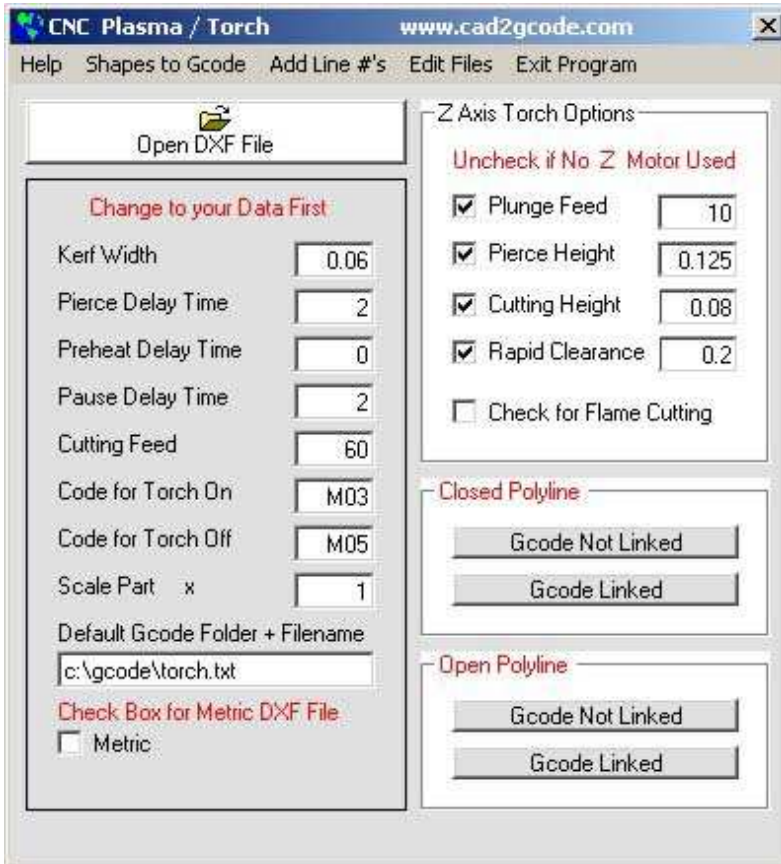


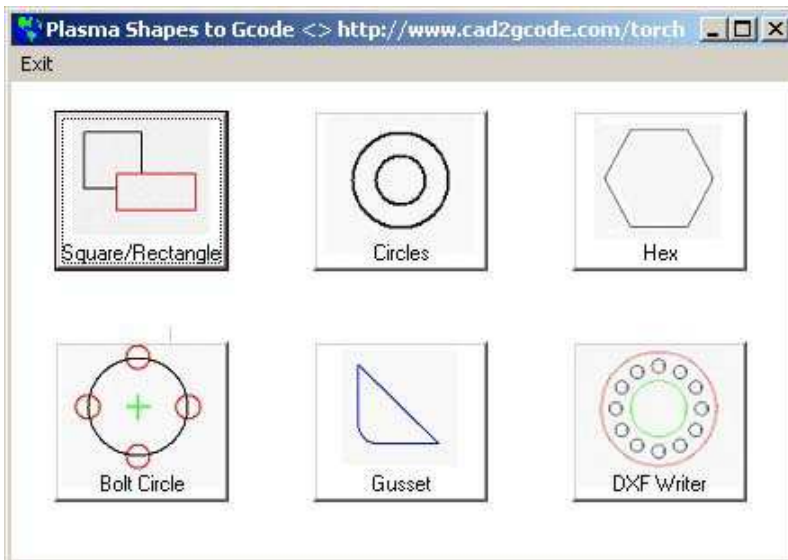
# Combine Plasma Shapes for CNC CAD CAM

By Bob Adams

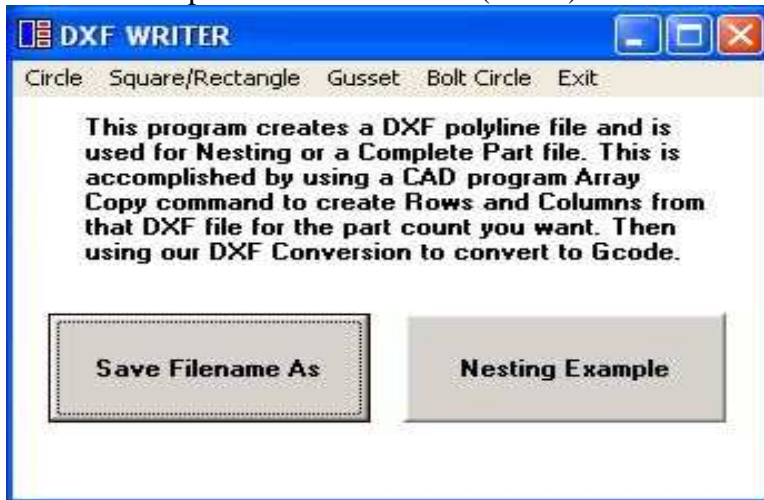
To Start Select from the Main Menu click on DXF Writer



Click on DXF Writer



Select the Shape that is the First Cut (Circle)



Example: Flange Part (Default file is Part.dxf)

Data input:

1. 1" Diameter hole
2. 2" Bolt Circle Dia. with four (.5 Dia. holes) the first hole at 45 degrees
3. 3" Outside Diameter
4. All XY Centers are 1"

These are the three Shapes to be used:

1. Circle Inside Cut is the First Cut
2. Bolt Circle is the Second Cut
3. Circle Outside Cut is the Last Cut

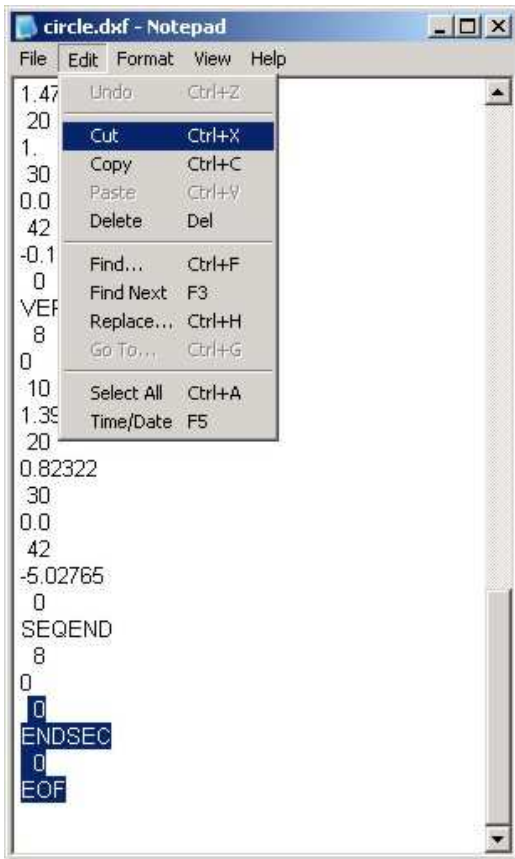
Change Kerf Width and Lead In/Out to Suit

Select Inside Cut

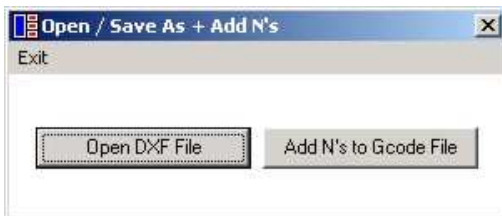


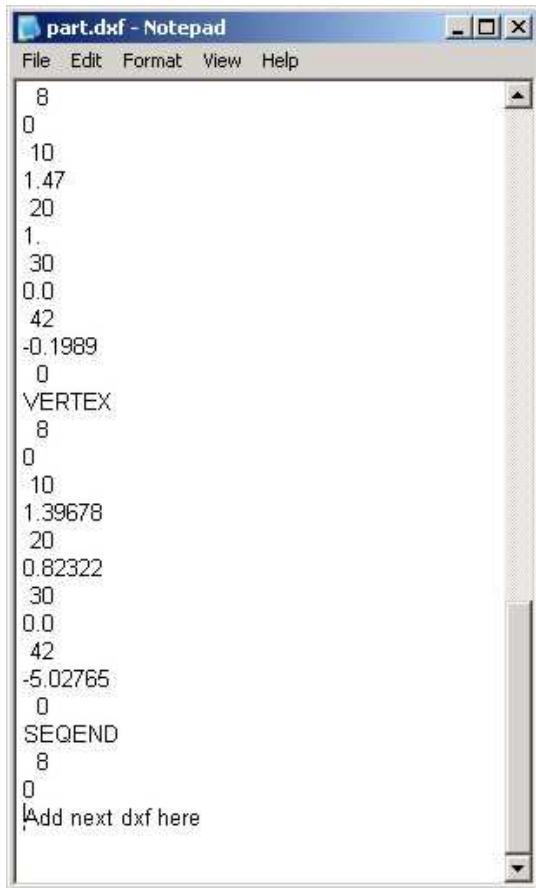
1. Next click on Make DXF
2. Enter Circle Data
3. Then click on Edit File (To Cut, Copy, Paste, and Select All)
4. Highlight the last 4 lines
5. Then click on Edit
6. Then on Cut
7. Then on File

8. Then on Save As
9. Type in File name Part.dxf
10. Then on Save



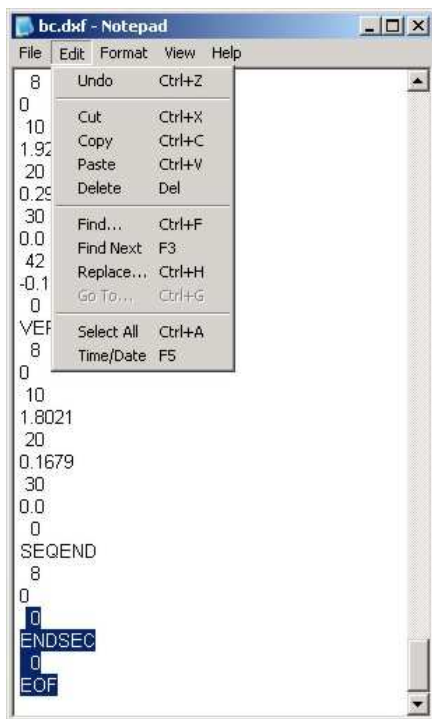
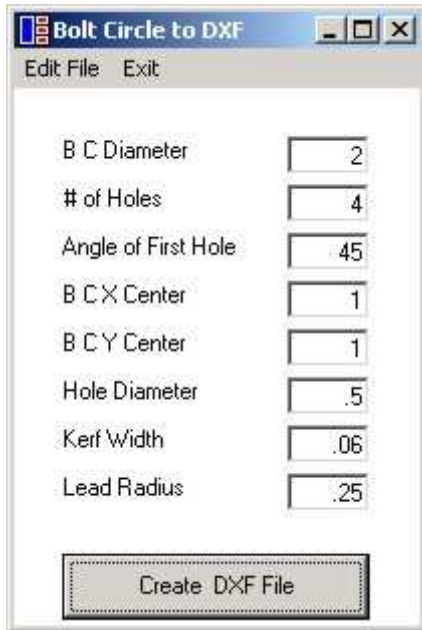
11. Next click on Add N's from the Main menu
12. Then on Open DXF File (Default File Part.dxf)





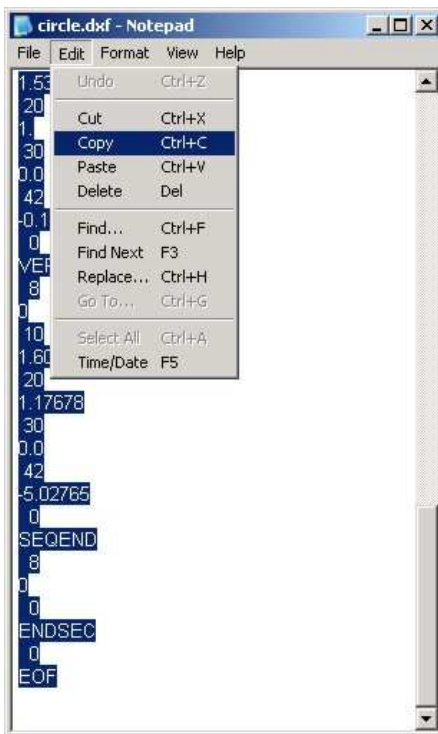
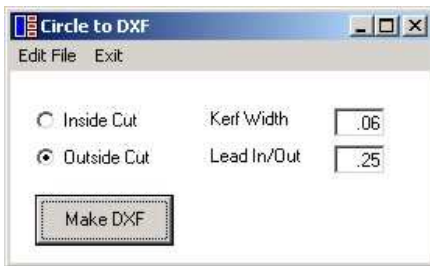
```
part.dxf - Notepad
File Edit Format View Help
8
0
10
1.47
20
1.
30
0.0
42
-0.1989
0
VERTEX
8
0
10
1.39678
20
0.82322
30
0.0
42
-5.02765
0
SEQEND
8
0
Add next dxf here
```

13. From the Main Menu click on DXF Writer
14. Select the next shape Bolt Circle
15. Enter Data
16. Click on Create DXF
17. Then on Edit File
18. Then Highlight the last 4 lines
19. Then on Edit
20. Then on Cut
21. Then on File
22. Then on Save



23. Then on Copy
24. Then on File
25. Then on Exit
26. From the Main Menu select Add N's
27. Then click on Open DXF File
28. Then on Edit
29. Then on Paste and Paste at the end of Part.dxf
30. Then click on File

31. Then on Save
32. Then on Exit
33. From the Main Menu Select DXF Writer
34. Select Circle for the Last cut
35. Select Outside Cut
36. Then click on Make DXF
37. Enter Circle data for the Outside Cut
38. Then click on Edit File



39. Then on Select All
40. Then on Copy
41. Then on File
42. Then on Exit

1. From the Main menu Select Add N's

2. Then click on Open DXF File
3. Click on Edit
4. Place the mouse at the End of the file
5. Click on Paste
6. Then on File
7. Then on Save
8. Then on Exit
9. Part File is finished

From the main menu select DXF Conversion

1. Select Get DXF File
2. Select Part.dxf
3. Then click on Open
4. Then on Closed Polyline Make Gcode file
5. Then click on OK
6. Then on Exit

Gcode File is finished

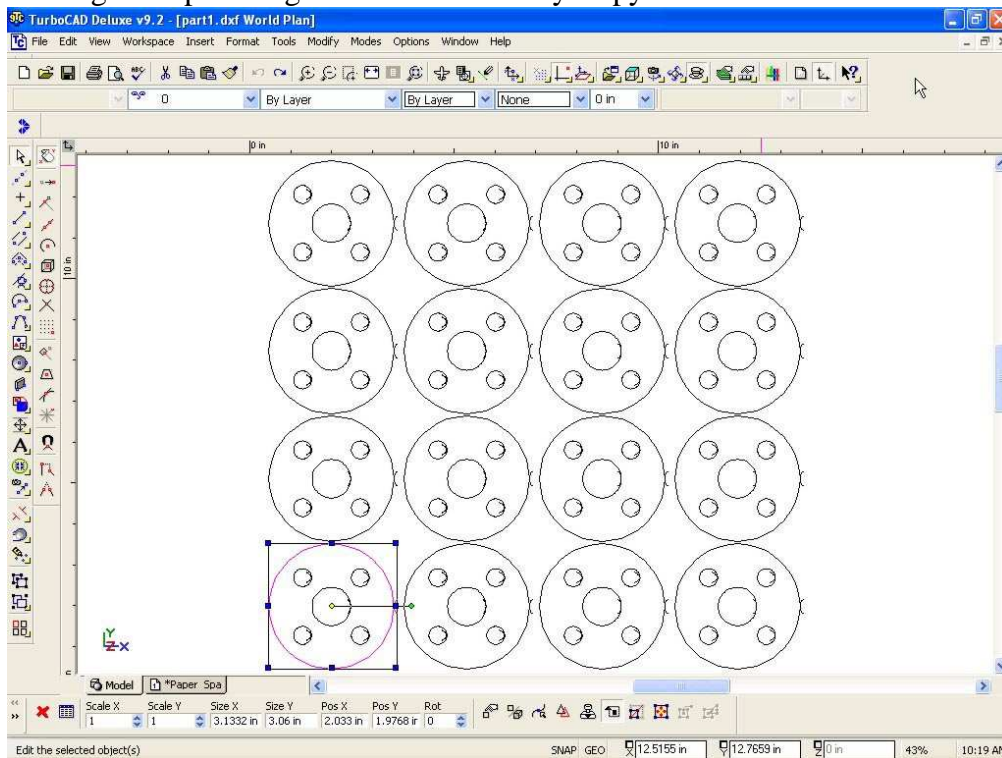
To checkout the Gcode File.

Mach3 Plasma or Turbocnc4 Machine control software is a good source.

Note:

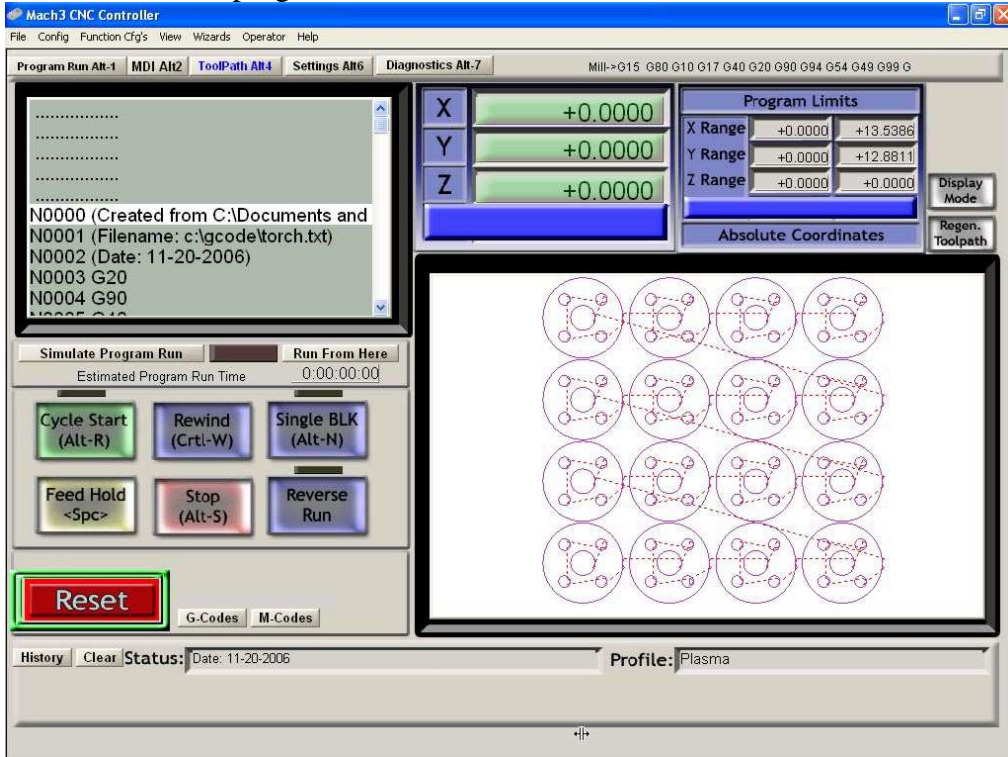
Nesting is to set number of parts required and the minimum sheet space used.

Nesting example using TurboCad 9.2 Array Copy 4 Rows 4 Columns



The Part in the Square Outline is Part.dxf

Mach3 Plasma example running Part.dxf converted to Torch.txt using our DXF Conversion program.



CNC Plasma Shapes Program

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