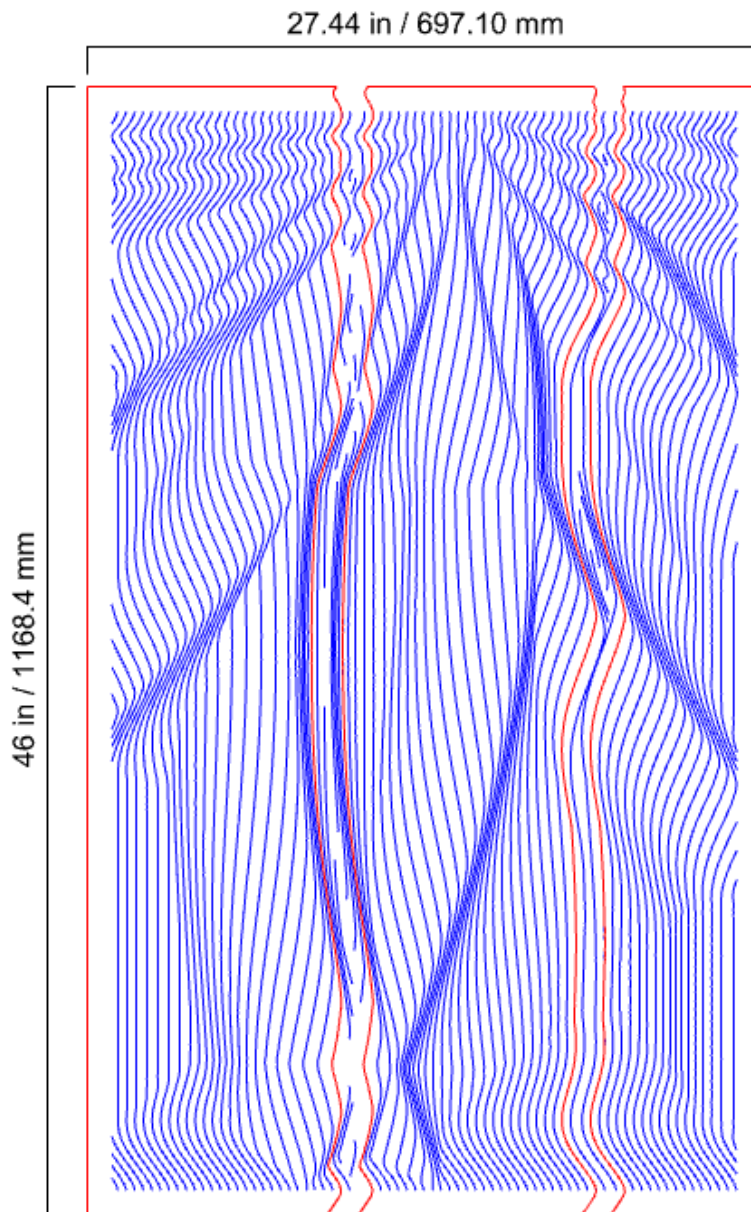


M.R. Walls Test File

Import

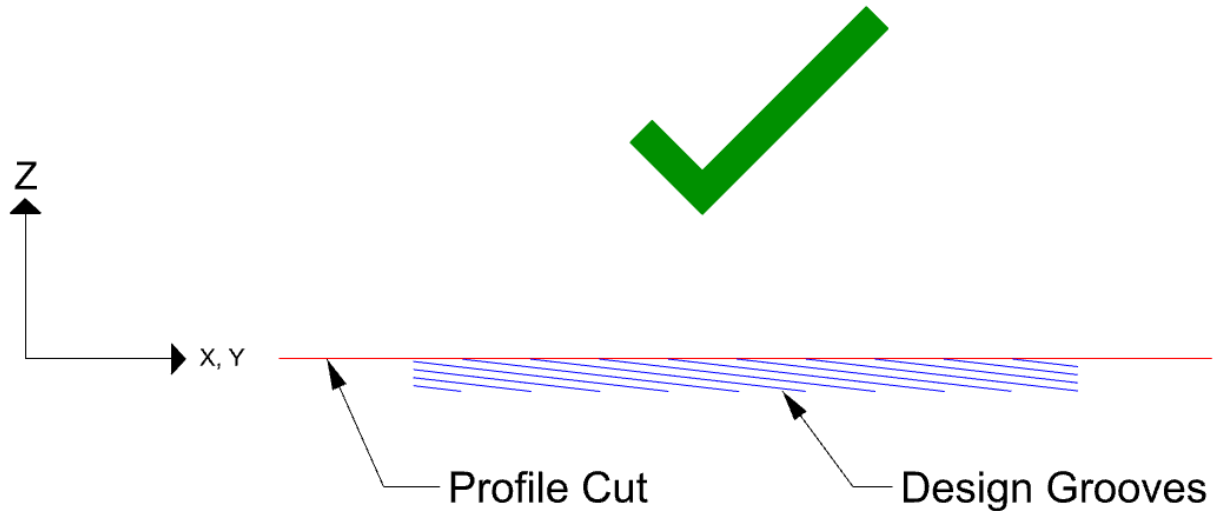
- Open new Rhino file in MM
- Import file "MR Walls Test File MM"
- Dimensions should match the diagram below



Front

View Diagram

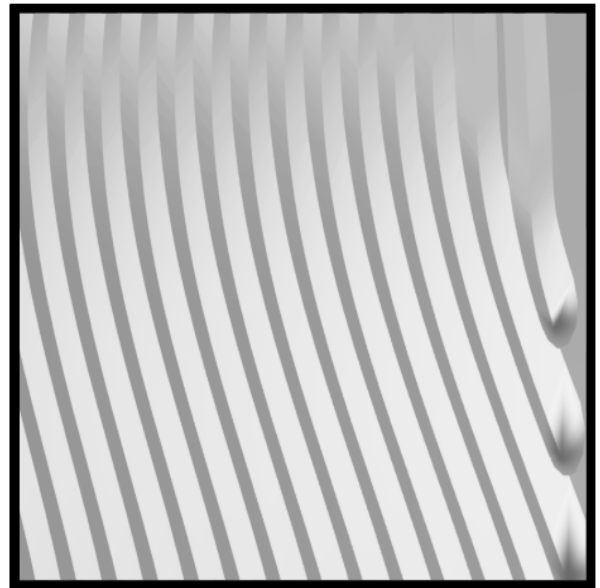
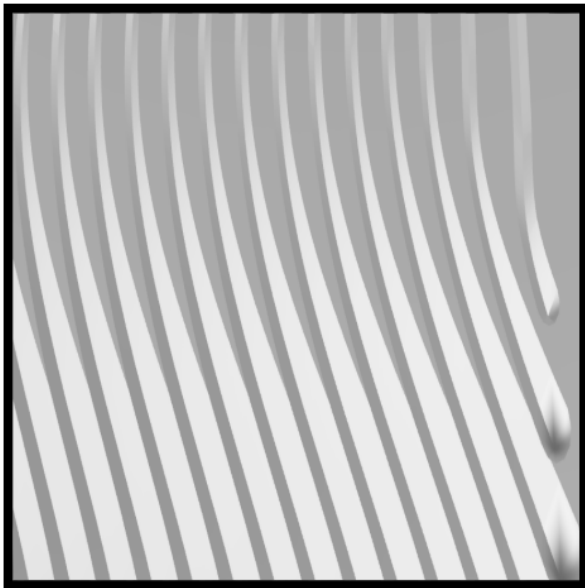
- After importing, the curves should have multiple heights. This is visible in Front View. This is called the Z depth or Z Variable. **Make sure the Z depth is not flat.**



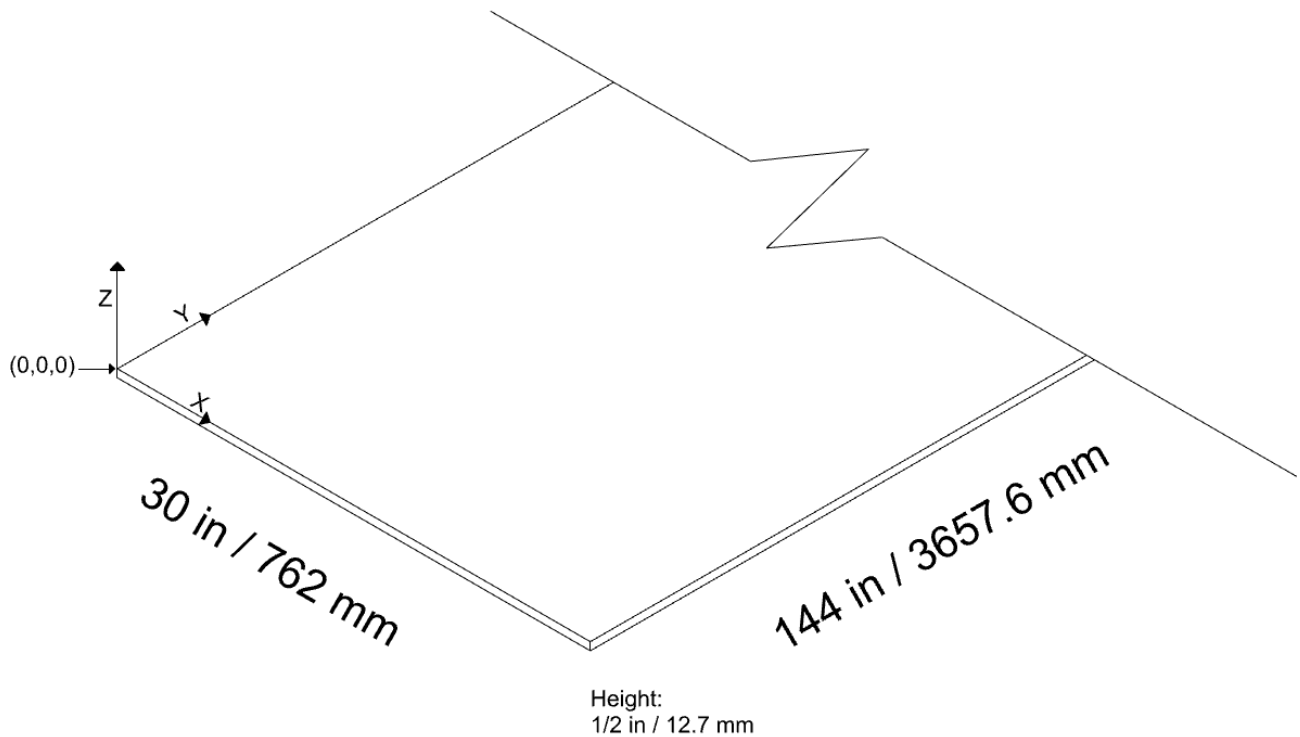
**** Notice the Z depth is changing**

CAD Simulation Diagram

- CAM Simulation will show the correct Z Variable depths. **The correct grooves will vary in width.** Near the borders the grooves will fade up. The incorrect Z variable will show grooves that are consistent in width and do not fade.



CNC Guide and Recommendation Notes



*** Z zero is set at top of material**

Tools

Layer Puzzle Grooves

Tool: V- 90

MOP type: Engraving

Cut Depth: 0

Layer Puzzle Profile

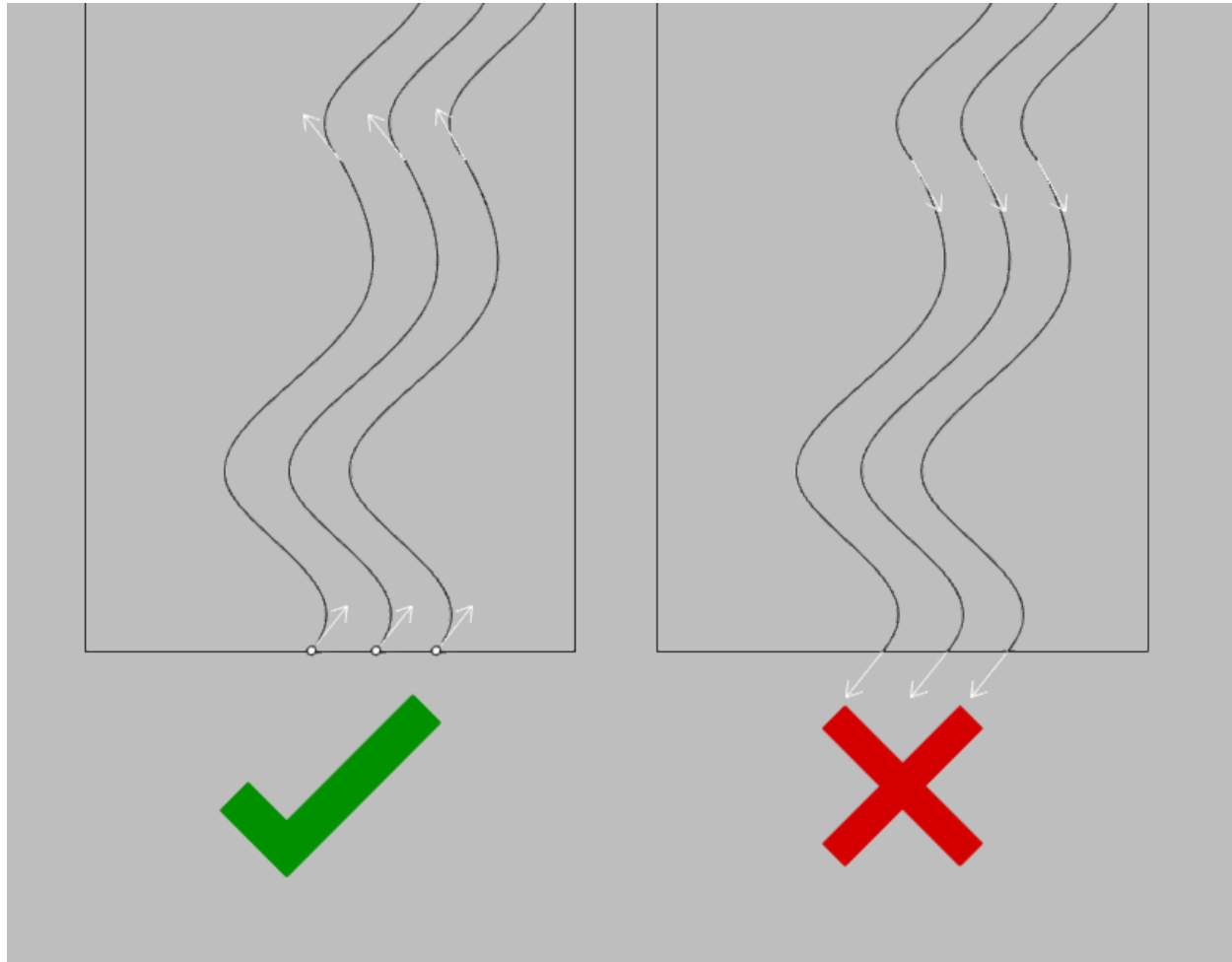
Tool: 1/4 in end mill

MOP type: Profile (Outside Cut)

Cut Depth: .51 in

*** Tool sharpness is required to avoid melted dust or micro chipping**

Tool Path Direction



- Direction must be Bottom → Top, Right → Left
- Rhino users: use command “Dir” to check/change Direction

* Test file has correct Directions

Parameters

Feed:

390 inches per minute or 8-10 meter per minutes

Speed:

18000 RPM

Necessary Profile Parameters:

- Entry/Exit: **NONE**
- Bridges (Tabs): **NONE**
- Arc fitting: **NONE**
- Rounding: **NONE**