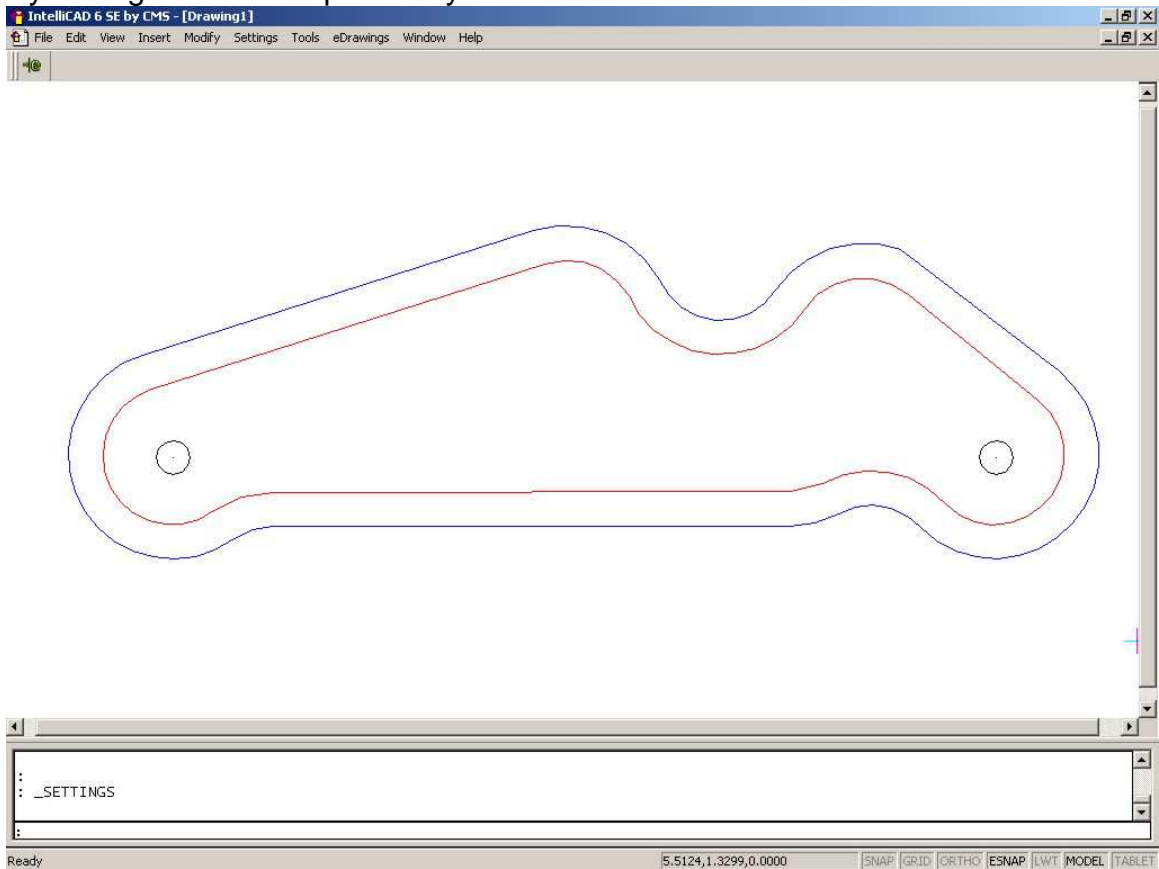


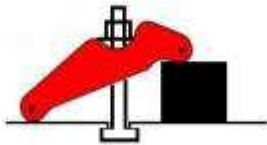
CAD2Mill

Start with a drawing called clamp.dxf converted to Polyline.
Using the Offset Command offset the profile by half the Tool Diameter.
The Blue Line is the Tool's path.
From the Edit menu select Cut.
Cut the Inside profile.
From the File menu select Save as.
Save the Blue Outside tool path as clampcut. Dxf.
By saving this as clampcut.dxf your other dxf can be intact for future reference.

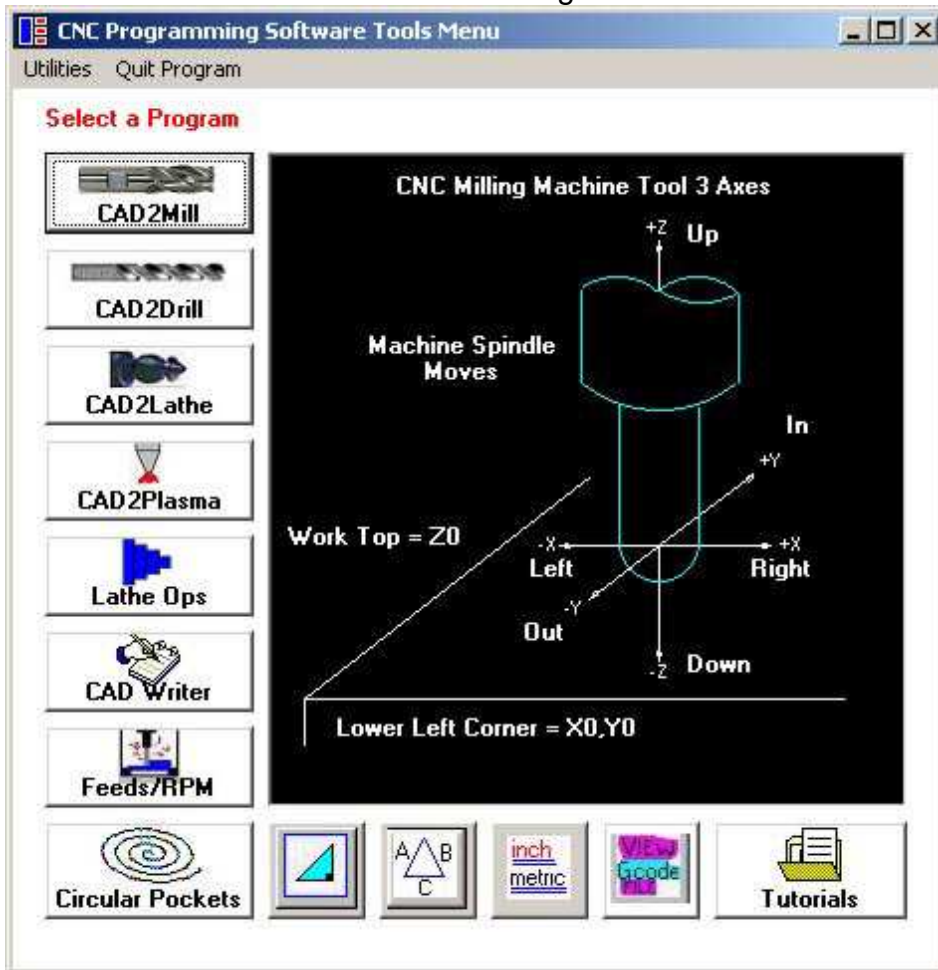


This is what the Clamp does.

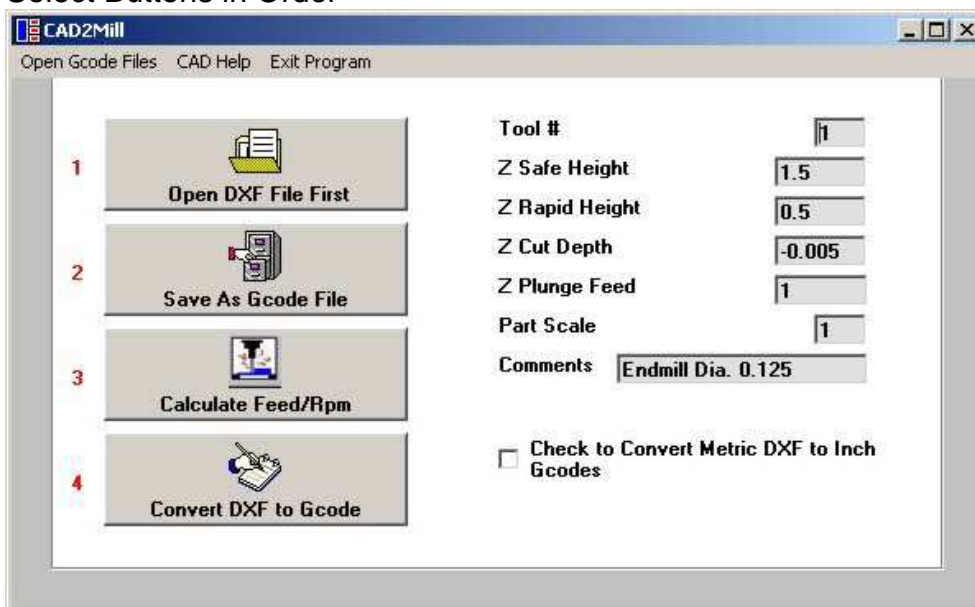
Make 2 sides for one clamp. Space & bolt together



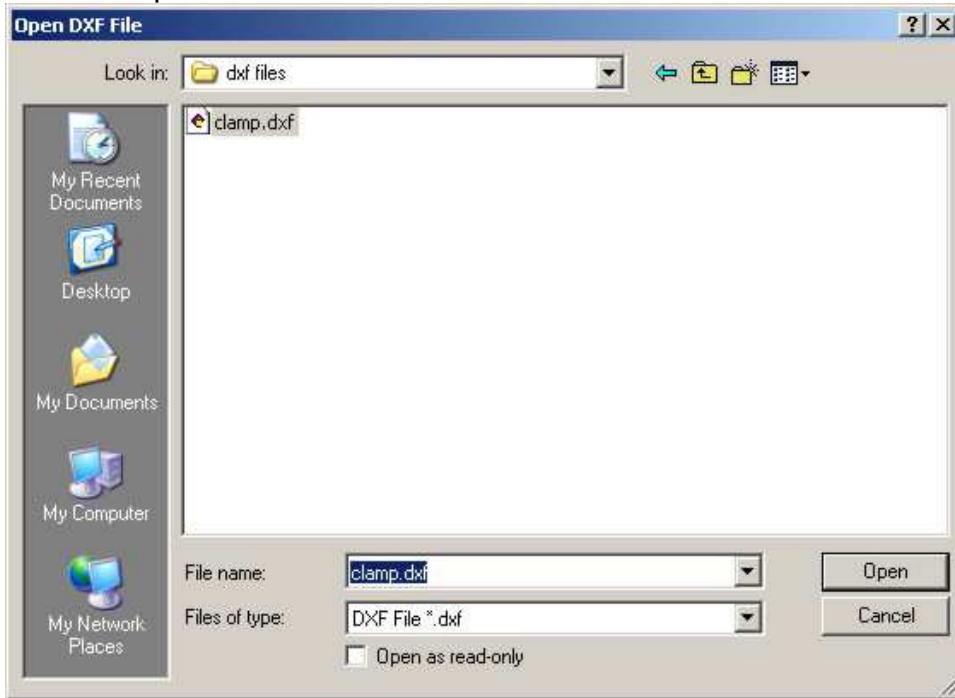
Next Select the Gcode Conversion Program



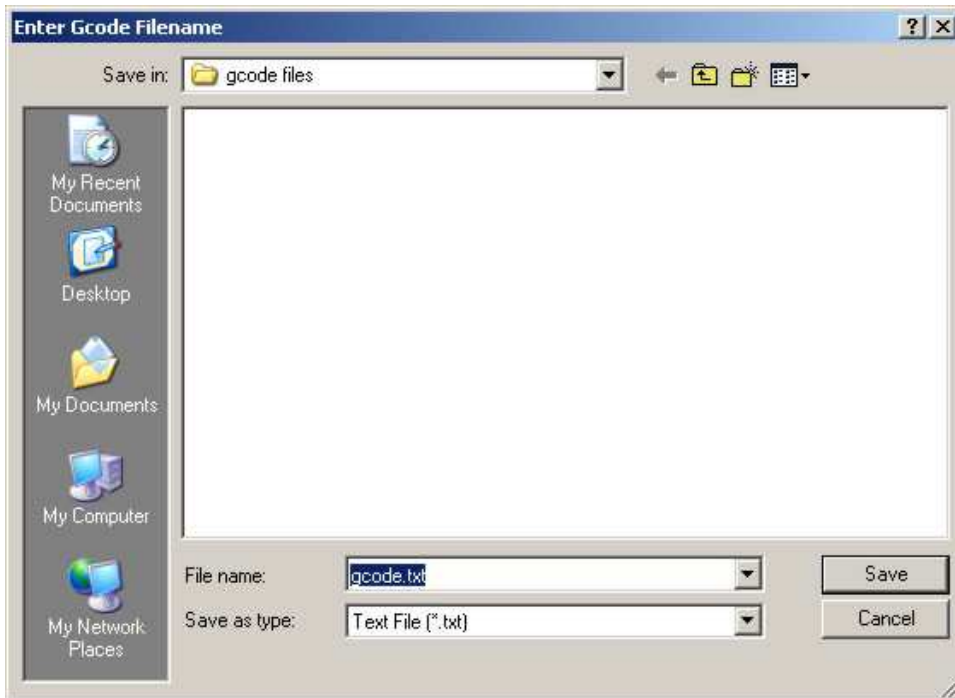
CAD2Mill Program
Select Buttons in Order



Click on Open DXF File



Click on Save As Gcode File



Speed/Feeds Calculator
Click on Calculate Speed/Rpm
Click on Material first
Then Tool
Then Diameter

The screenshot shows the 'Speeds/Feeds Calculator' window. At the top, there are two dropdown menus: 'Select Material' and 'Select Tool'. Below them is a checkbox for 'Check for Metric' and a 'Diameter' dropdown menu. The window is divided into four sections, each with a 'Calculate' button and a 'Reset' button:

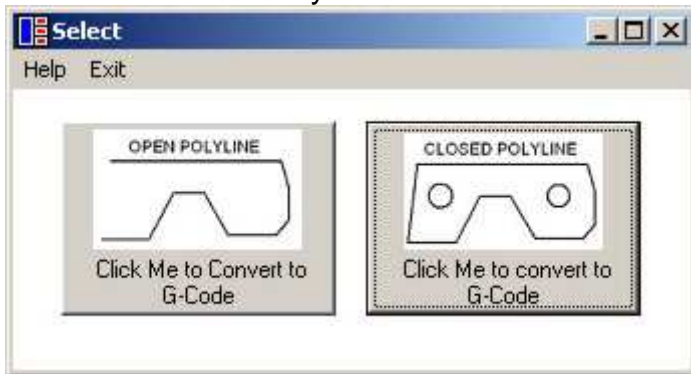
- Revolutions per Minute (RPM):** 'Enter SFM' is empty, 'Diameter' is empty, and 'RPM' is empty.
- Surface Feet per Minute (SFM):** 'Enter RPM' is empty, 'Diameter' is empty, and 'SFM' is empty.
- Inches per Tooth (IPT):** 'Enter IPT' is 3.0, '# Flutes' is 2, 'RPM' is empty, and 'IPT' is empty.
- Inches per Minute (IPM):** 'Enter IPT' is .0001, '# Flutes' is 2, 'RPM' is empty, and 'IPM' is empty.

Calculate the RPM and Feed (IPM) for the Tool Diameter

The screenshot shows the 'Speeds/Feeds Calculator' window with the following values entered:

- 'Select Material' is set to 'Aluminum' and 'Select Tool' is set to 'High Speed Steel (HSS)'. The 'Diameter' dropdown is set to '0.125'.
- Revolutions per Minute (RPM):** 'Enter SFM' is 500, 'Diameter' is 0.125, and 'RPM' is 15279.
- Surface Feet per Minute (SFM):** 'Enter RPM' is 15279, 'Diameter' is empty, and 'SFM' is empty.
- Inches per Tooth (IPT):** 'Enter IPT' is 3.0, '# Flutes' is 2, 'RPM' is 15279, and 'IPT' is empty.
- Inches per Minute (IPM):** 'Enter IPT' is .0001, '# Flutes' is 2, 'RPM' is 15279, and 'IPM' is 3.0558.

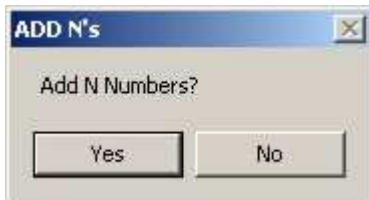
Click on Convert DXF to Gcode
Then Select Open or Closed Polyline
A Closed Polyline is one continuous profile.
Circle is a Closed Polyline too.



Next click OK



Next click Yes or No



Next If Yes was selected
Change the Filename if you want.



The files are done one has N's



That's it run the gcode file to verify it is correct.