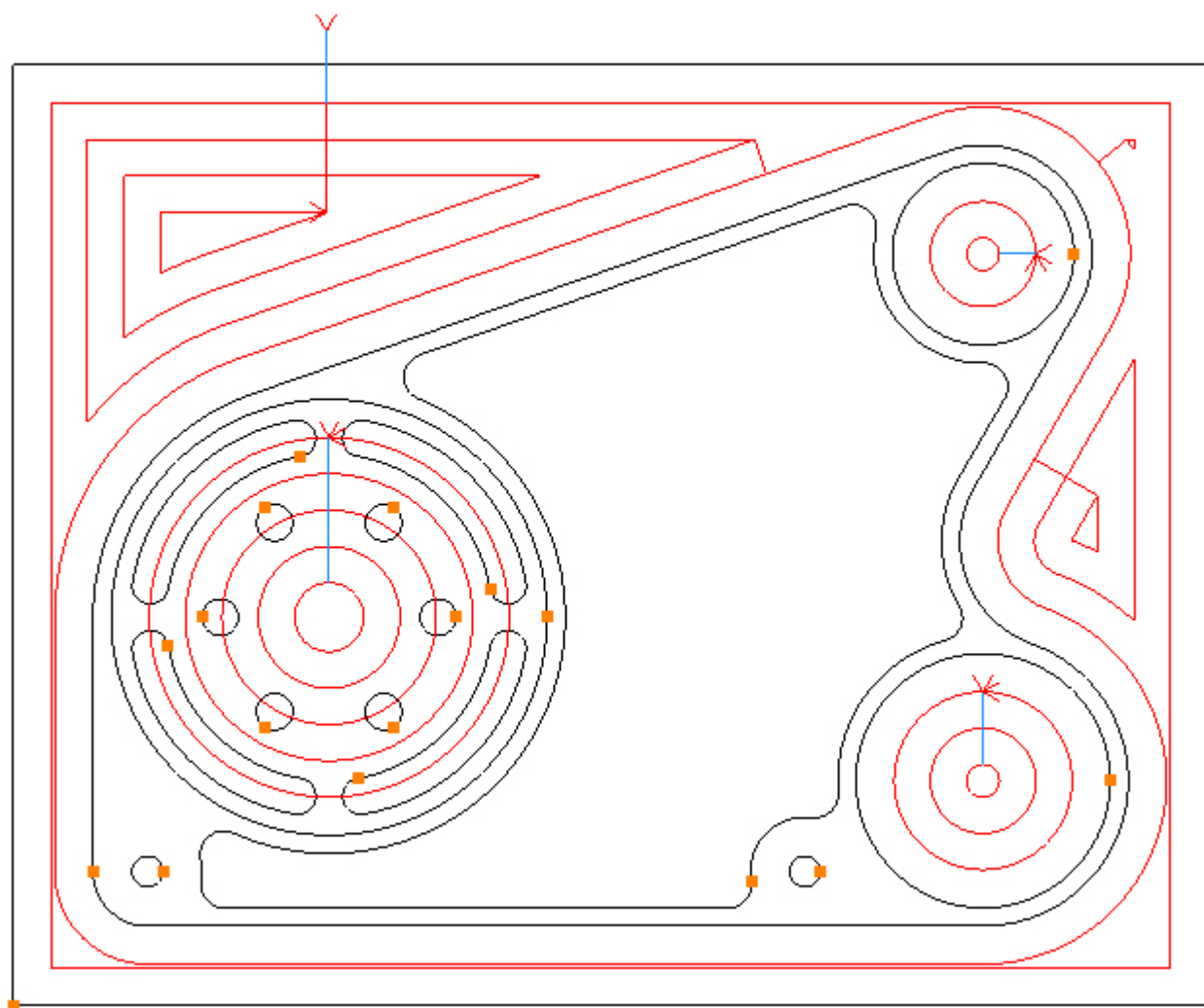
Z Positions	
Initial Rapid	<input type="text" value="2"/>
Feed From	<input type="text" value="2"/>
Material Surface	<input type="text" value="0"/>
Finish Depth	<input type="text" value="-32"/>
Retract	<input type="text" value="2"/>
Number of Passes	<input type="text" value="5"/>
Depth of Cut	 <input type="text" value="6.4"/>

Enter the following values for the Cutting Data:

Cutting Data	
Entry	Advanced
Spindle Speed	<input type="text" value="8000"/>
Plunge Feed Rate	<input type="text" value="200"/>
Cut Feed Rate	<input type="text" value="500"/>
Finish Allowance	<input type="text" value="0.5"/>
Step Over	<input type="text" value="10"/>
Coolant	<input type="text" value="Flood"/>

Select the Ø50 and Ø70 circles by directly clicking them:






Gear Housing Tutorial


Step 7 - Rough inside

Rough inside pocket using Pocket

Menu: Machine-> Pocket

Toolbar button: 

Choose the command and THEN select the tool for this operation.

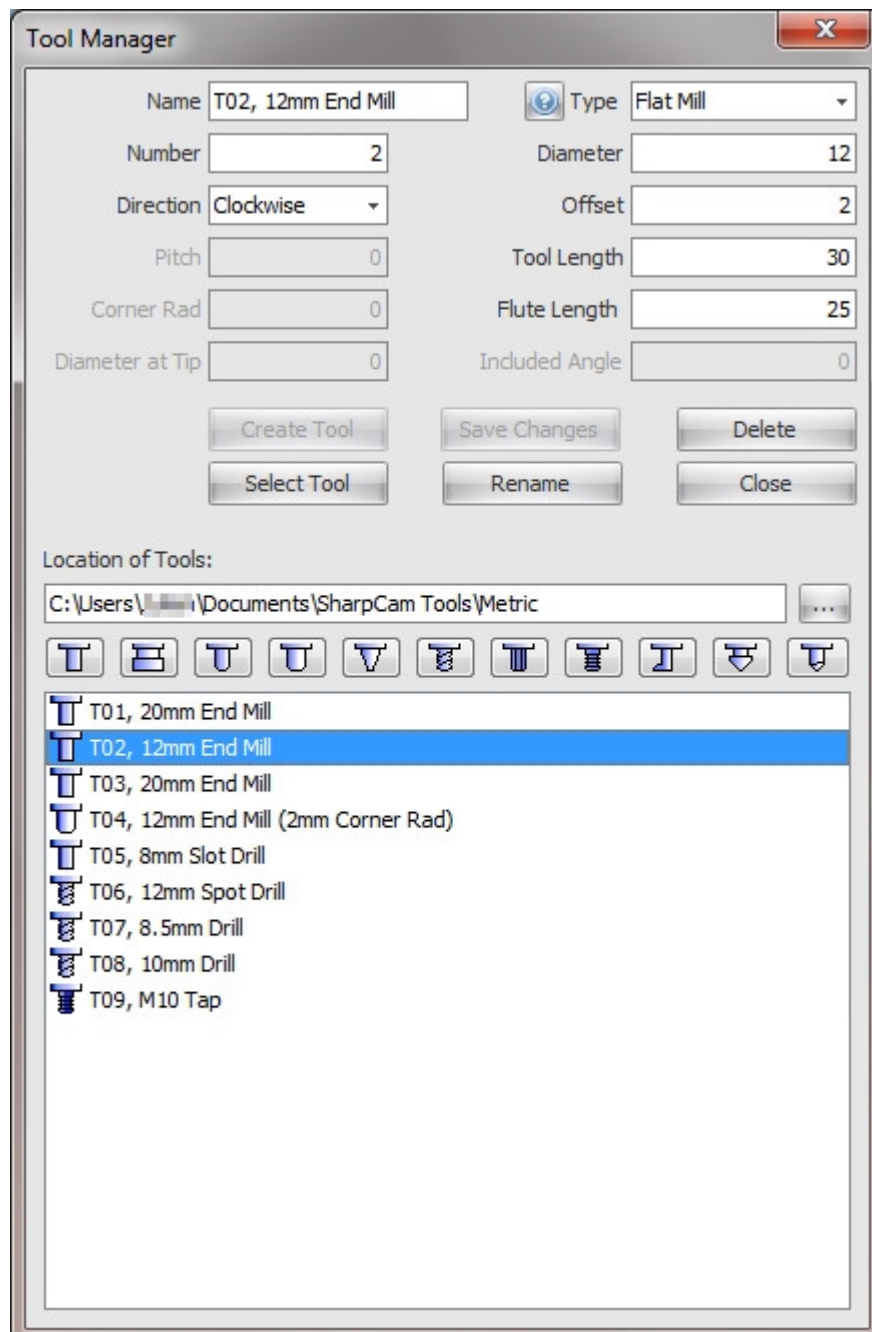
 If a tool is selected, before choosing the Pocket command, SharpCam will assume that the current operation is to be created with a different tool and will regenerate the toolpath accordingly (do not forget that the Ø50 and Ø70 bores have just been roughed and are still editing the operation).

Choose the Tool Manager:

Menu: Machine-> Tool Manger

Toolbar button: 

Choose the command to display the Tool Manager and click on 'T02, 12mm End Mill', then click the 'Select Tool' button. Alternatively double click a tool to select it:



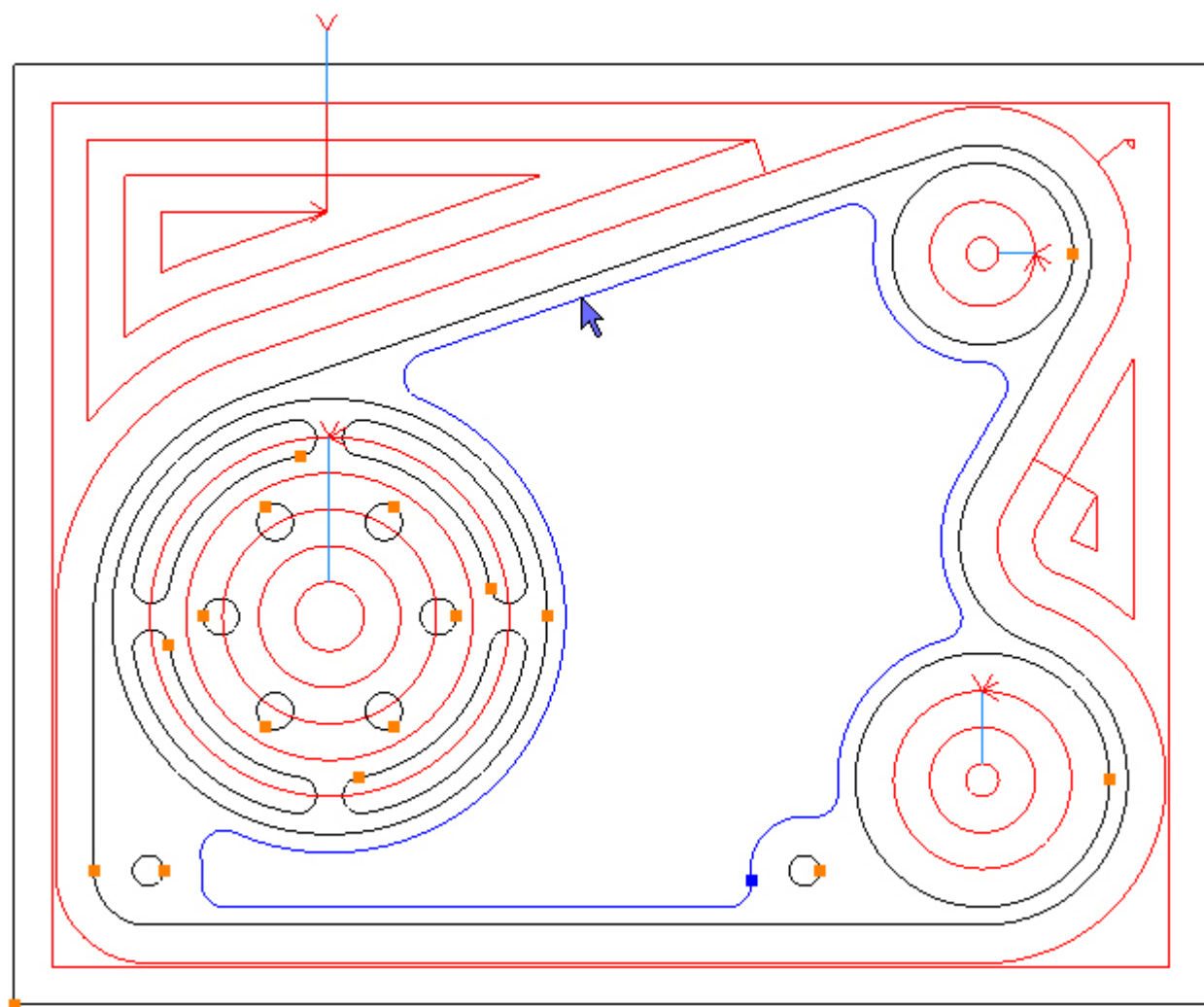
Enter the following Z Positions:


Z Positions	
Initial Rapid	50
Feed From	2
Material Surface	0
Finish Depth	-19
Retract	2
Number of Passes	4
Depth of Cut	4.75

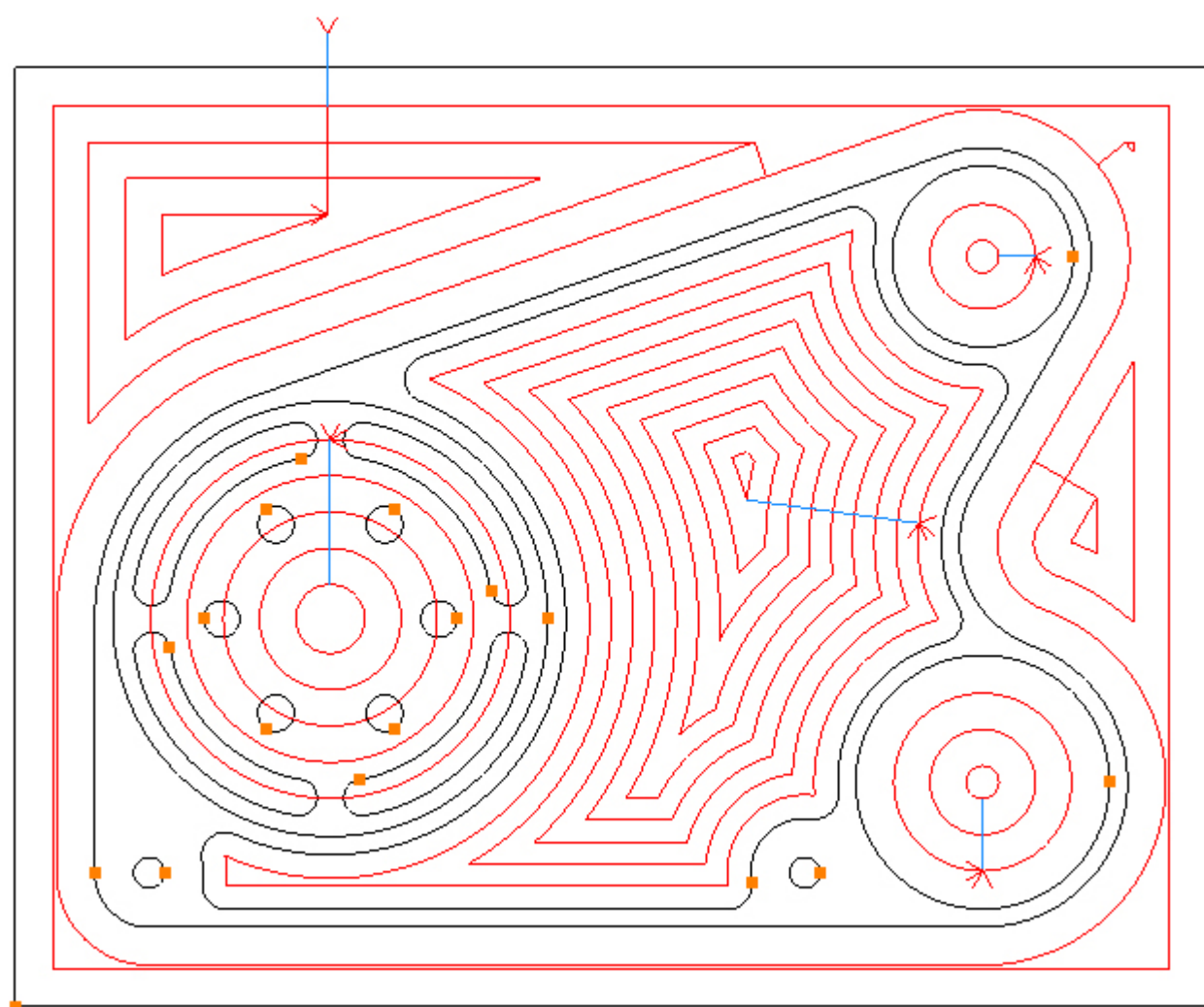
Enter the following values for the Cutting Data:

Cutting Data	
Entry	Advanced
Spindle Speed	10000
Plunge Feed Rate	1000
Cut Feed Rate	2500
Finish Allowance	0.5
Step Over	0.1
Coolant	Flood

Select the Contour on the inside by directly clicking it:



To pocket the selected Contour click the Add button . The toolpath is created:




Gear Housing Tutorial

Step 8 - Finish outside profile


Finish outside profile using Profile

Menu: Machine-> Profile

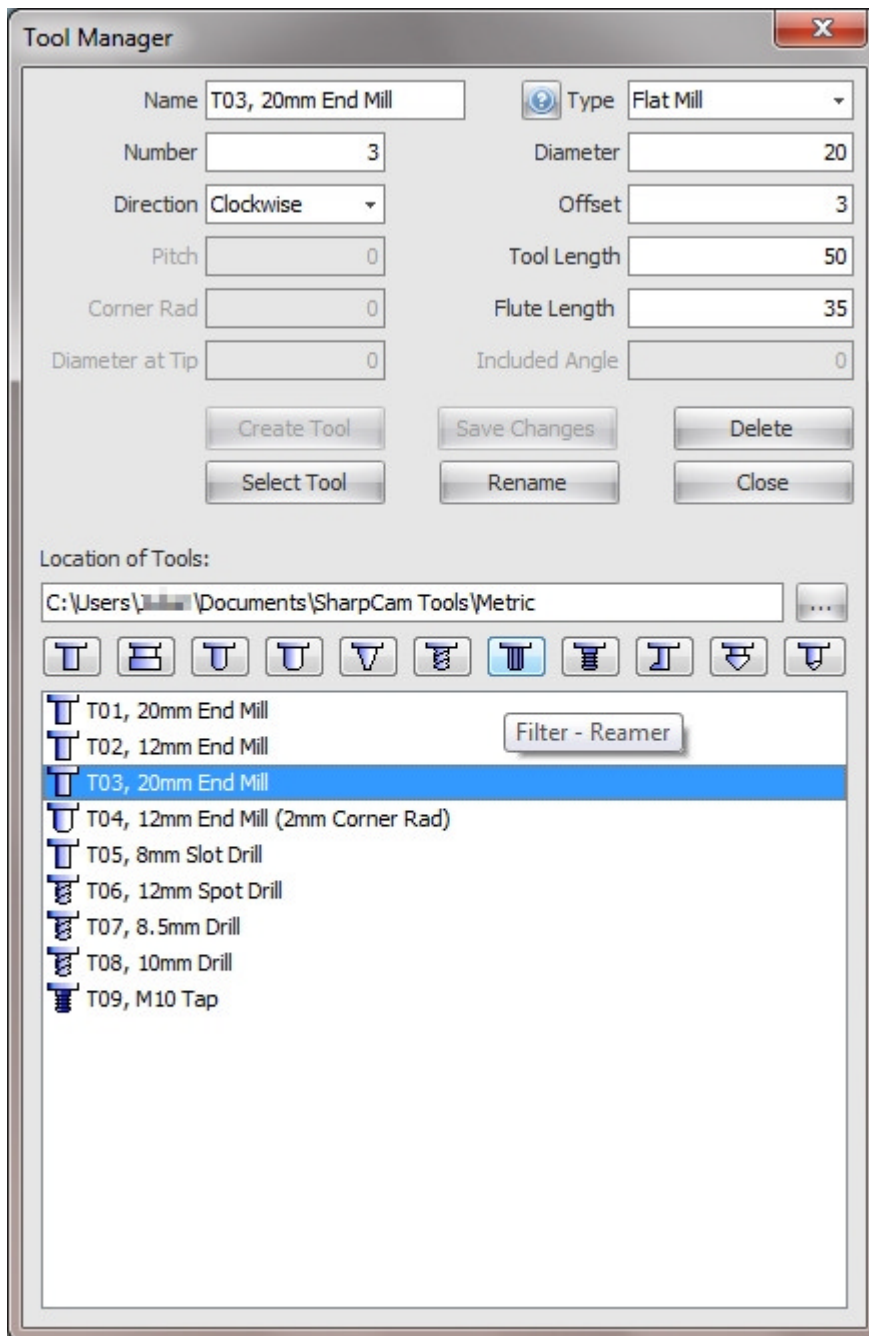
Toolbar button: 

Choose the Profile command then select the tool for this operation:

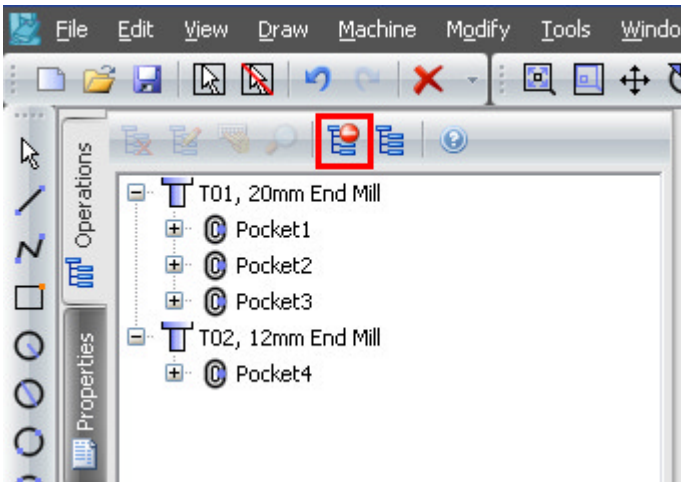
Menu: Machine-> Tool Manger

Toolbar button: 

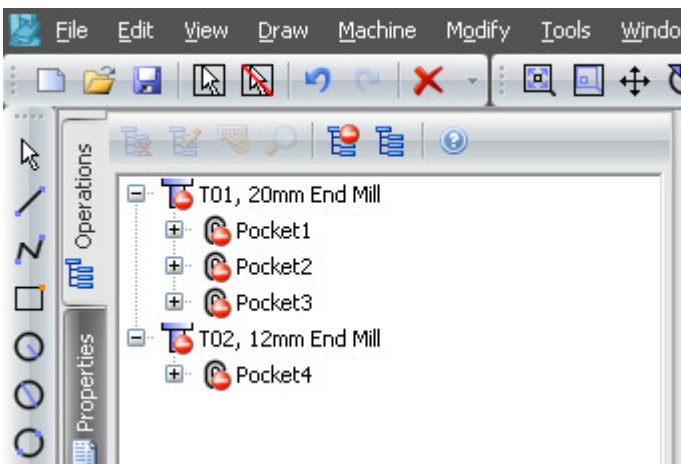
Choose the command to display the Tool Manager and click on 'T03, 20mm End Mill', then click the 'Select Tool' button. Alternatively double click a tool to select it:



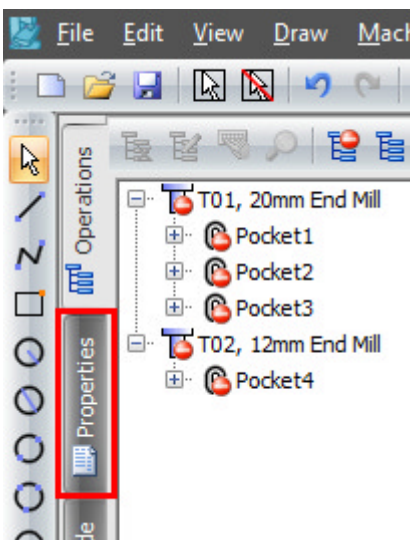
The Part now has a number of toolpaths. In order to prevent the view from being obscured, suppress them so they are hidden. Choose the Operations tab on the Part Manager and click the Suppress All button:



All operations now indicate that they are suppressed and the toolpaths are now hidden:




Click the Properties tab on the Part Manager to continue with the Profile command:



Enter the following Z Positions:

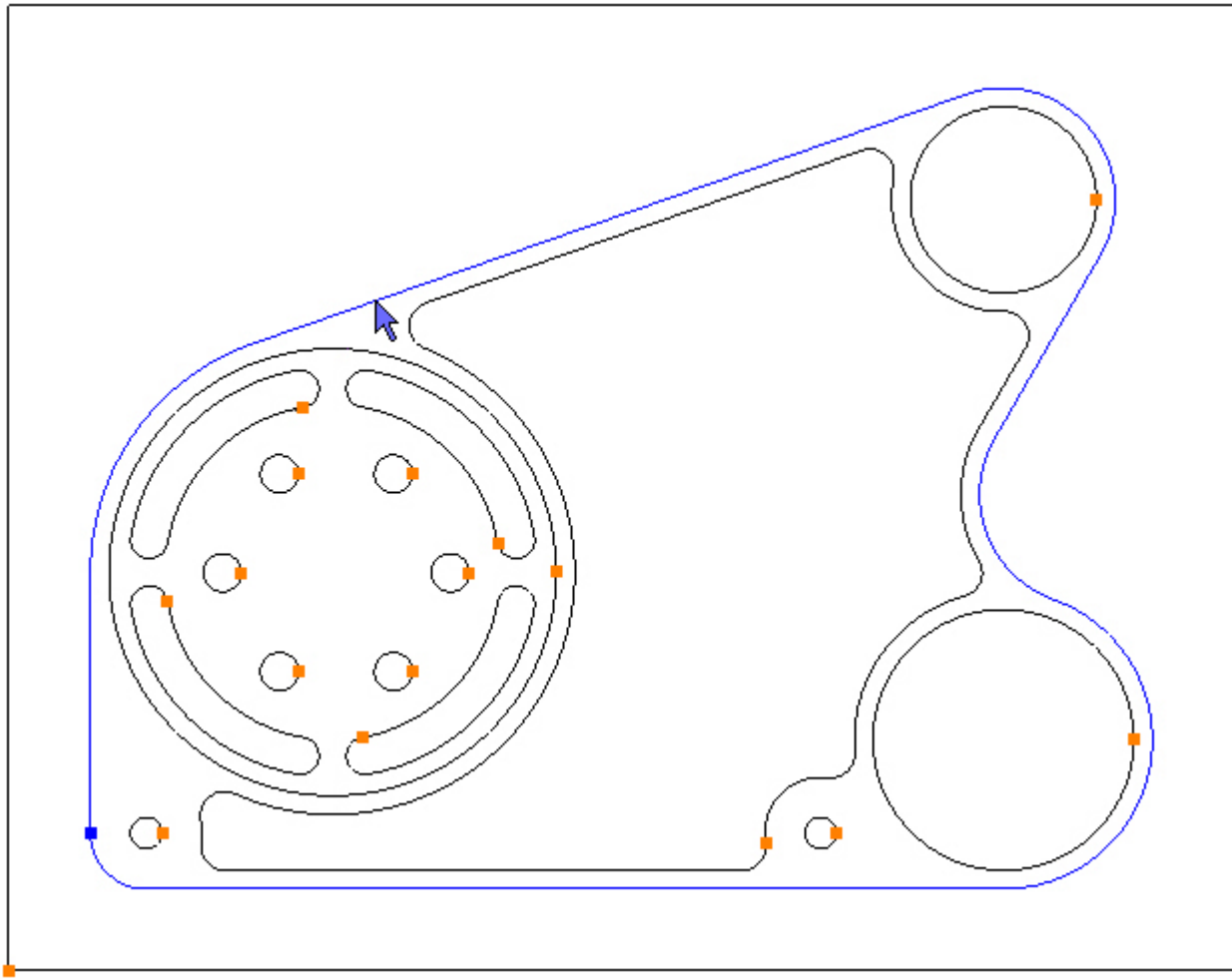
Gear Housing Tutorial


Z Positions	
Initial Rapid	50
Feed From	2
Material Surface	0
Finish Depth	-26
Retract	2
Number of Passes	1
Depth of Cut	 26

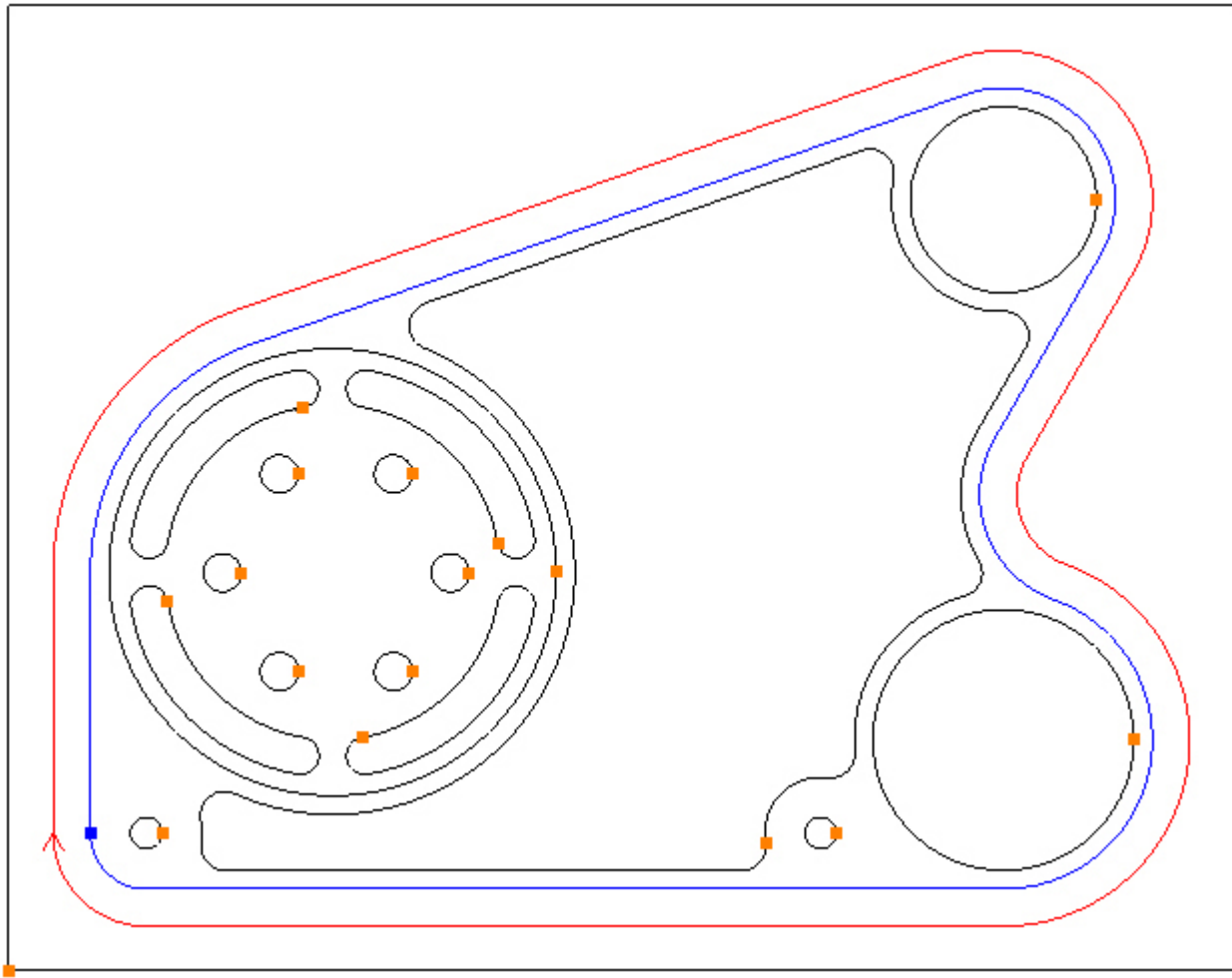
Enter the following values for the Cutting Data:

Cutting Data		Entry	Exit
Spindle Speed	8000		
Plunge Feed Rate	500		
Cut Feed Rate	1200		
Finish Allowance	0		
Coolant	Flood		
Cutter Radius Comp	None		
Sub Routines	<input type="checkbox"/>		

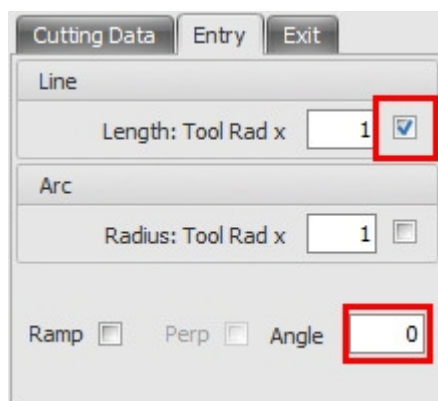
Select the outside Contour by directly clicking it:



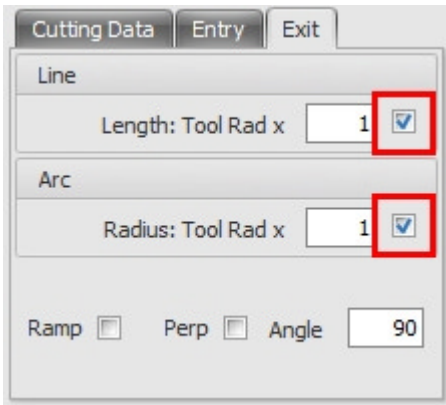
To profile the selected Contour click the Add button . The toolpath is created:



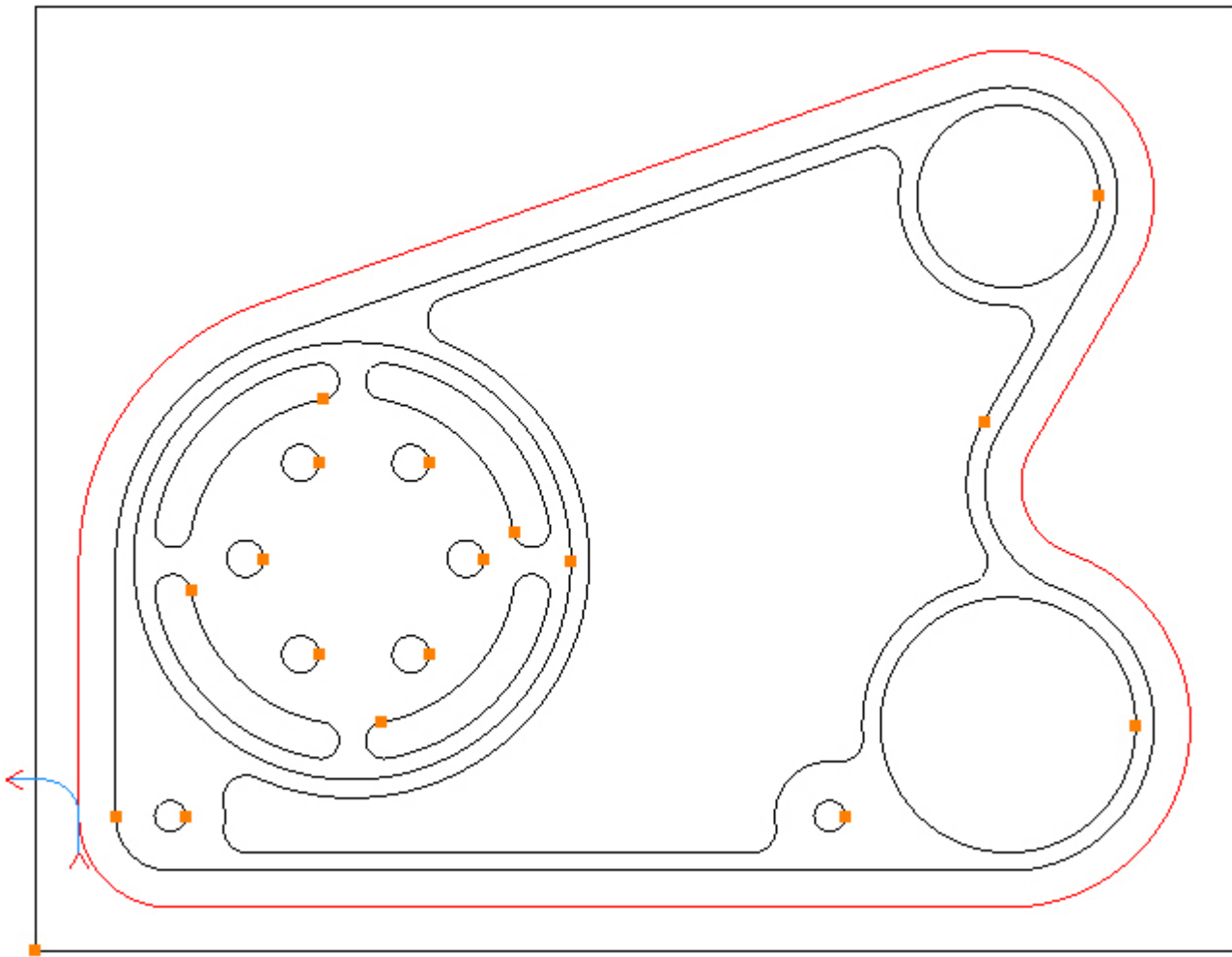
Add an entry and exit. Choose the Entry tab and change the Line/Arc Angle to 0 and check the Line check box:



Choose the Exit tab and check the Line and Arc check box:

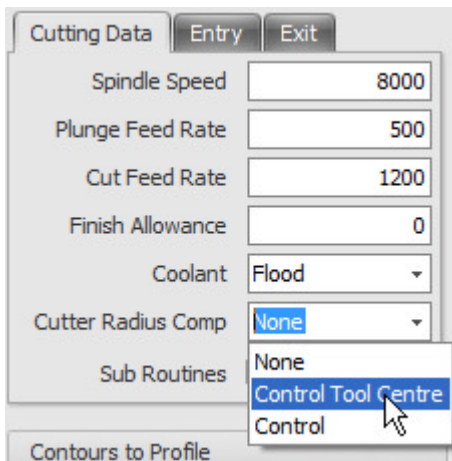


The entry and exit have been added:



Cutter radius compensation is required for this profile operation. Choose the Cutting Data tab and select *Control Tool Centre*:

Gear Housing Tutorial



The screenshot shows a CNC control interface with a 'Cutting Data' tab. The 'Entry' button is highlighted. The 'Exit' button is also visible. The 'Cutting Data' section contains the following fields:

Parameter	Value
Spindle Speed	8000
Plunge Feed Rate	500
Cut Feed Rate	1200
Finish Allowance	0
Coolant	Flood
Cutter Radius Comp	None
Sub Routines	None

The 'Sub Routines' dropdown menu is open, showing the following options:

- None
- Control Tool Centre
- Control


A mouse cursor is pointing at the 'Control Tool Centre' option. The 'Contours to Profile' button is located at the bottom left of the interface.

When using *Control Tool Centre*, zero must be entered in the control offset table for the correct size tool. Adjust the size with small + or - values.
If you prefer to enter the full radius in the control offset table, then choose *Control*.


Step 9 - Finish bores

Finish Ø50 and Ø70 bores using Profile

Menu: Machine-> Profile

Toolbar button: 

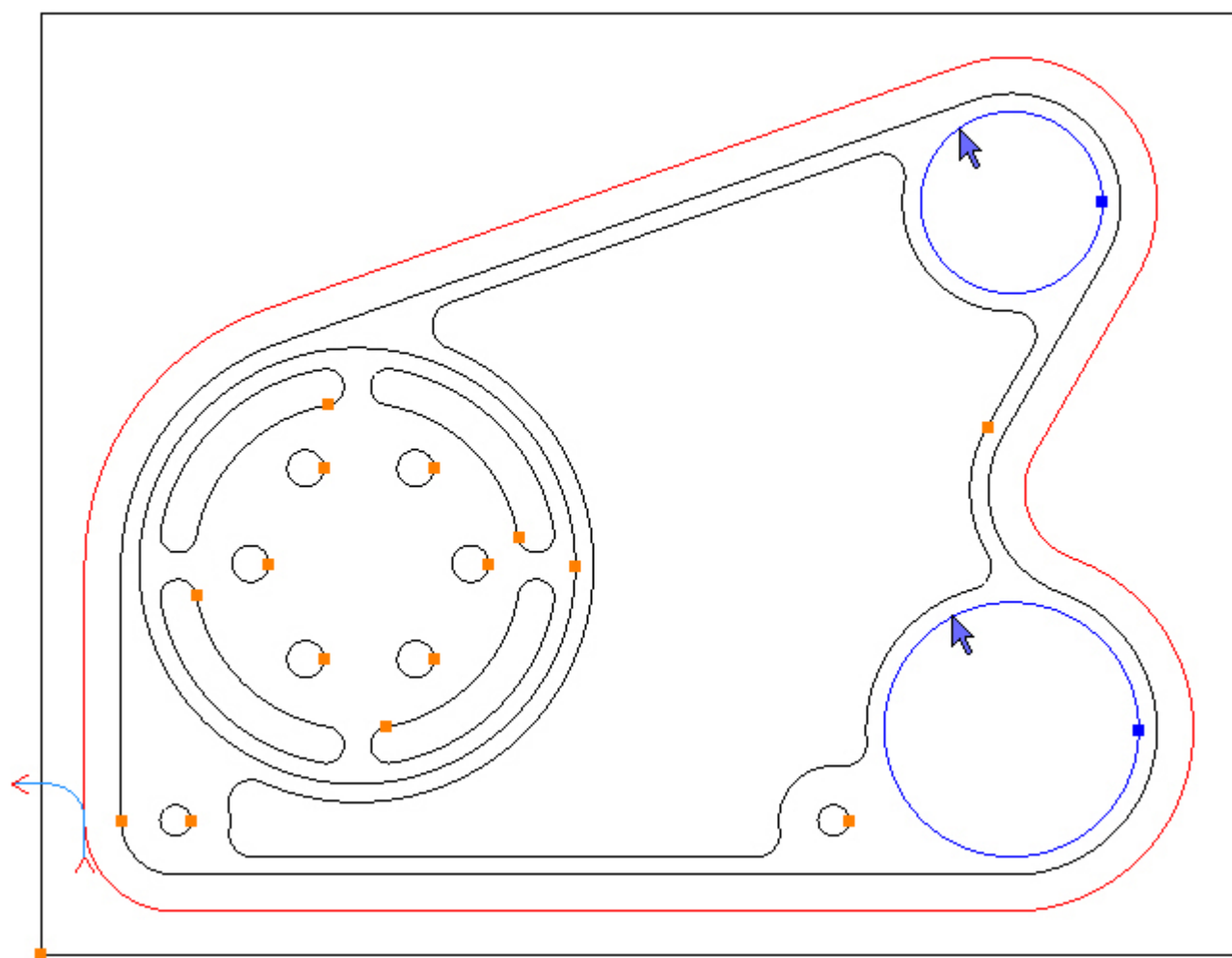
Choose the Profile command then select the tool and enter the following values for the Z Positions:

Z Positions	
Initial Rapid	2
Feed From	2
Material Surface	0
Finish Depth	-32
Retract	2
Number of Passes	1
Depth of Cut	 32

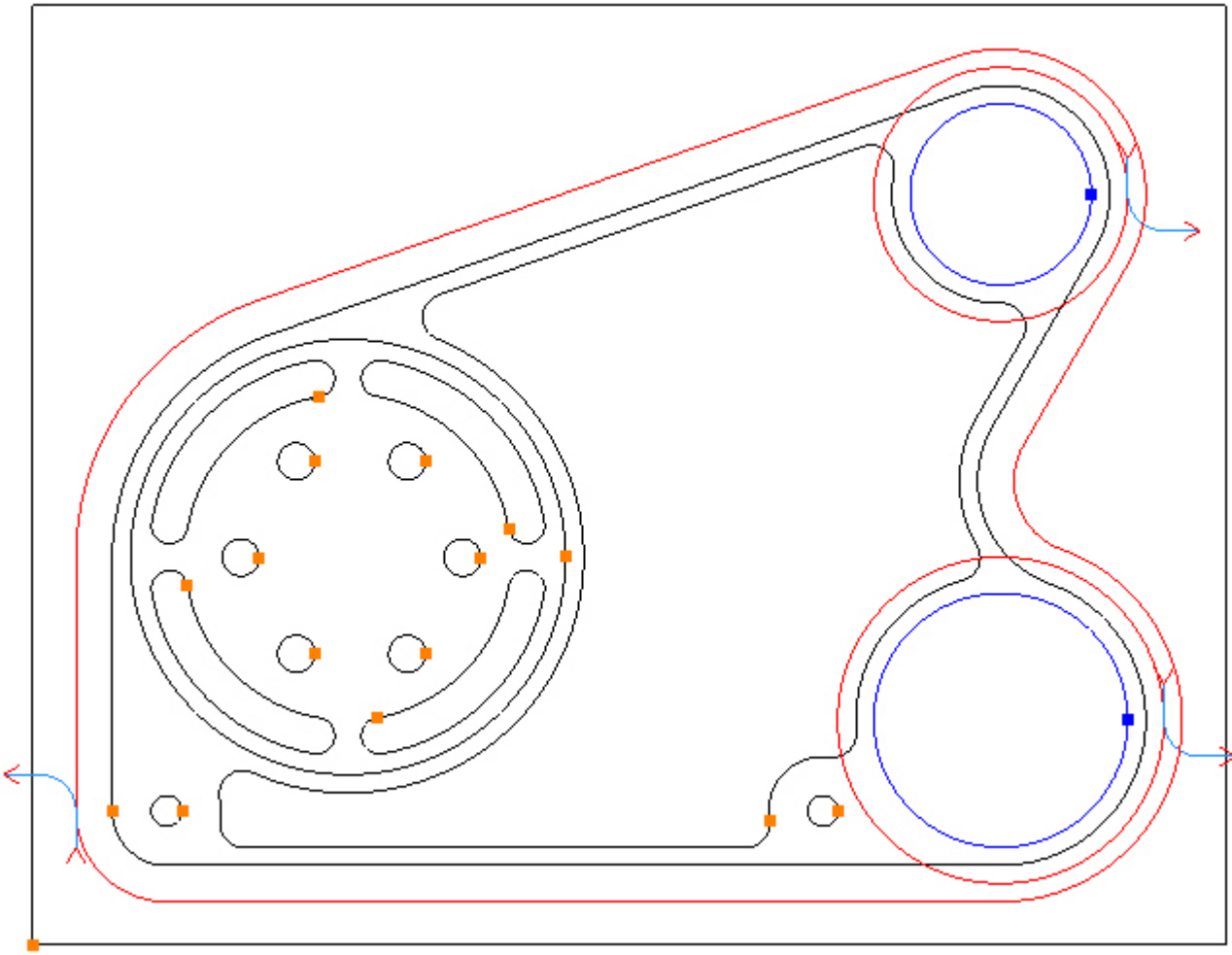
Enter the following values for the Cutting Data:

Cutting Data	
Spindle Speed	8000
Plunge Feed Rate	2000
Cut Feed Rate	1000
Finish Allowance	0
Coolant	Flood
Cutter Radius Comp	None
Sub Routines	<input type="checkbox"/>

Select the Ø50 and Ø70 circles by directly clicking them:



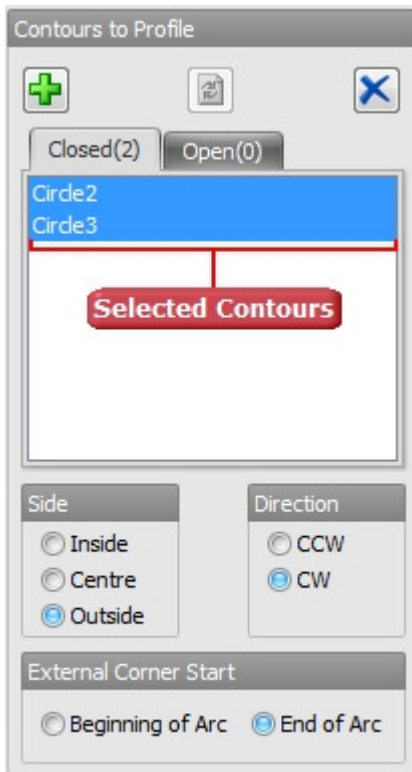
To profile the selected Contours click the Add button . The toolpaths are created:



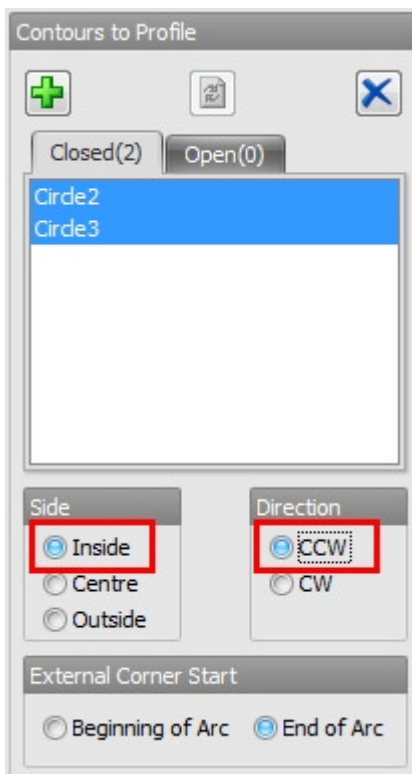
As can be seen the toolpaths are on the outside and in a clockwise direction, this is the default. This needs to be changed to the inside in a counter-clockwise direction.

The Contours must be selected in order to change the side and direction of the resulting toolpaths. When Contours are added to an operation they will be left selected. If the Contours are not selected they must be selected first, they can also be selected by clicking the name in *Contours to Profile* group box:

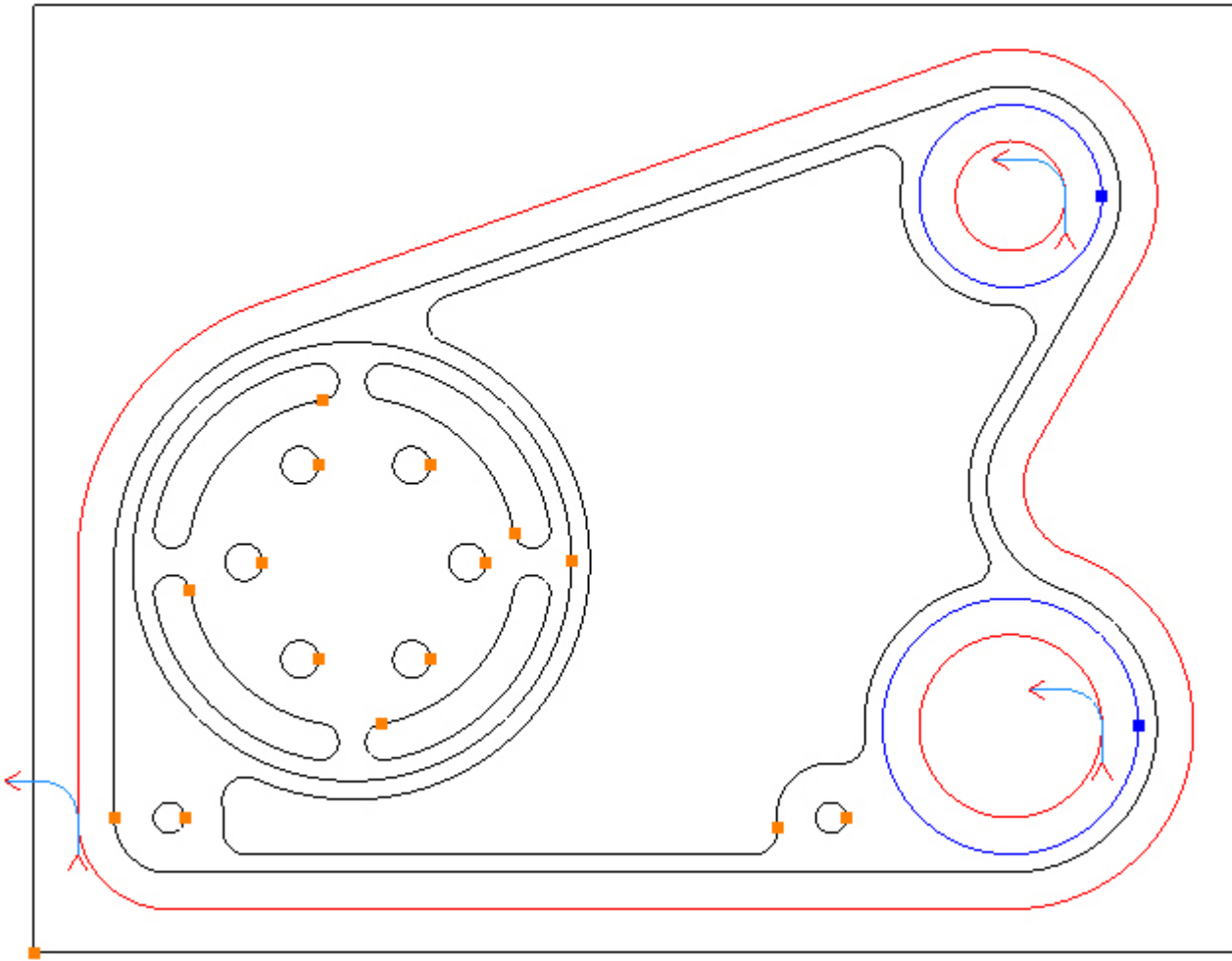
Gear Housing Tutorial



To change the side and direction click the appropriate radio button, in this case *Inside* and *CCW*:



The toolpath is now on the inside and in a counter-clockwise direction:

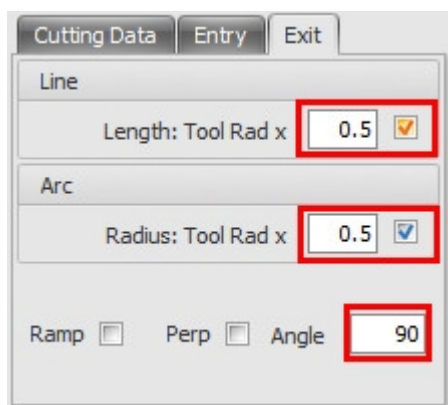


Change the entry and exit because the settings from the previous operation are still in effect. Choose the Entry tab and set the values (before checking the boxes) as below and check the line and arc check box:

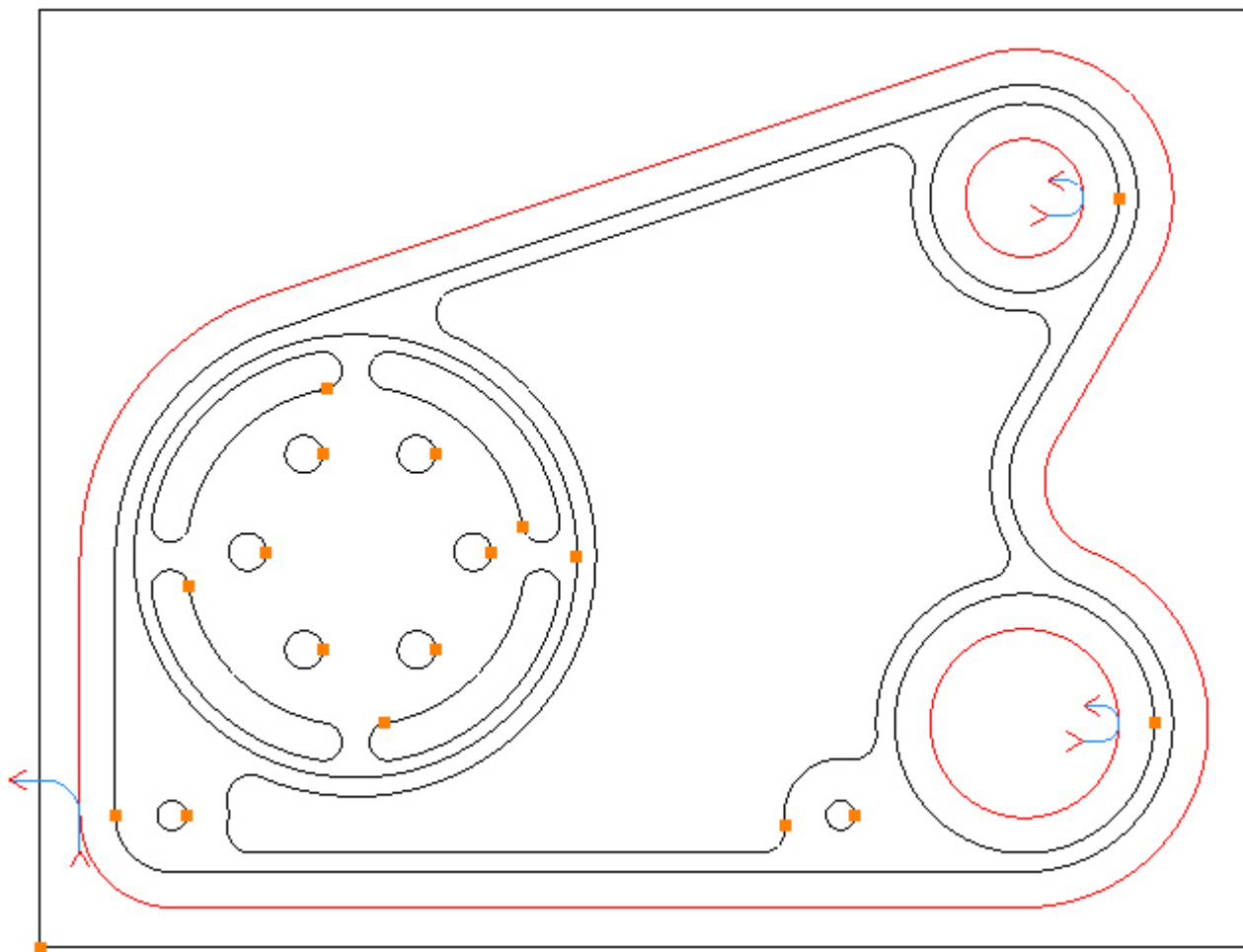
Cutting Data		Entry	Exit
Line			
Length: Tool Rad x	0.5	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Arc			
Radius: Tool Rad x	0.5	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Ramp	<input type="checkbox"/>	Perp	<input type="checkbox"/>
Angle	90		

Choose the Exit tab and change the Length and Radius values and click the Refresh  button:

Gear Housing Tutorial



The entry and exit have been added:




Cutter radius compensation is required for this profile operation. Choose the Cutting Data tab and select *Control Tool Centre*:

Cutting Data		Entry	Exit
Spindle Speed		8000	
Plunge Feed Rate		2000	
Cut Feed Rate		1000	
Finish Allowance		0	
Coolant		Flood	
Cutter Radius Comp		Control Tool Ce	
Sub Routines	<input type="checkbox"/>		

Deselect the Contours in readiness for the next operation:

Menu: Edit -> Deselect All


Toolbar button: 

Gear Housing Tutorial


Step 10 - Finish counterbore

Finish Ø120 counterbore using Pocket

Menu: Machine-> Pocket

Toolbar button: 

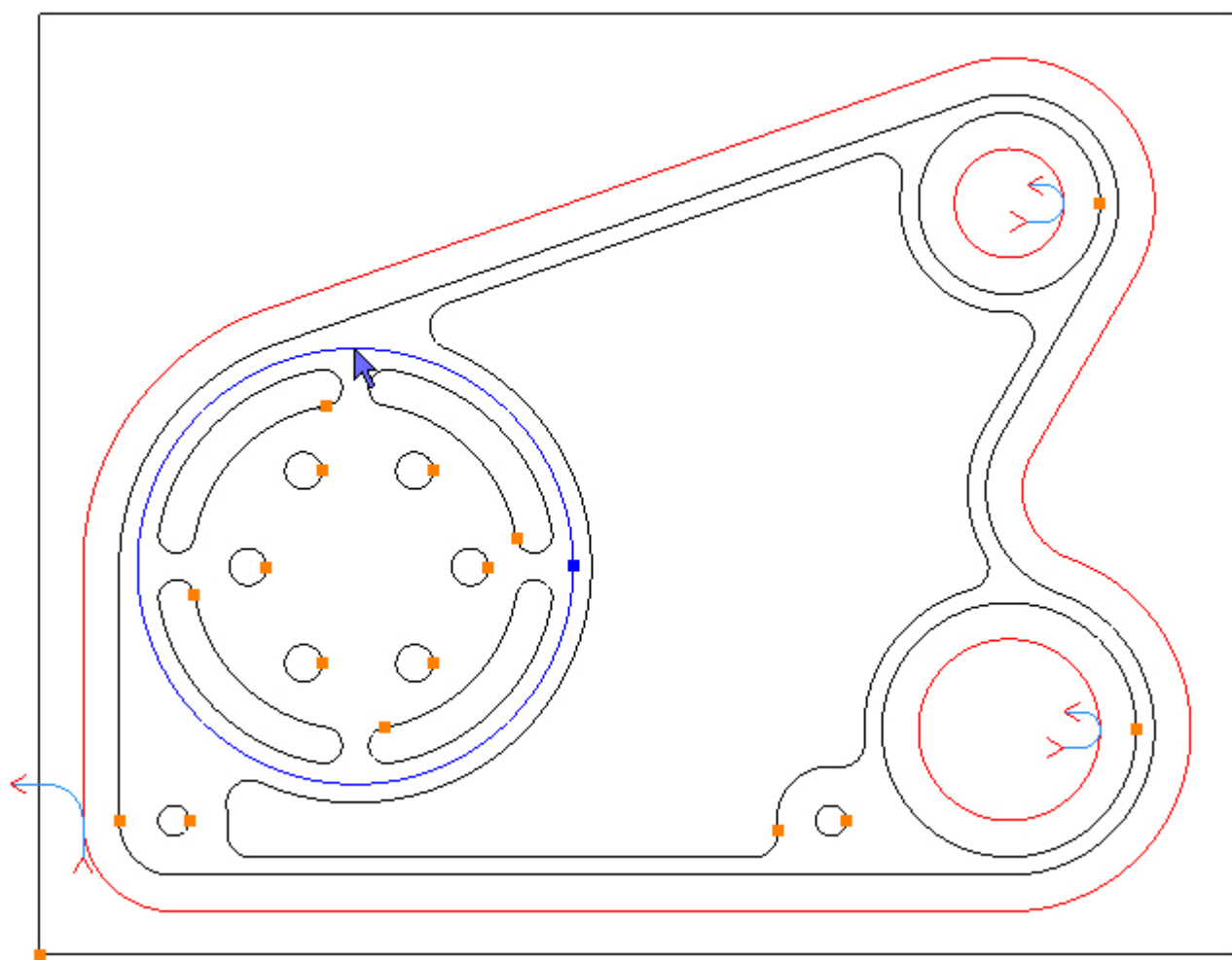
Choose the command and enter the following values for the Z Positions:


Z Positions	
Initial Rapid	<input type="text" value="2"/>
Feed From	<input type="text" value="-12.5"/>
Material Surface	<input type="text" value="-14.5"/>
Finish Depth	<input type="text" value="-15"/>
Retract	<input type="text" value="2"/>
Number of Passes	<input type="text" value="1"/>
Depth of Cut	 <input type="text" value="0.5"/>

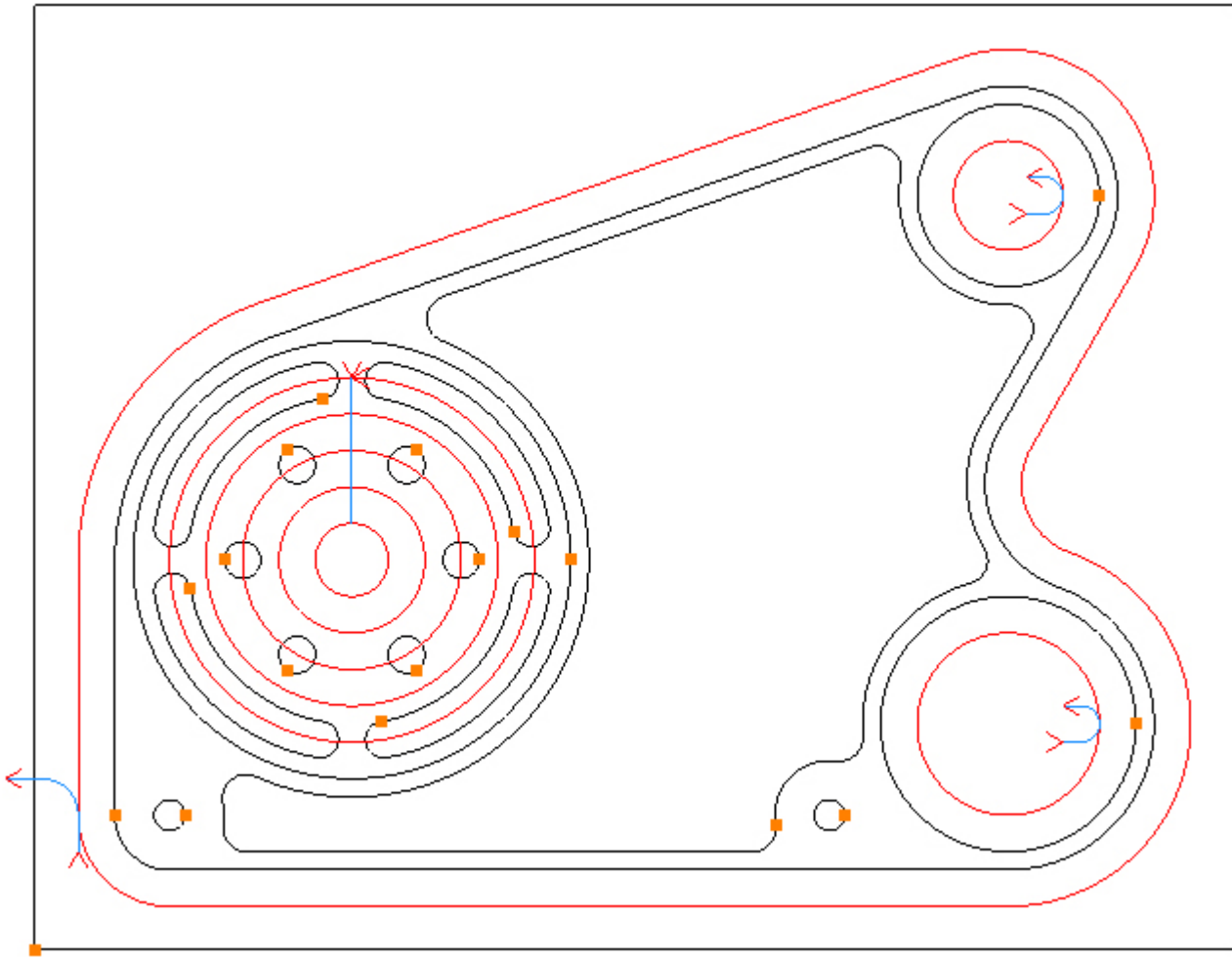
Enter the following values for the Cutting Data:

Cutting Data	
Entry	Advanced
Spindle Speed	<input type="text" value="8000"/>
Plunge Feed Rate	<input type="text" value="1000"/>
Cut Feed Rate	<input type="text" value="2000"/>
Finish Allowance	<input type="text" value="0"/>
Step Over	<input type="text" value="10"/>
Coolant	<input type="text" value="Flood"/>

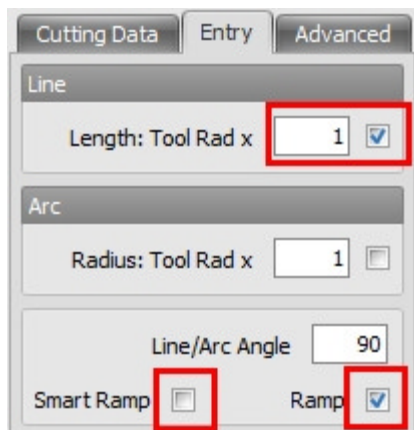
Select the Contour by directly clicking it:



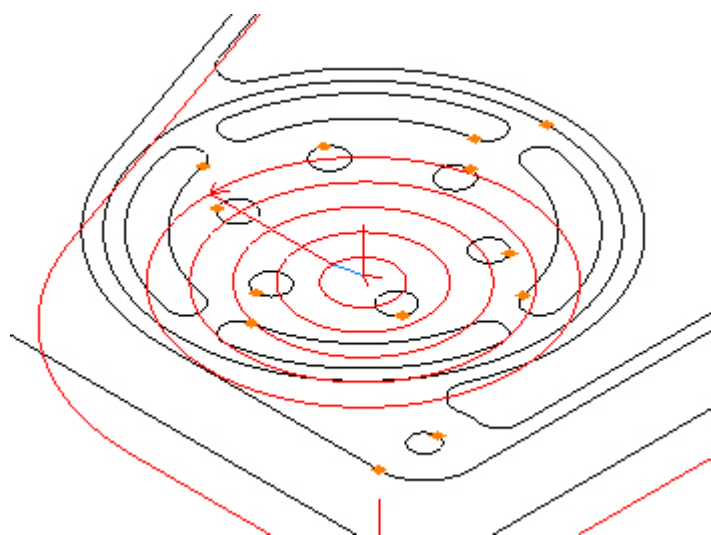
To profile the selected Contour click the Add button . The toolpath is created:



Smart Ramp is applied, but is not particularly suitable as the cutter will plunge against the side wall. Choose the Entry tab, uncheck the Smart Ramp and change the line length to 1. Check the Line and then the Ramp check box:



This will create a smaller ramp from the centre of the counterbore:




Gear Housing Tutorial

Step 11 - Finish inside


Finish inside pocket using Pocket

Menu: Machine-> Pocket

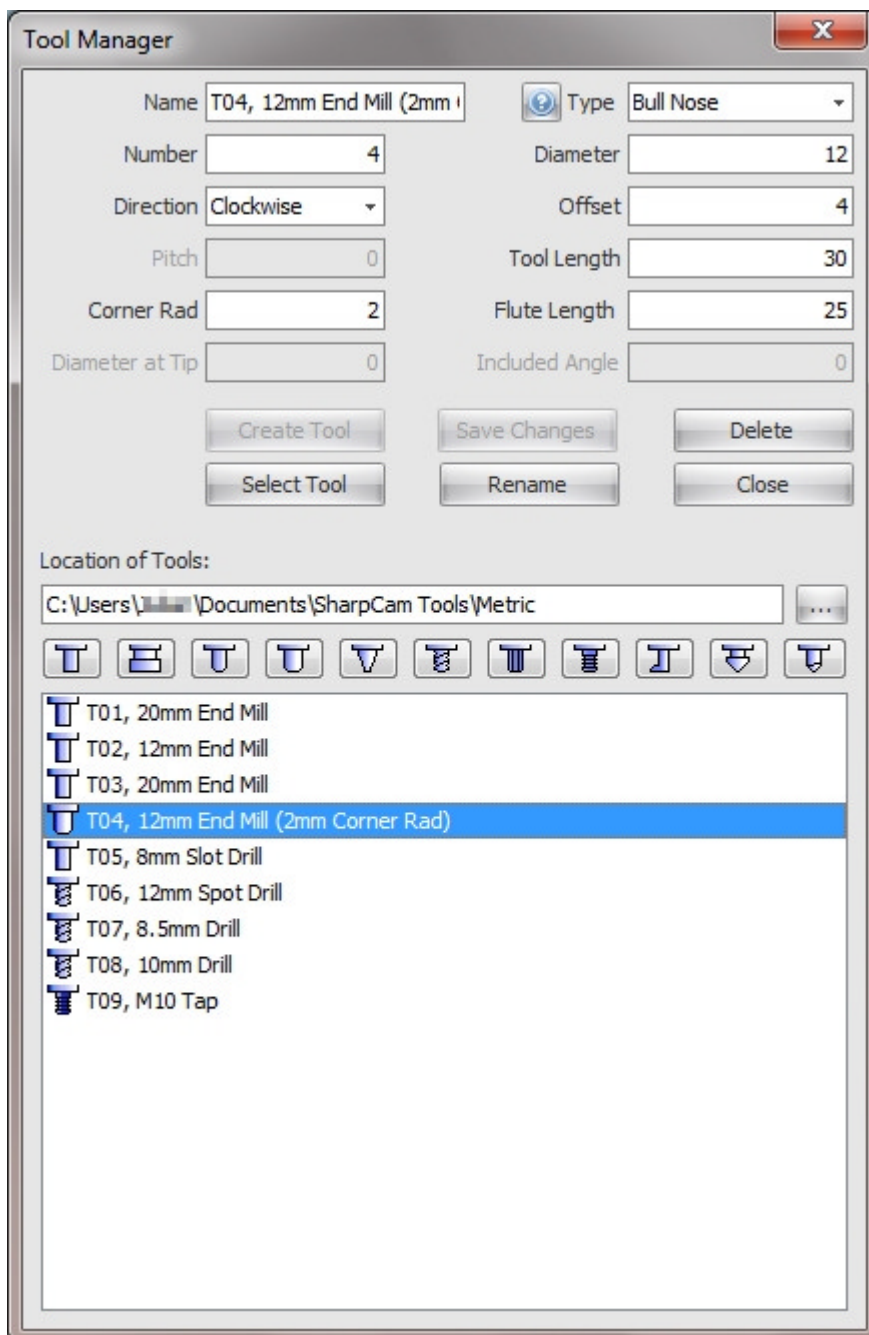
Toolbar button: 

Choose the command and then select the tool for this operation:

Menu: Machine-> Tool Manger

Toolbar button: 

Choose the command to display the Tool Manager and click on 'T04, 12mm End Mill (2mm Corner Rad)', then click the 'Select Tool' button. Alternatively double click a tool to select it:



Enter the following values for the Z Positions:

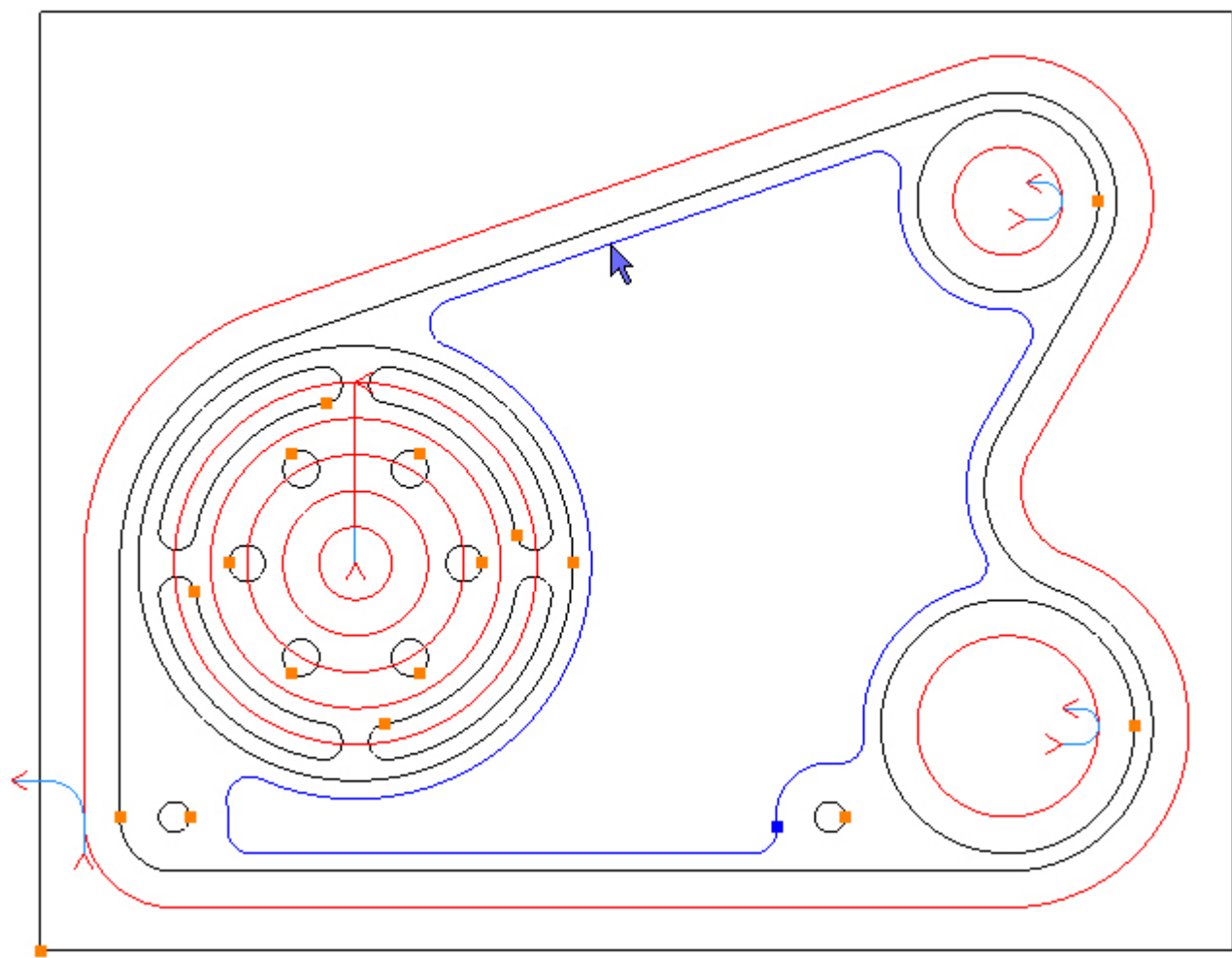
Z Positions	
Initial Rapid	50
Feed From	-17
Material Surface	-19
Finish Depth	-20
Retract	2
Number of Passes	1
Depth of Cut	1


Enter the following values for the Cutting Data.

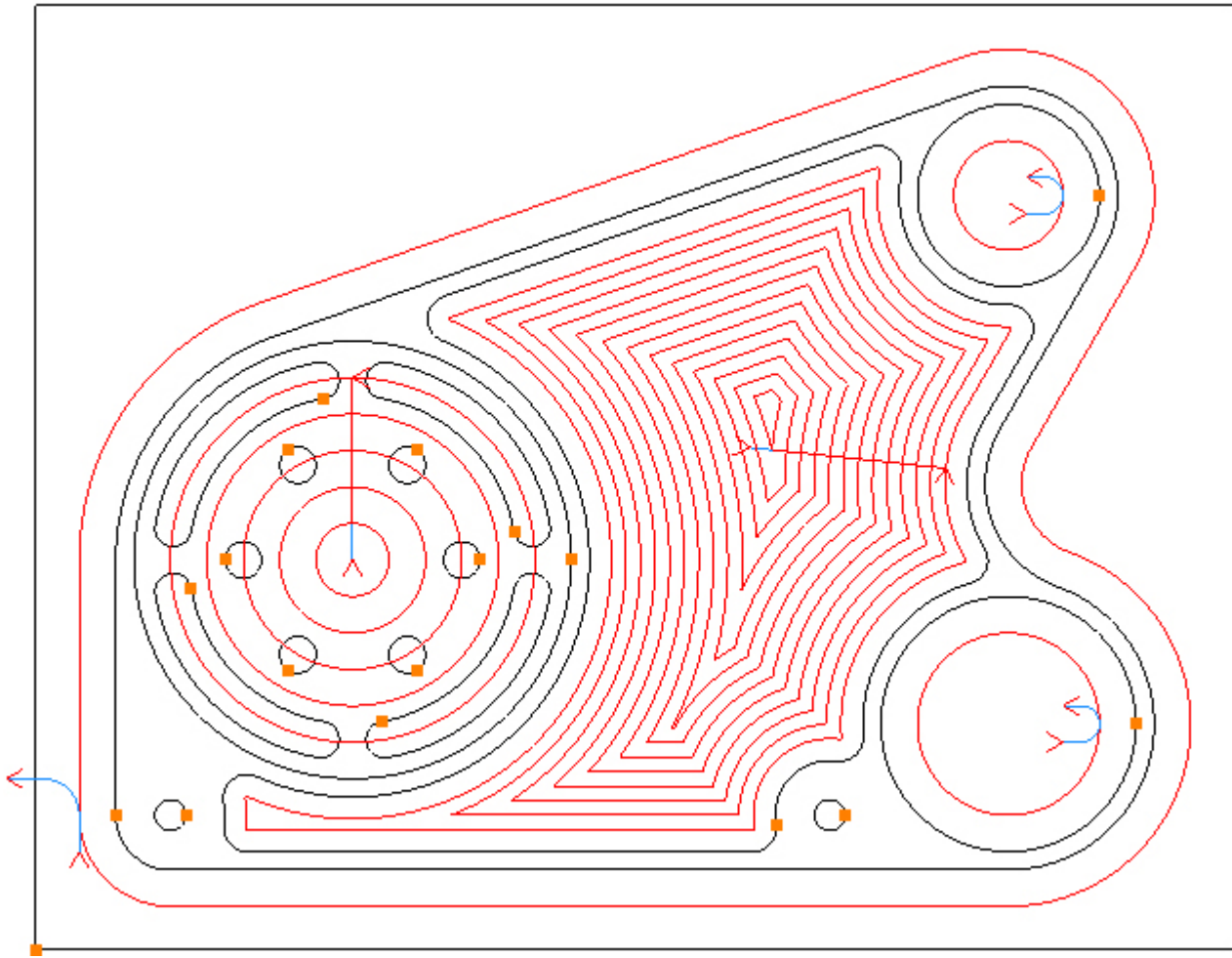
Note that the step over value has been changed from the default value of 6 to 4 to ensure that pocket fully cleans up on the bottom, don't forget that the cutter has a 2mm corner radius:

Cutting Data	
Spindle Speed	10000
Plunge Feed Rate	1000
Cut Feed Rate	2000
Finish Allowance	0
Step Over	4
Coolant	Flood

Select the Contour on the inside by directly clicking it:



To pocket the selected Contour click the Add button . The toolpath is created:




The entry settings from the previous operation are acceptable.

Gear Housing Tutorial

Step 12 - Machine radial slots


Machine radial slots using Profile

Menu: Machine-> Profile

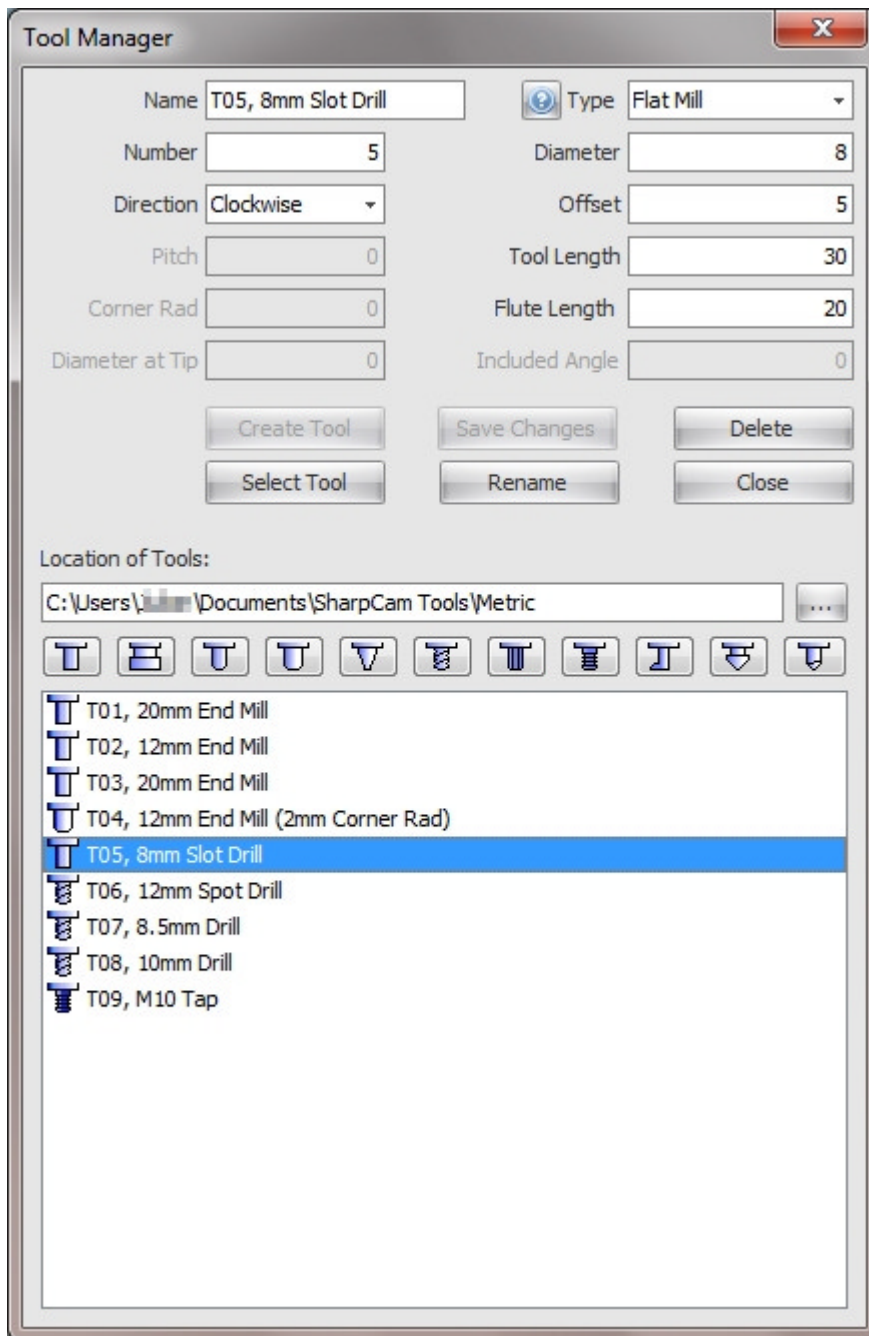
Toolbar button: 

Choose the Profile command then select the tool for this operation:

Menu: Machine-> Tool Manger

Toolbar button: 

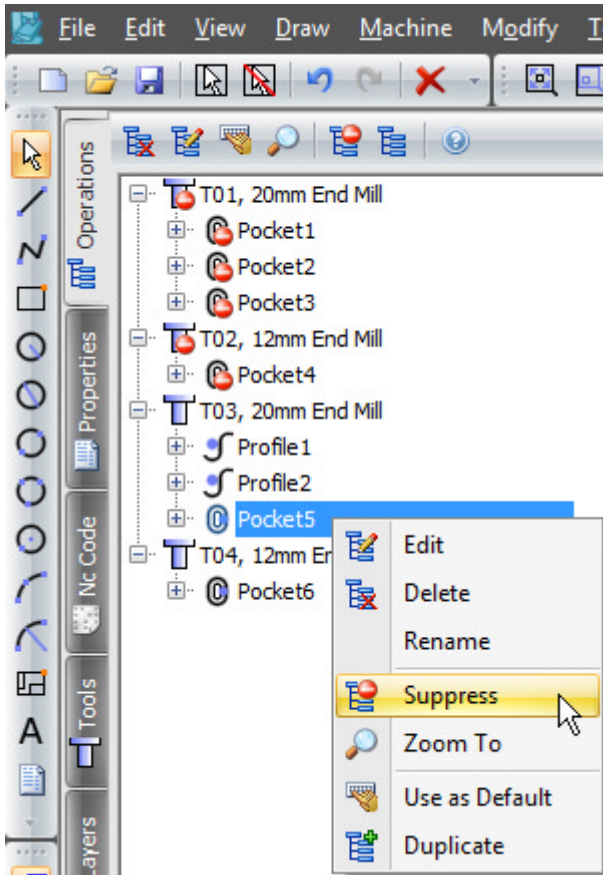
Choose the command to display the Tool Manager and click on 'T05, 8mm Slot Drill', then click the 'Select Tool' button. Alternatively double click a tool to select it:



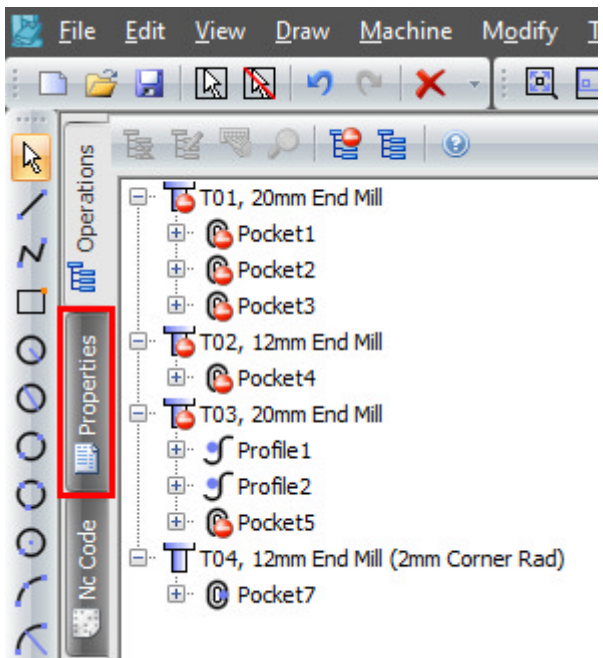
Before machining the slots suppress the operation that machined the Ø120 counterbore, so it does not obscure the view.

Choose the Operations tab on the Part Manager and right click on the last operation created by

T03, 20mm End Mill' and select Suppress:




Click the Properties tab on the Part Manager to continue with the Profile command:



Enter the following values for the Z Positions:

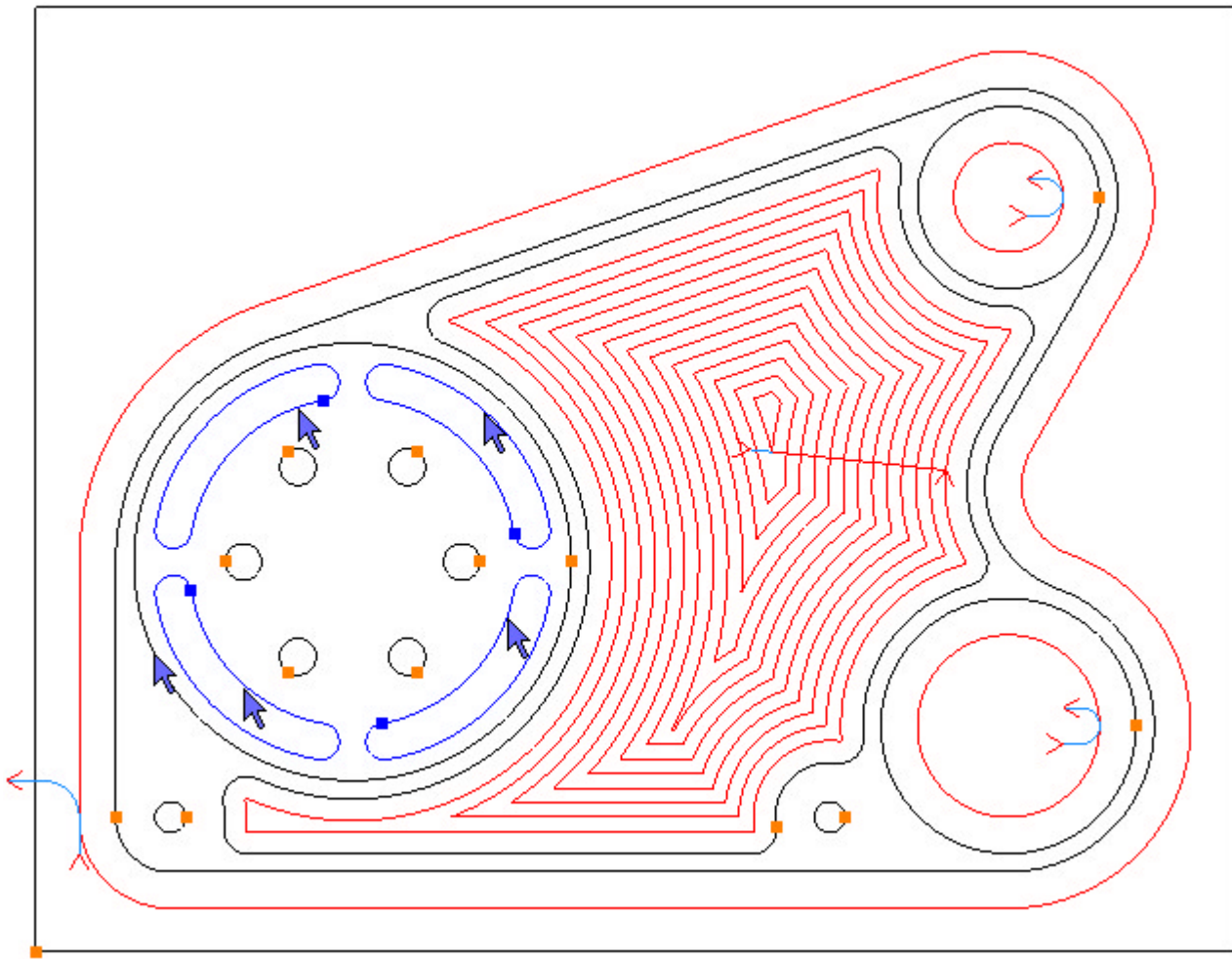
Gear Housing Tutorial


Z Positions	
Initial Rapid	50
Feed From	-13
Material Surface	-15
Finish Depth	-26
Retract	2
Number of Passes	11
Depth of Cut	 1

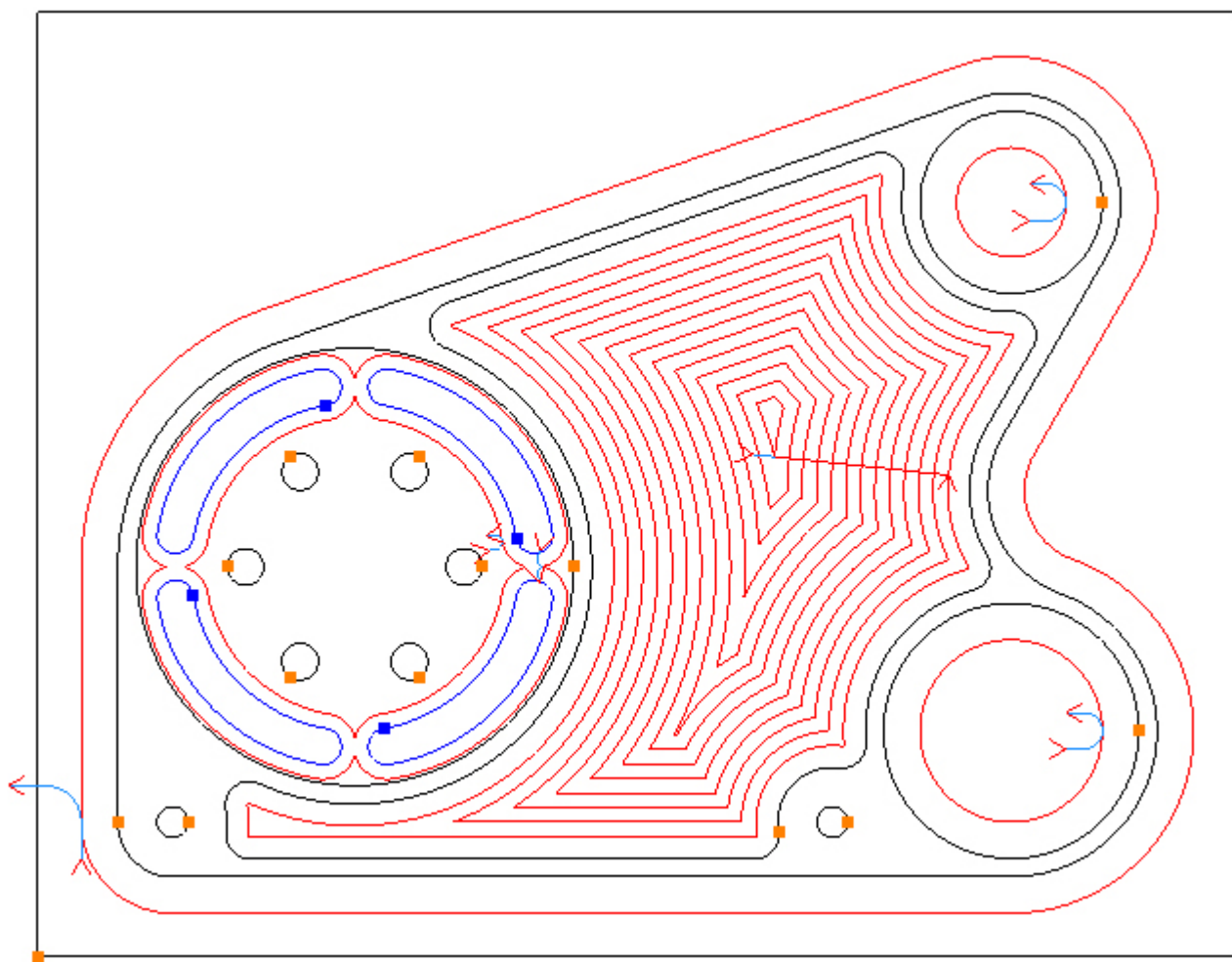
Enter the following values for the Cutting Data:

Cutting Data		Entry	Exit
Spindle Speed	12000		
Plunge Feed Rate	100		
Cut Feed Rate	500		
Finish Allowance	0		
Coolant	Flood		
Cutter Radius Comp	None		
Sub Routines	<input type="checkbox"/>		

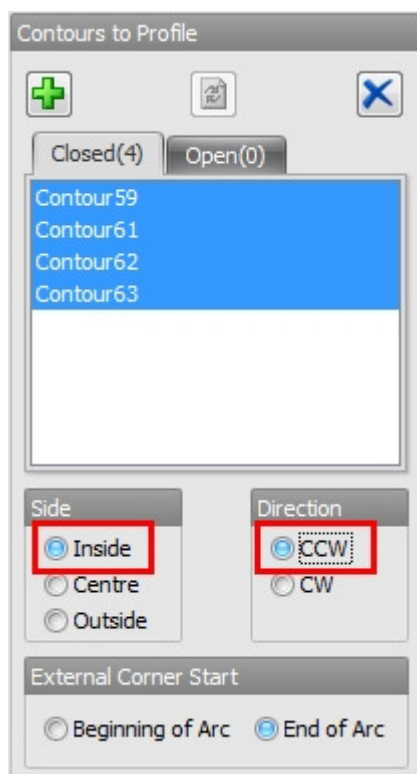
Select the slots by directly clicking them. Also unselect the Ø120 circle by directly clicking it, it was selected when it was suppressed:



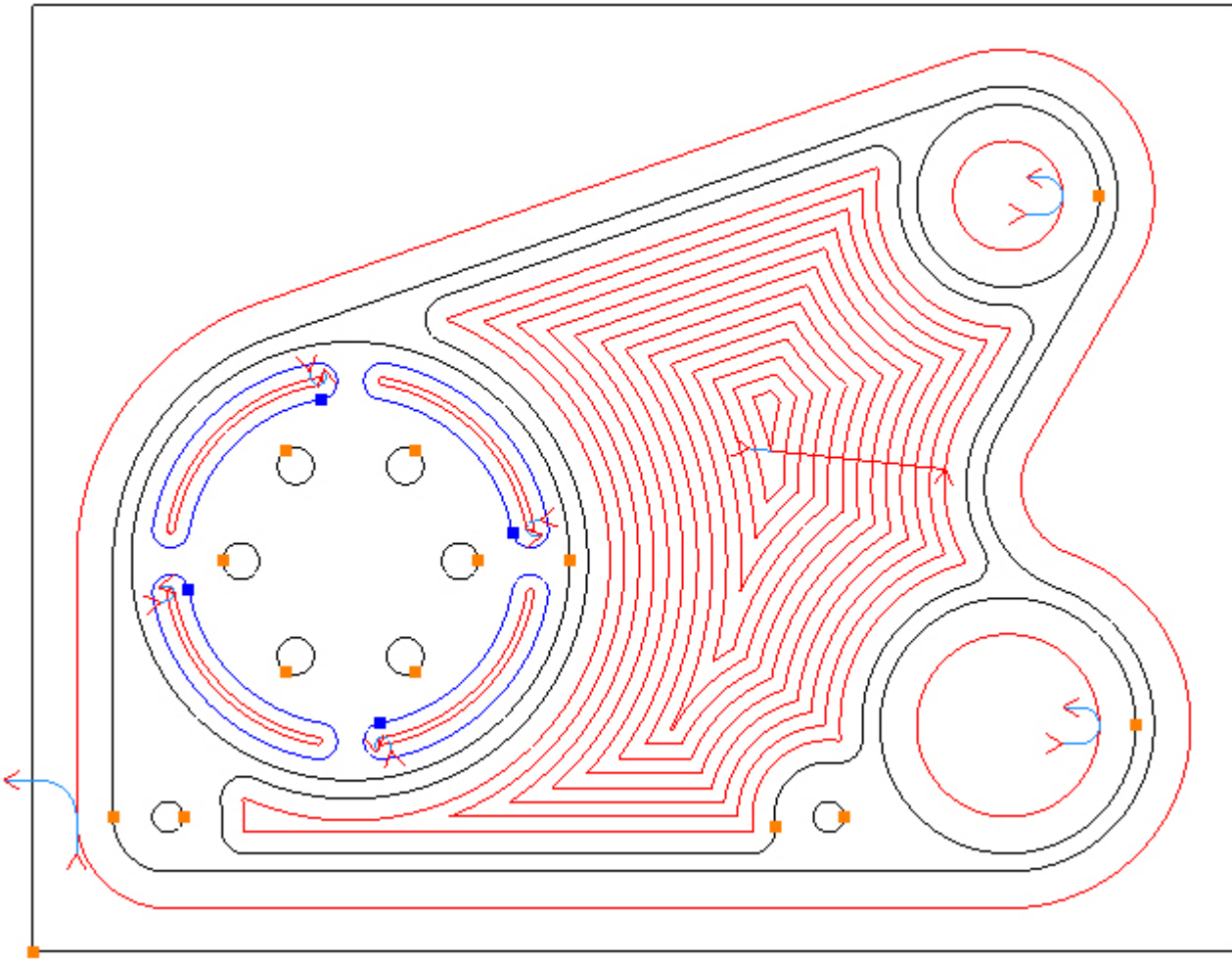
To profile the selected Contours click the Add button . The toolpaths are created:



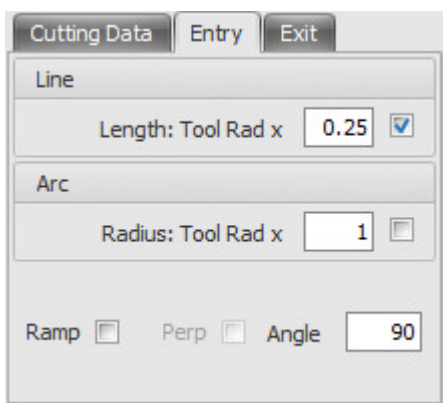
With the Contours still selected change the side to *Inside* and the direction to *CCW*:



The toolpath is now on the inside and in counter-clockwise direction:



Choose the Entry tab and set as below, changes the values before checking/unchecking the boxes:



Choose the Exit tab and set the same as the entry:

Gear Housing Tutorial

Cutting Data Entry Exit

Line

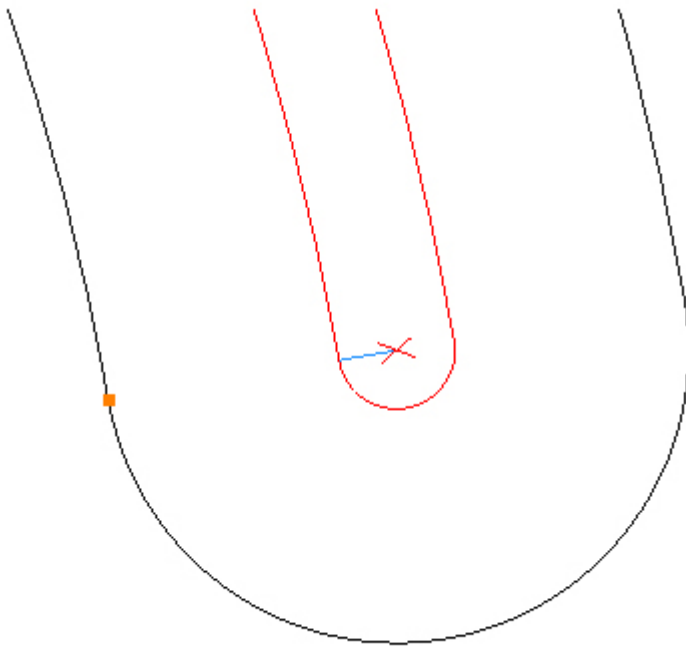
Length: Tool Rad x ☒

Arc

Radius: Tool Rad x ☐

Ramp ☐ Perp ☐ Angle


The entry and exits have been added to all 4 slots:



Step 13 - Spot drill holes


Spot Drill holes using Drilling

Menu: Machine-> Drilling

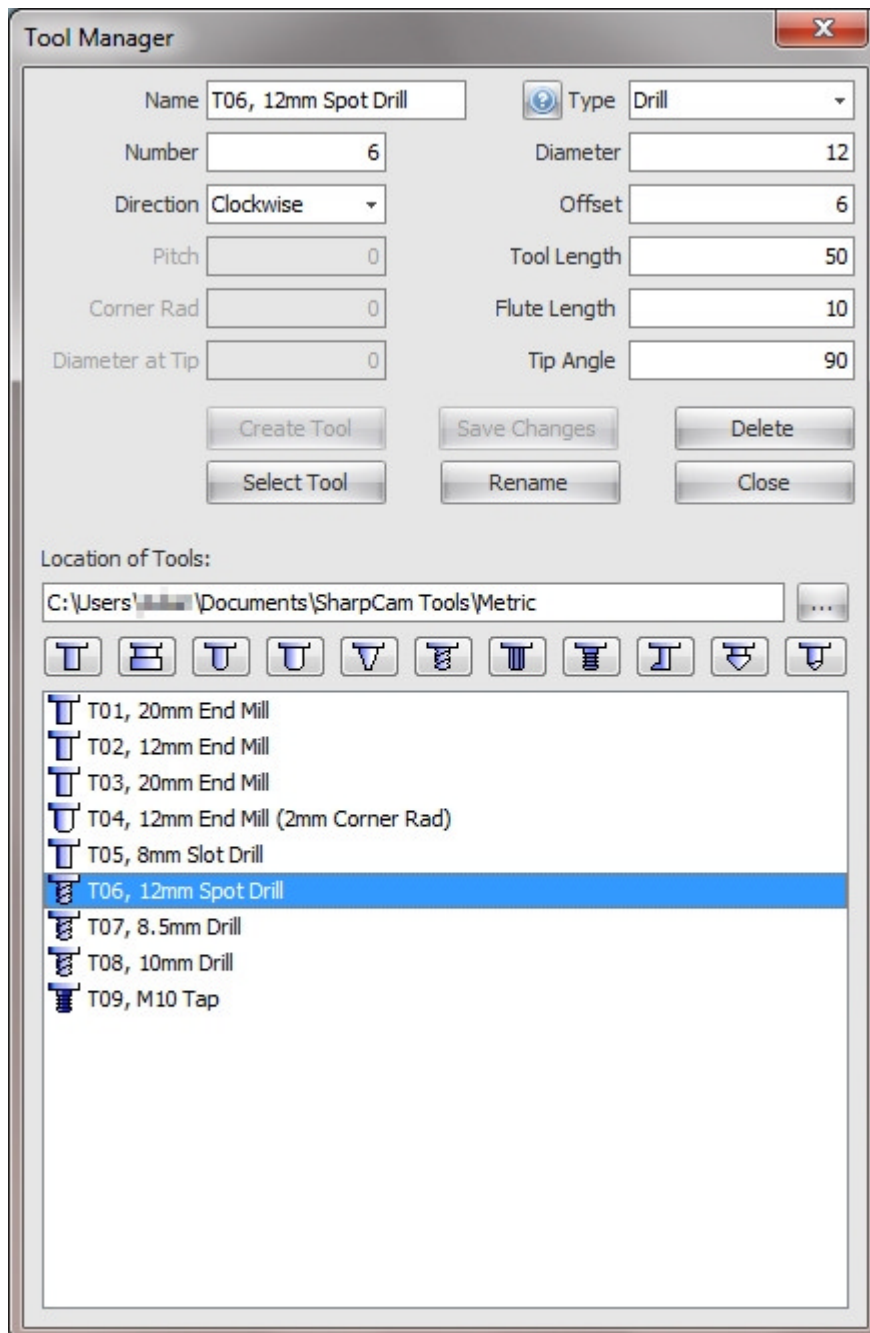
Toolbar button: 

Choose the Drilling command then select the tool for this operation:

Menu: Machine-> Tool Manger

Toolbar button: 

Choose the command to display the Tool Manager and click on 'T06, 12mm Spot Drill', then click the 'Select Tool' button. Alternatively double click a tool to select it:

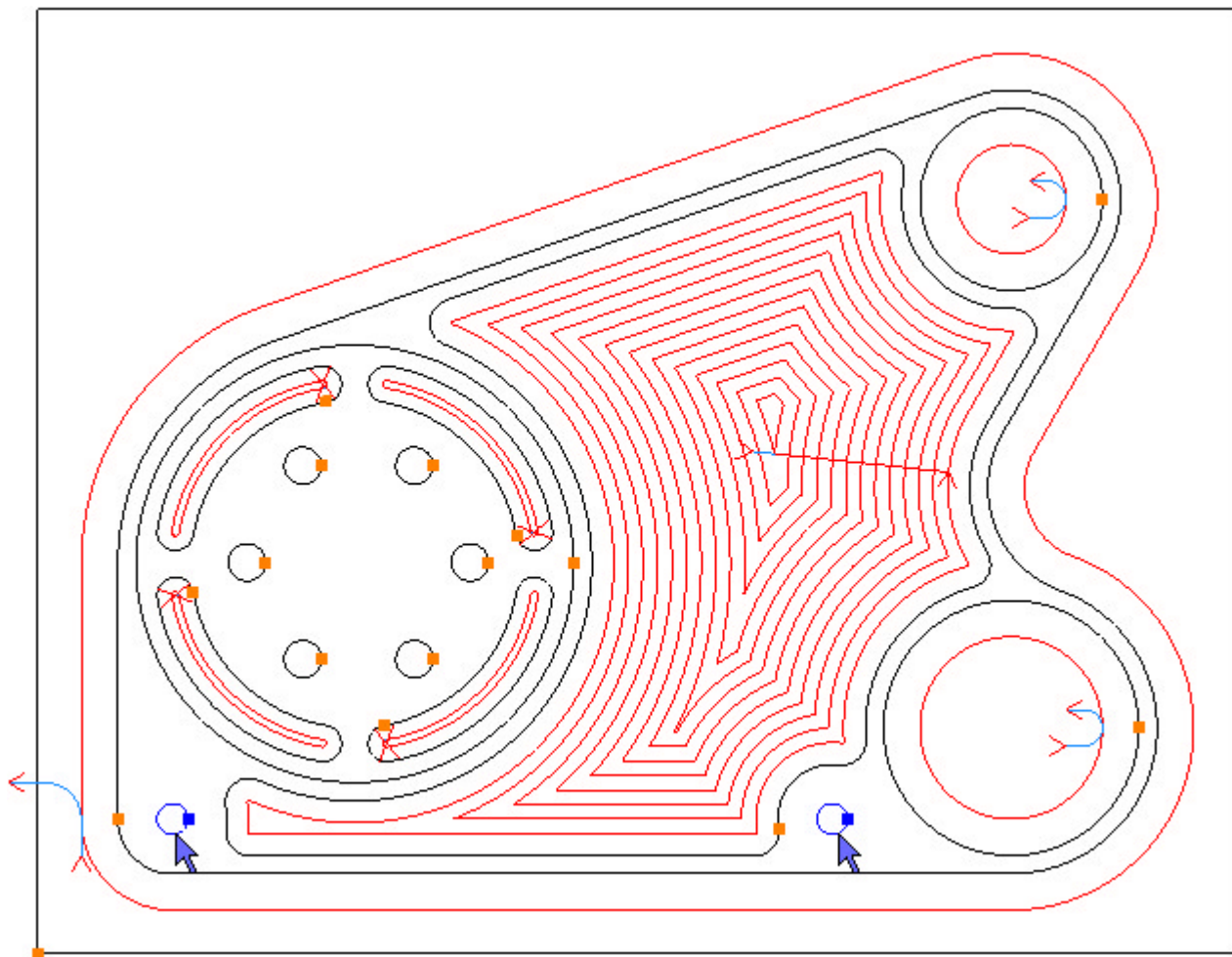



Enter the following Z Positions and Cutting Data as below:

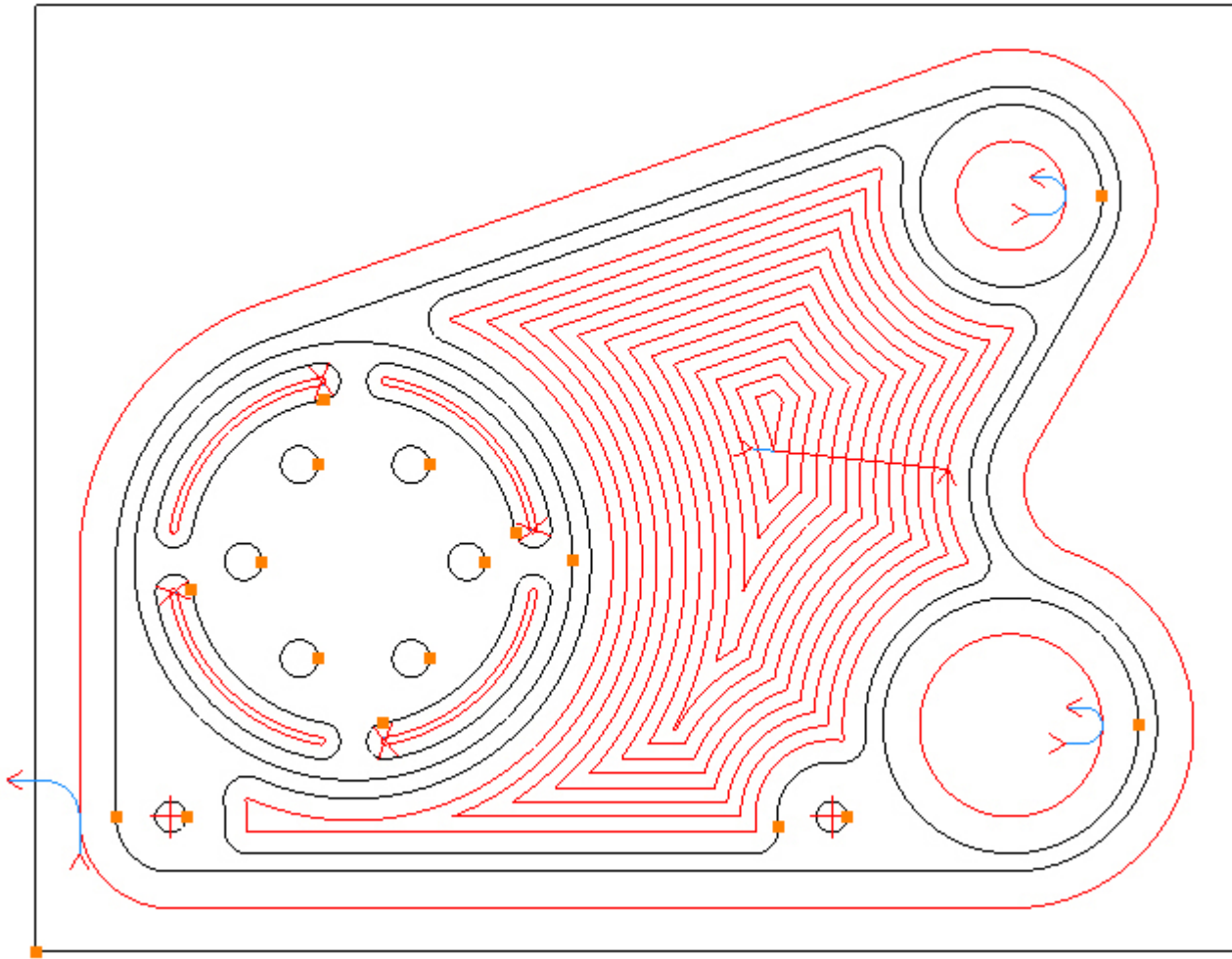
Gear Housing Tutorial

Type	Drilling
Z Positions	
Initial Rapid	50
Feed From	2
Material Surface	0
Finish Depth	-4.5
<input type="radio"/> Initial Rapid	
Retract To:	<input checked="" type="radio"/> Feed From
Cutting Data	
Spindle Speed	8000
Feed Rate	200
Peck Amount	0
Dwell	0
Coolant	Flood

Select the Circles by directly clicking them:




To drill the selected Circles click the Add button . The toolpaths are created:



As the Z position of the $\varnothing 10$ holes are different a new drilling operation is required.

Menu: Machine-> Drilling

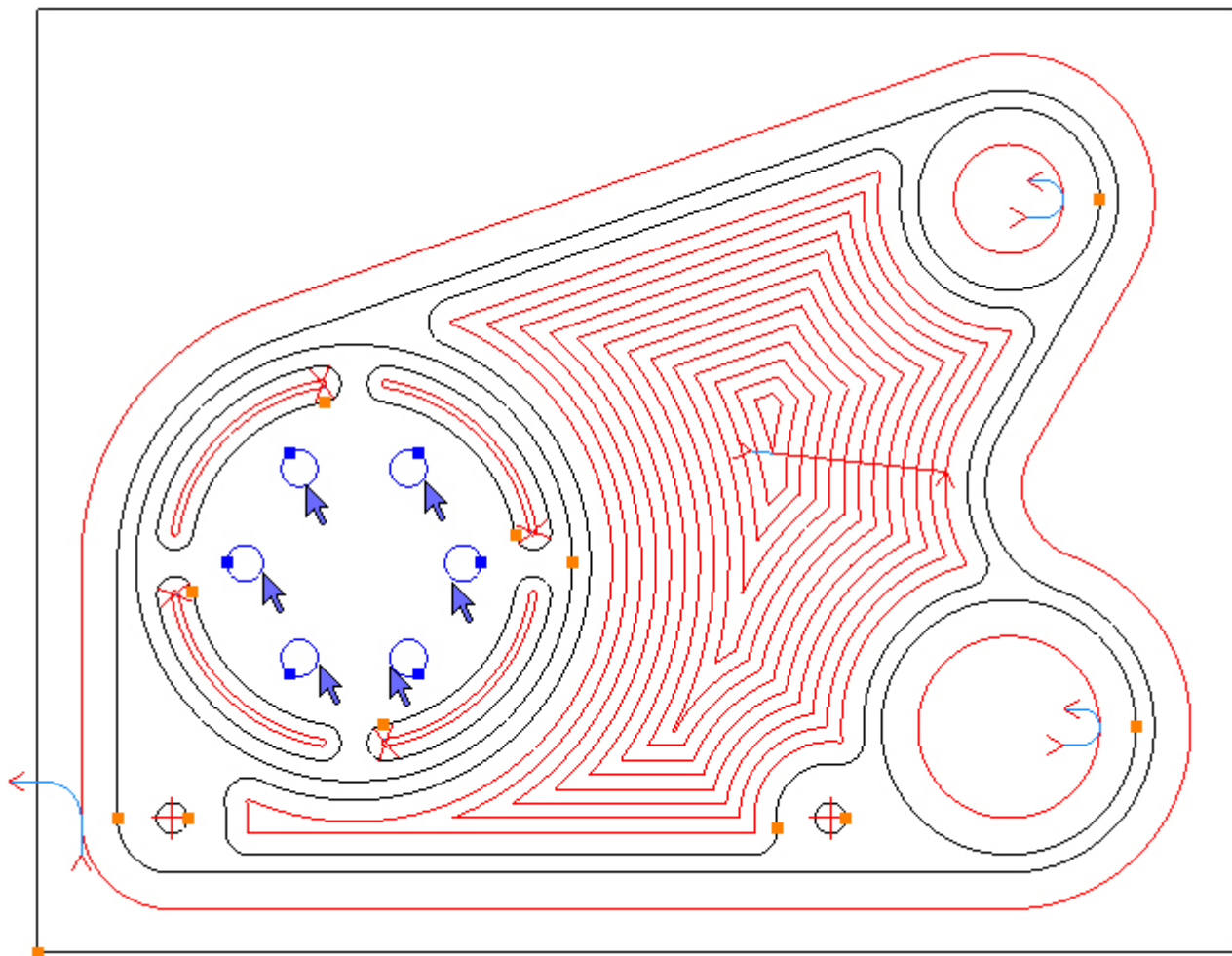
Toolbar button: 


Choose the Drilling command then enter the following values for the Z Positions:

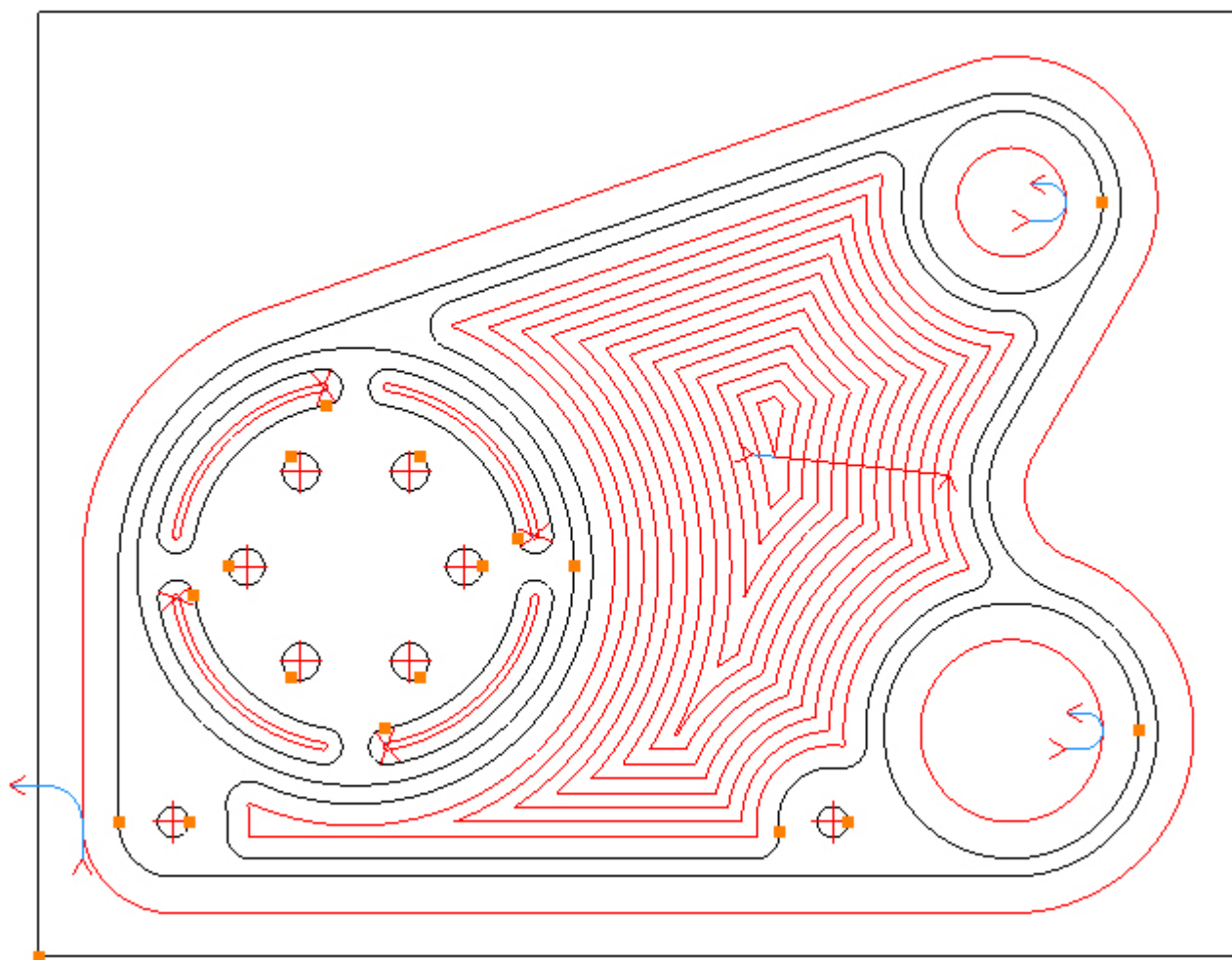
Gear Housing Tutorial

Type	Drilling
Z Positions	
Initial Rapid	2
Feed From	-13
Material Surface	-15
Finish Depth	-20.5
Retract To:	<input checked="" type="radio"/> Initial Rapid <input type="radio"/> Feed From
Cutting Data	
Spindle Speed	8000
Feed Rate	200
Peck Amount	0
Dwell	0
Coolant	Flood

Select the Circles by directly clicking them:



To drill the selected Circles click the Add button . The toolpaths are created:




Gear Housing Tutorial

Step 14 - Drill holes


Drill Ø8.5 holes using Drilling

Menu: Machine-> Drilling

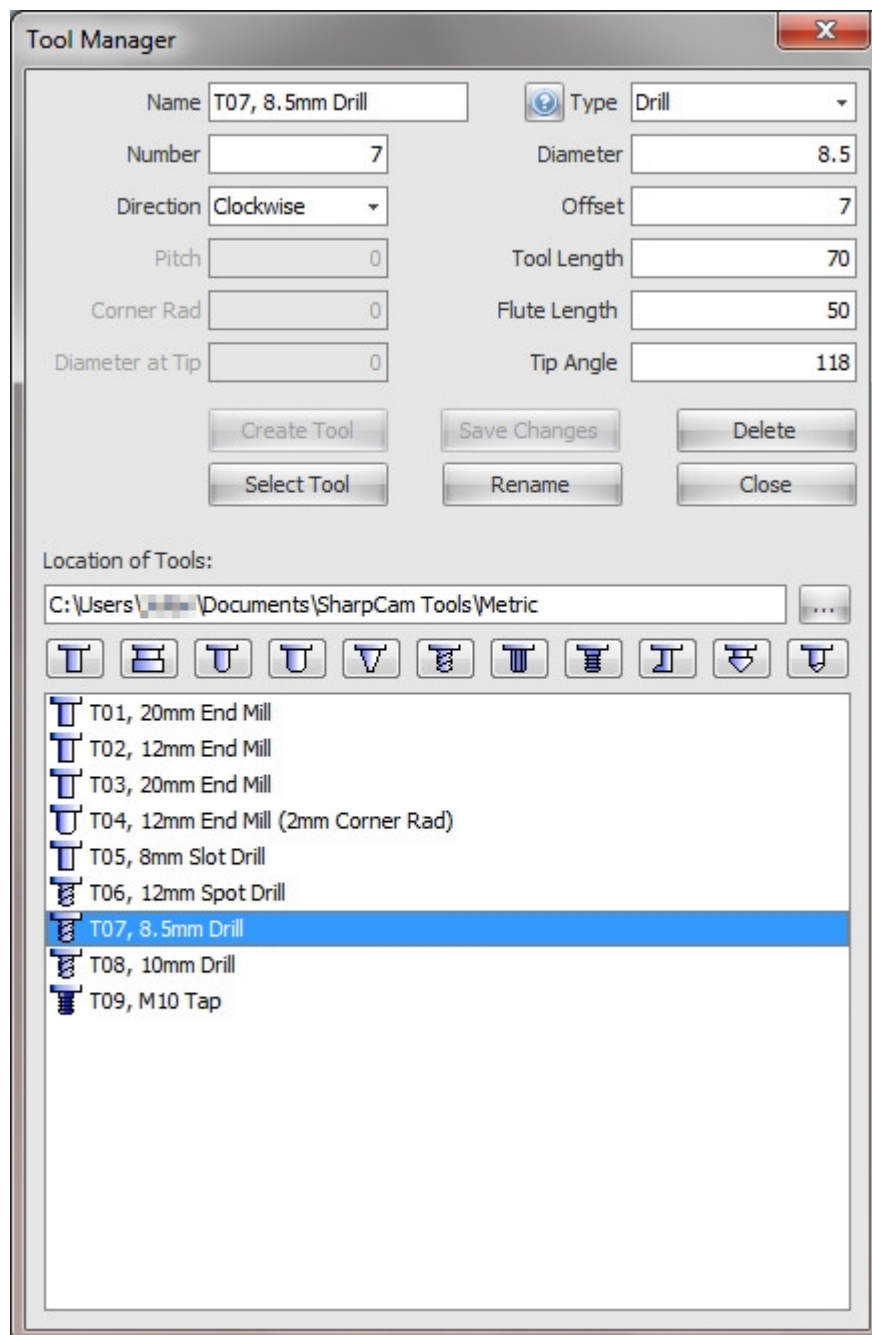
Toolbar button: 

Choose the Drilling command then select the tool for this operation:

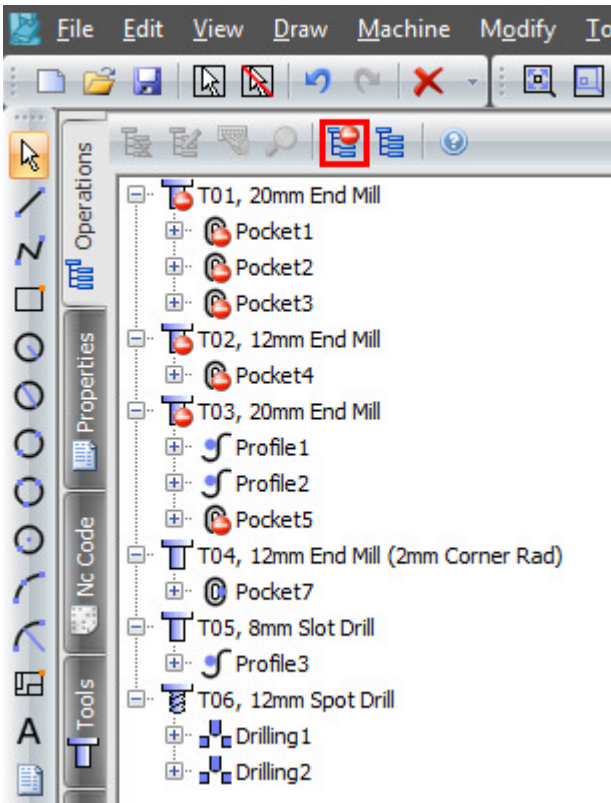
Menu: Machine-> Tool Manger

Toolbar button: 

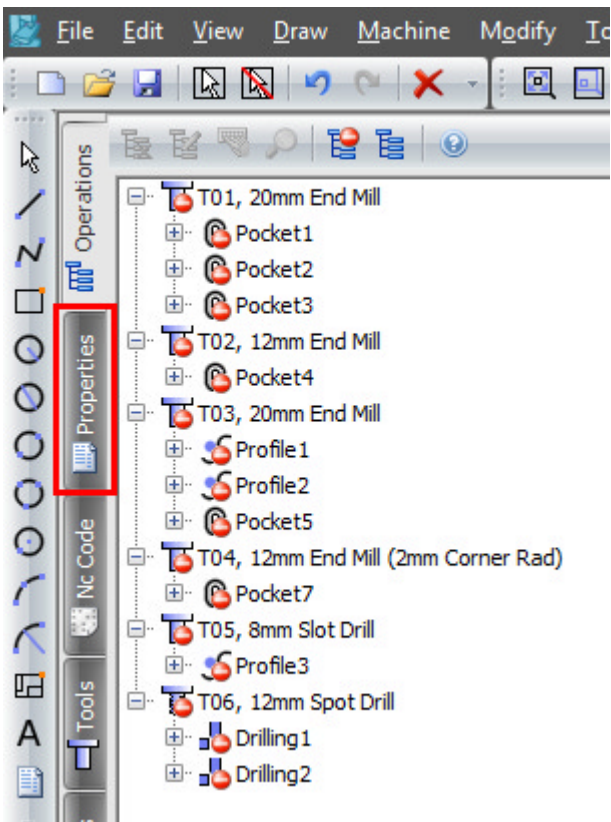
Choose the command to display the Tool Manager and click on 'T07, 8.5mm Drill', then click the 'Select Tool' button. Alternatively double click a tool to select it:



The Part now has a number of toolpaths. In order to prevent the view from being obscured, suppress them so they are hidden. Choose the Operations tab on the Part Manager and click the Suppress All button:



Click the Properties tab on the Part Manager to continue with the Drilling command:

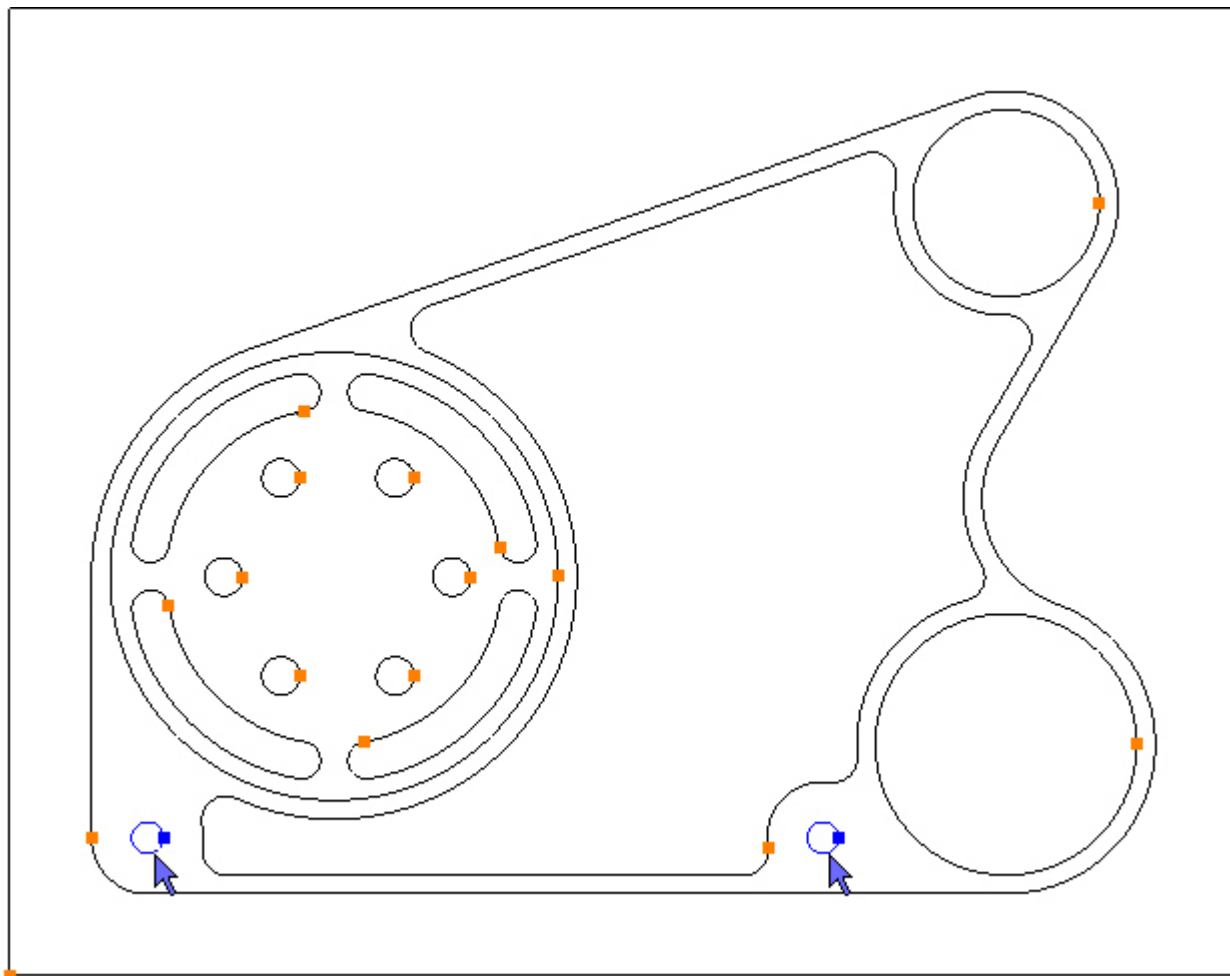



Enter the following Z Positions and Cutting Data as below, note that the type is Peck Drill:

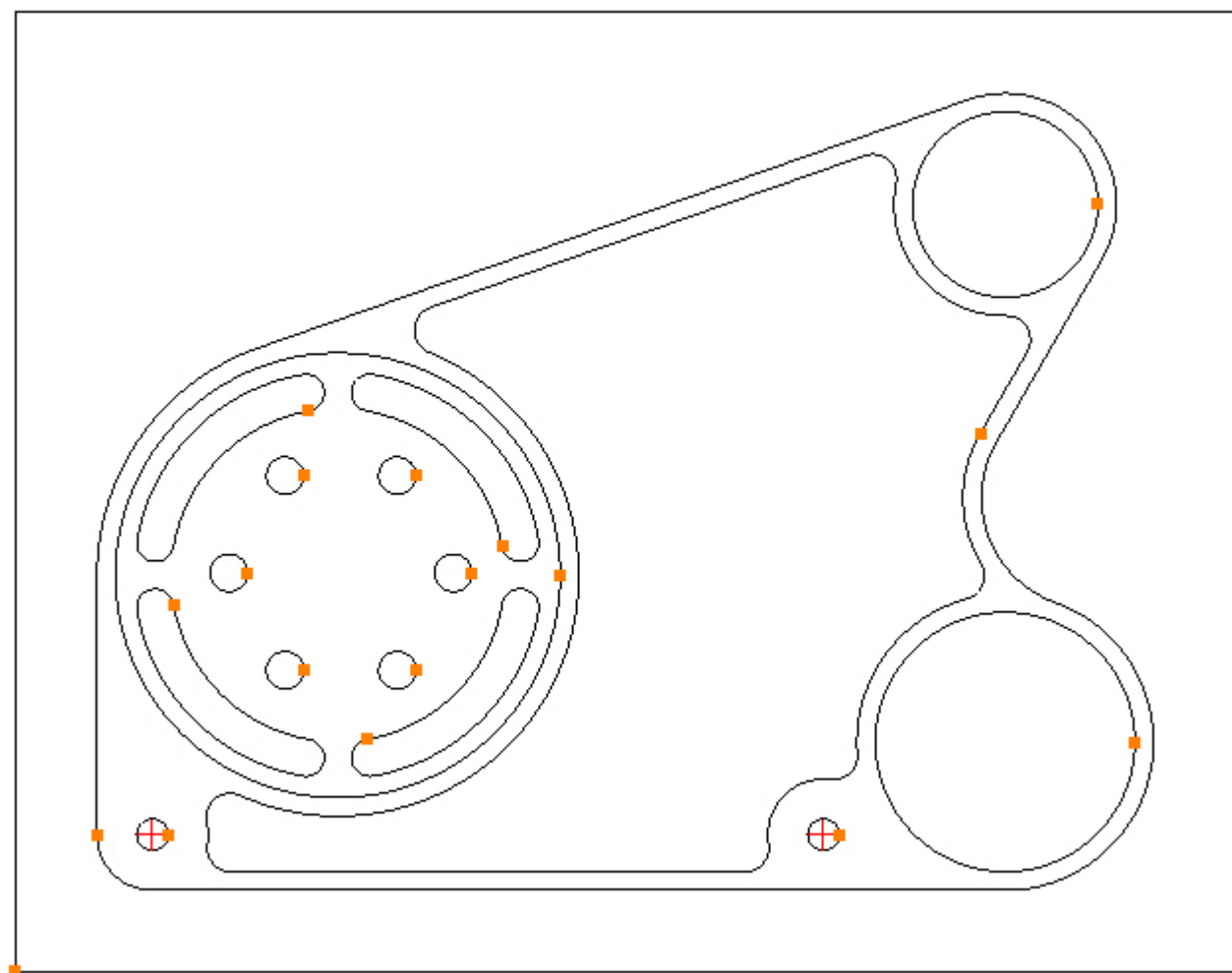
Gear Housing Tutorial

Type	Peck Drill
Z Positions	
Initial Rapid	50
Feed From	2
Material Surface	0
Finish Depth	-35
Retract To:	
<input type="radio"/> Initial Rapid	
<input checked="" type="radio"/> Feed From	
Cutting Data	
Spindle Speed	8000
Feed Rate	600
Peck Amount	10
Dwell	0
Coolant	Flood

Select the Circles by directly clicking them:



To drill the selected Circles click the Add button . The toolpaths are created:




Gear Housing Tutorial

Step 15 - Drill holes


Drill Ø10 holes using Drilling

Menu: Machine-> Drilling

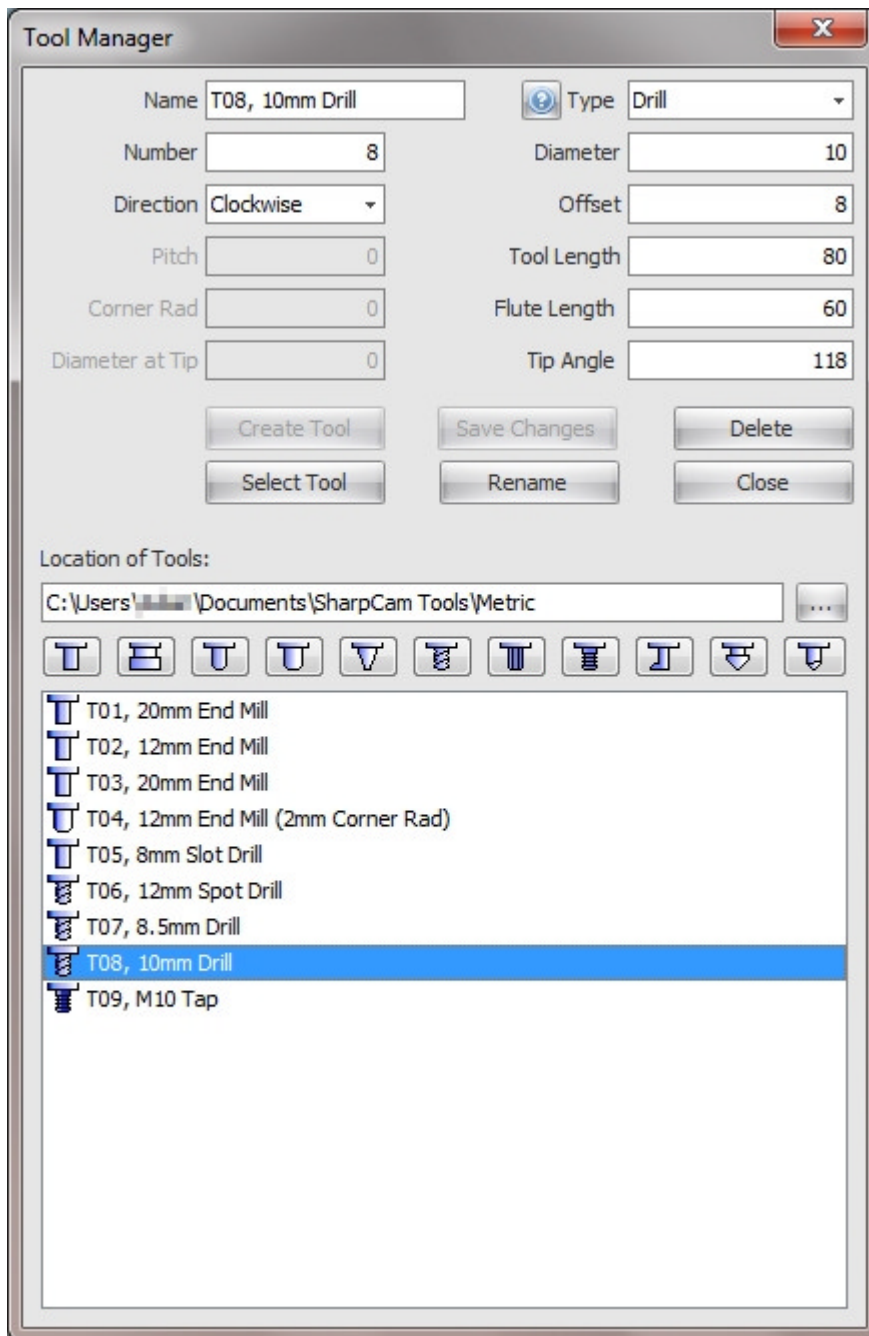
Toolbar button: 

Choose the Drilling command then select the tool for this operation:

Menu: Machine-> Tool Manger

Toolbar button: 

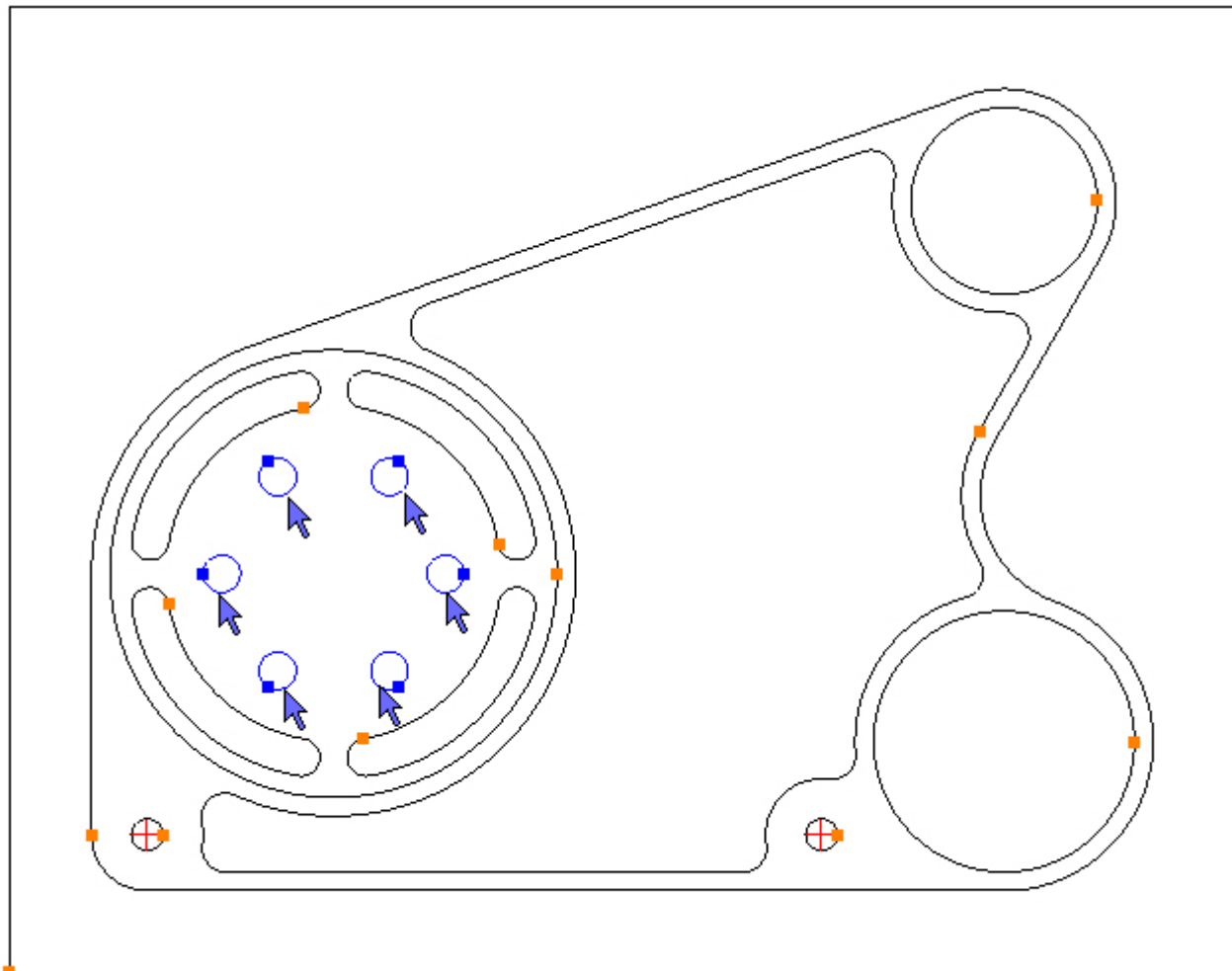
Choose the command to display the Tool Manager and click on 'T08, 10mm Drill', then click the 'Select Tool' button. Alternatively double click a tool to select it:




Enter the following Z Positions and Cutting Data as below, note that the type is Drilling:

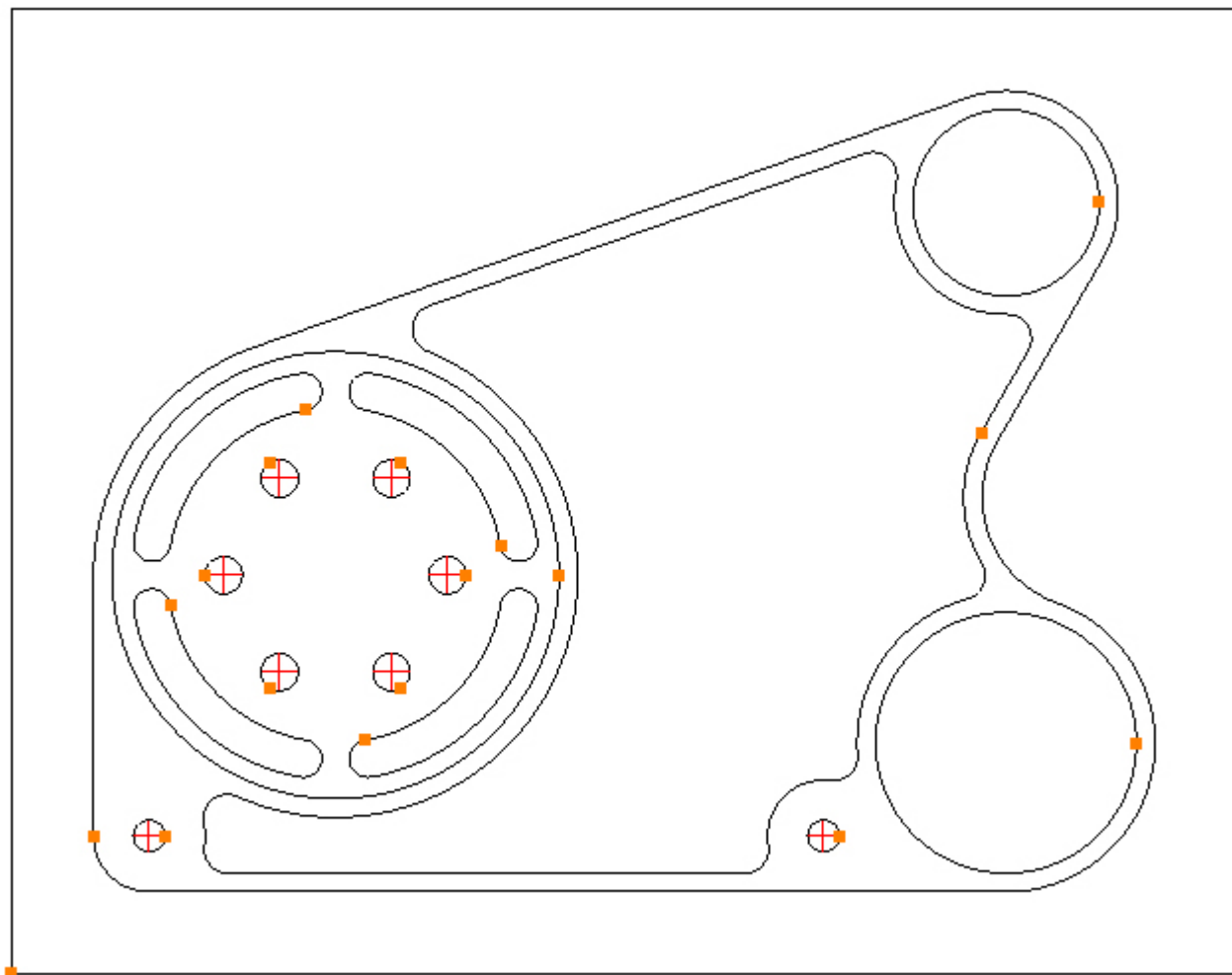
Type	Drilling
Z Positions	
Initial Rapid	2
Feed From	-13
Material Surface	-15
Finish Depth	-35
Retract To:	<input checked="" type="radio"/> Initial Rapid <input type="radio"/> Feed From
Cutting Data	
Spindle Speed	7000
Feed Rate	700
Peck Amount	0
Dwell	0
Coolant	Flood

Select the Circles by directly clicking them:



Gear Housing Tutorial

To drill the selected Circles click the Add button . The toolpaths are created:



All toolpaths have now been created.


Step 16 - Create Material Stock

Create Material Stock for Solid Simulation

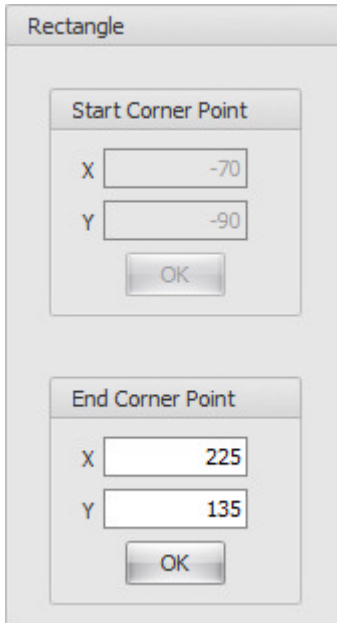
First a rectangle must be created that represents the Material Stock. As mentioned in Step 1 the Gear Housing is to be made from an aluminium rectangular billet 295mm x 225mm x 30mm.

Choose the Rectangle command:

Menu: Draw -> Rectangle

Toolbar button: 

Create a rectangle with a start point value of X-70, Y-90 and an end point value of X225, Y135:

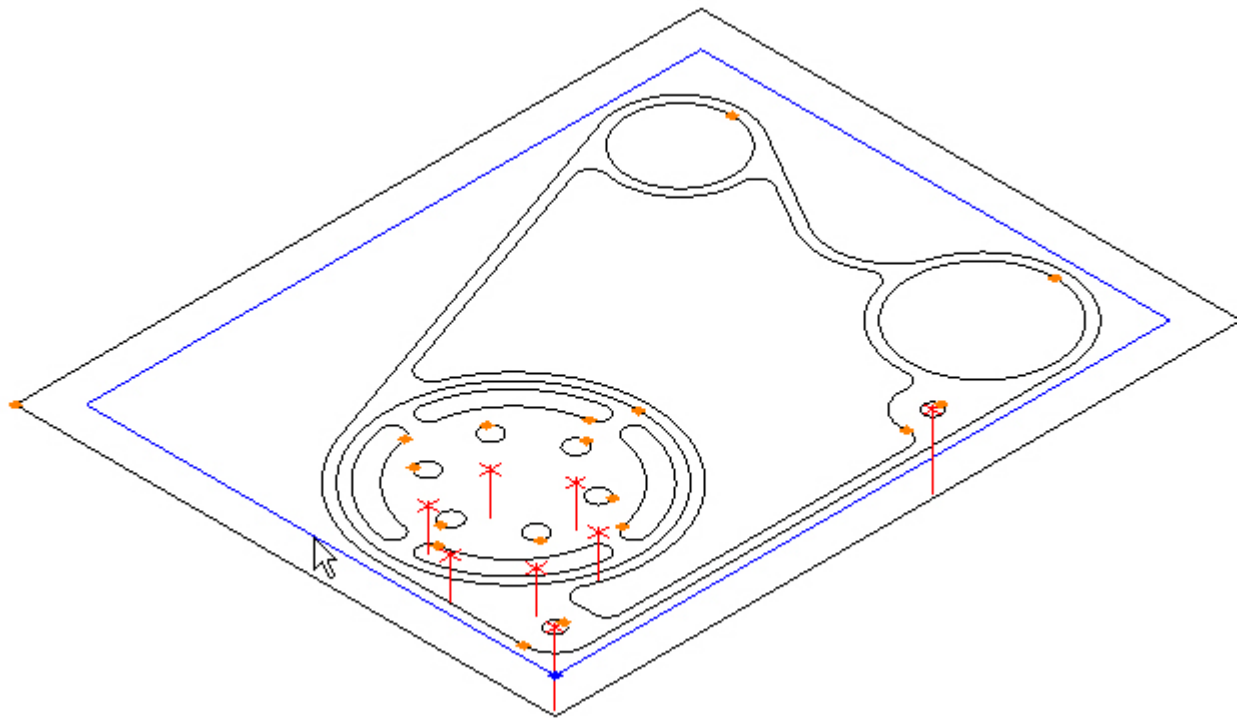


Extrude the rectangle

Menu: View-> Material Stock -> Extrude Contours

Toolbar button:  -> 

Select the Rectangle by directly clicking it:



Enter -27 in Z Bottom:

Extrude Contour

Z Top

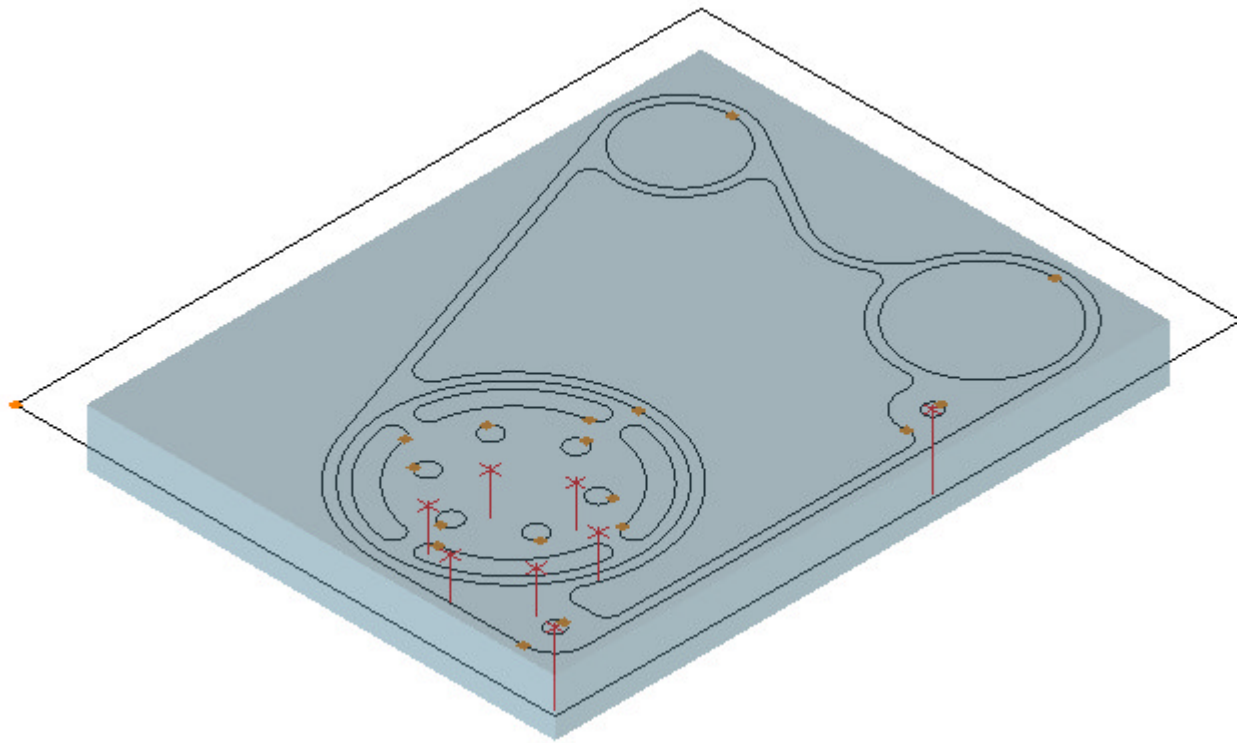
0

Z Bottom

-27

Apply

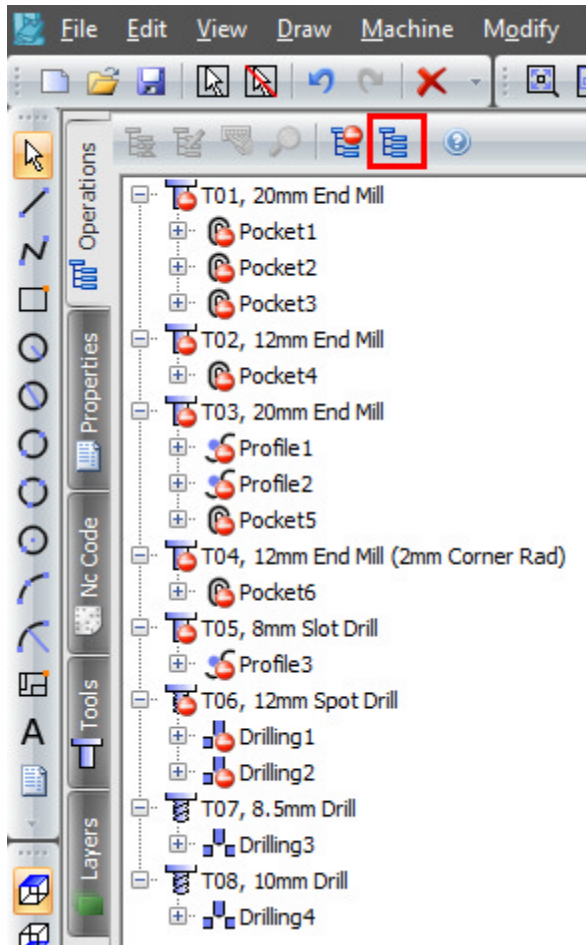
Click the Apply button, the Material Stock is created:



Gear Housing Tutorial

Step 17 - Solid Simulation



Before simulating the part the operations must be unsuppressed. Choose the Operations tab on the Part Manager and click the Unsuppress All button:

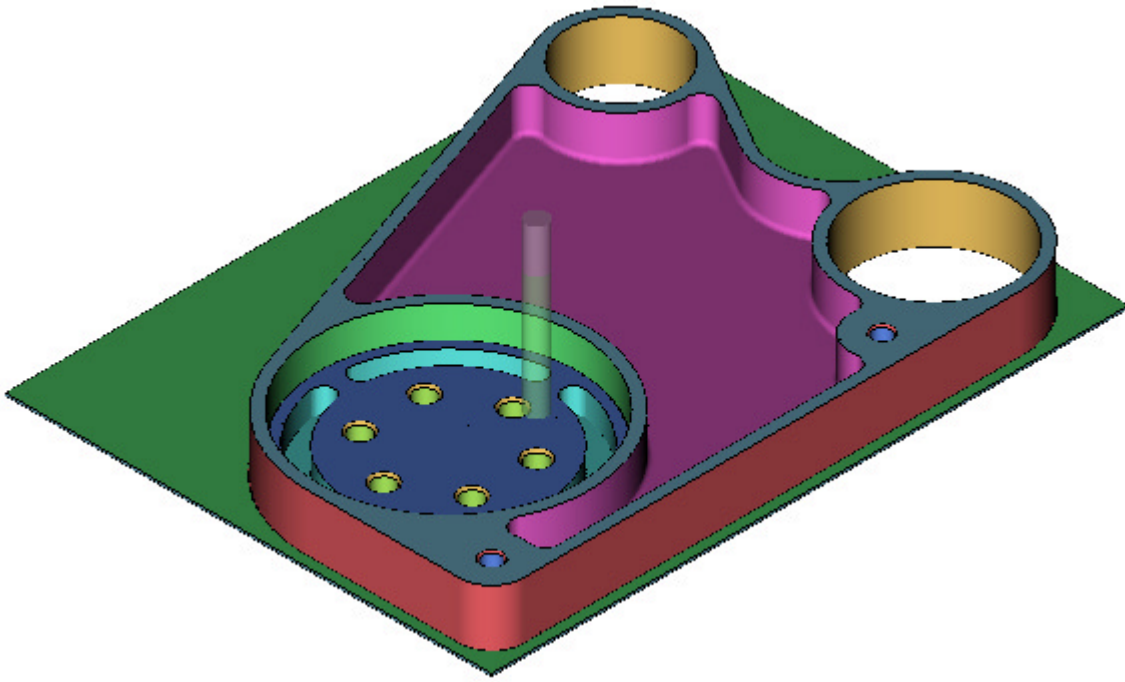


Simulate part being machined

Menu: View-> Solid Simulation

Toolbar button: 

There are many options and you are encouraged to experiment, but for now you can press either the Forwards button  or the Fast Forwards button . The part is simulated until the end:



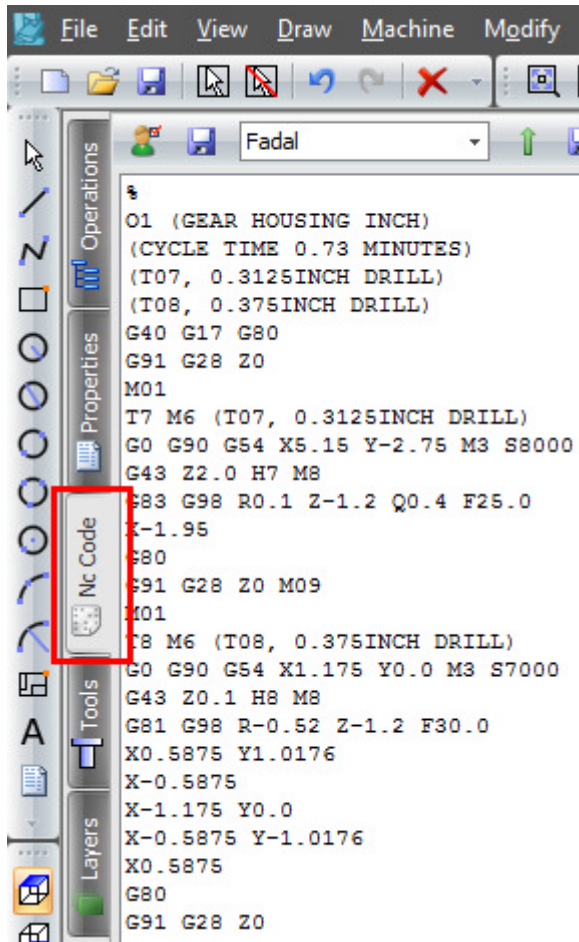
☑ Simulating the Part is optional and does not need to be performed to create the Nc code.

Gear Housing Tutorial



Step 18 - Output Nc code

Outputting Nc Code

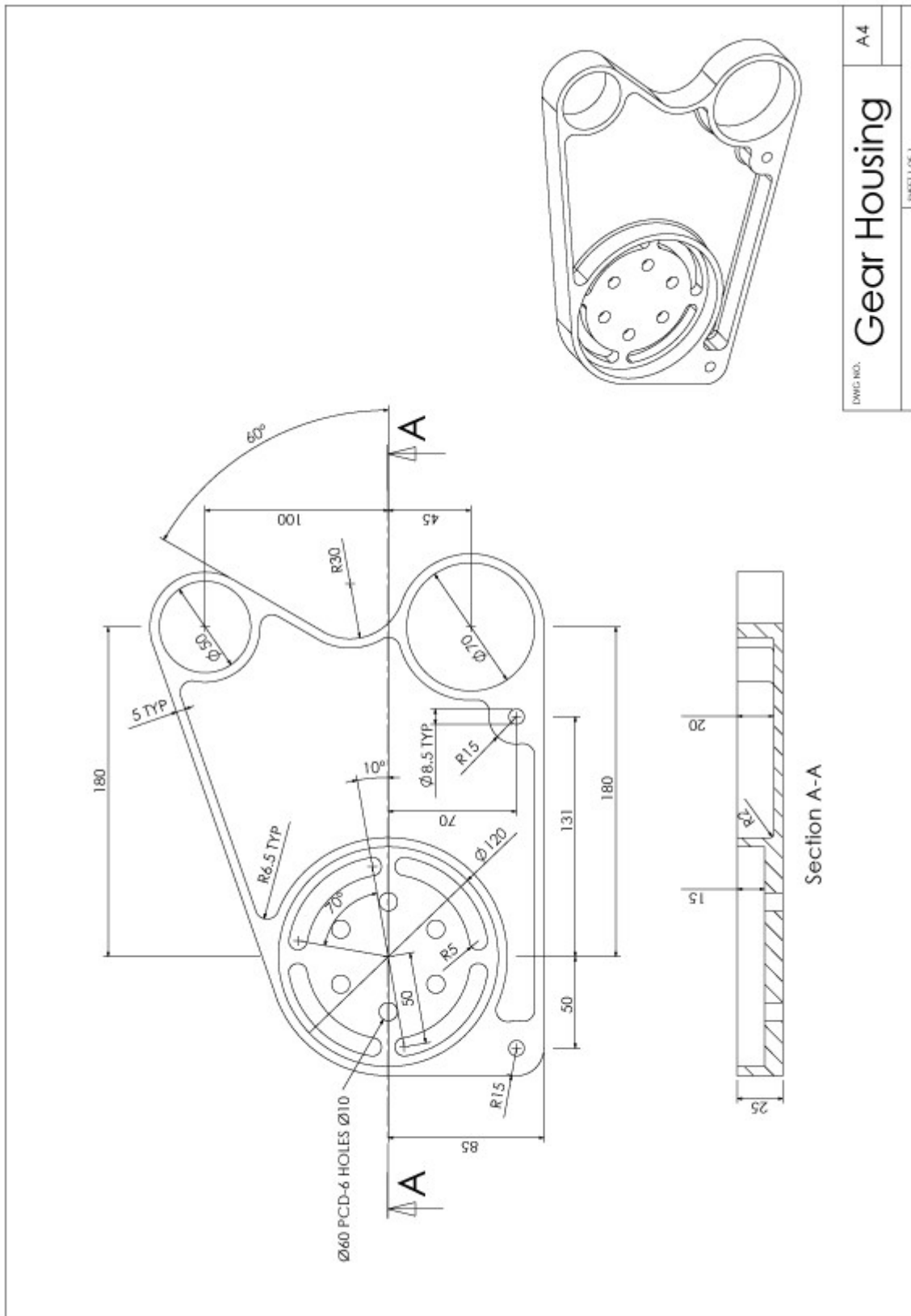
Choose the Nc Code tab on the Part Manager :



There are two choices:

- Click the  button and save the Nc code to disk.
- Click the  button and send directly to the machine, using RS232 communications.

Gear Housing Drawing



Index

Gear Housing Drawing, 118
Getting Started, 1-2
Step 1 - Create three circles, 4-5
Step 1 - Process plan, 46
Step 10 - Create two circles, 23-24
Step 10 - Finish counterbore, 85-88
Step 11 - Create fillets, 25-26
Step 11 - Finish inside, 89-92
Step 12 - Machine radial slots, 93-99
Step 12 - Trim contours, 27-29
Step 13 - Connect contours, 30-31
Step 13 - Spot drill holes, 100-104
Step 14 - Create circle, 32
Step 14 - Drill holes, 105-108
Step 15 - Drill holes, 109-111
Step 15 - Rotate circle, 33-34
Step 16 - Create Material Stock, 112-114
Step 16 - Trim contours, 35-37
Step 17 - Connect contours, 38-39
Step 17 - Solid Simulation, 115-116
Step 18 - Output Nc code, 117
Step 18 - Rotate contour, 40-41
Step 19 - Create circles, 42-43
Step 2 - Create offsets, 6
Step 2 - Set start point, 47-48
Step 20 - Create circles, 44
Step 3 - Create line, 7-8
Step 3 - Prepare for roughing, 49-50
Step 4 - Create line, 9-10
Step 4 - Rough outside profile, 51-59
Step 5 - Create fillet, 12-13
Step 5 - Rough counterbore, 60-63
Step 6 - Create line, 14-15
Step 6 - Rough bores, 64-66
Step 7 - Create line, 16-18

Step 7 - Rough inside, 67-70

Step 8 - Create fillet, 19-20

Step 8 - Finish outside profile, 71-77

Step 9 - Create offsets, 21-22

Step 9 - Finish bores, 78-84