

## 2 Sided Part Alignment Using Sacrificial Base

This method is used when processing a part that has 2 cutting surfaces and uses a base material, or sacrificial base material, to assist on 2 sided part alignment. The sacrificial base material protects the machines aluminum table as well as providing a location for drilling and placing the pins during the “flipping” process.

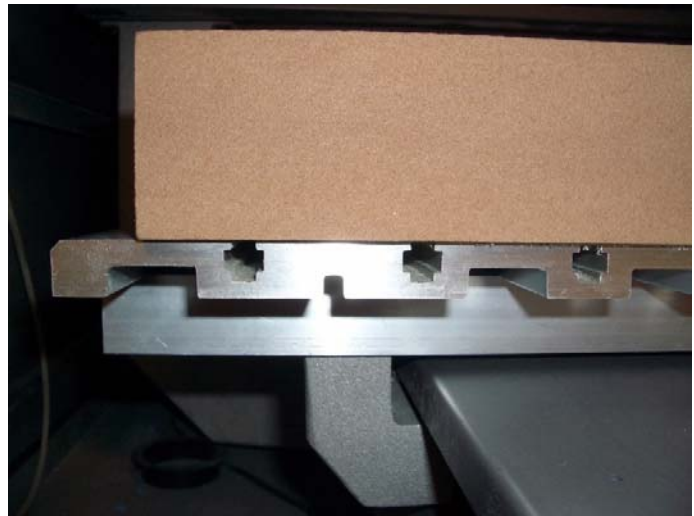
### Materials Required:

1. Base material such as particle board, wood, high density sanmodur, or similar product.
2. 4 large pins. 0.250” recommended.
3. 1 drill, or mill, for above mentioned pins.
4. Double sided tape.

Double sided tape, alignment pins, and end mill/drill.



Sacrificial base material securely mounted on top of machines table.



Top surface of sacrificial base can be drilled several times before being changed or surfaced.



## 2 Sided Part Alignment Using Sacrificial Base

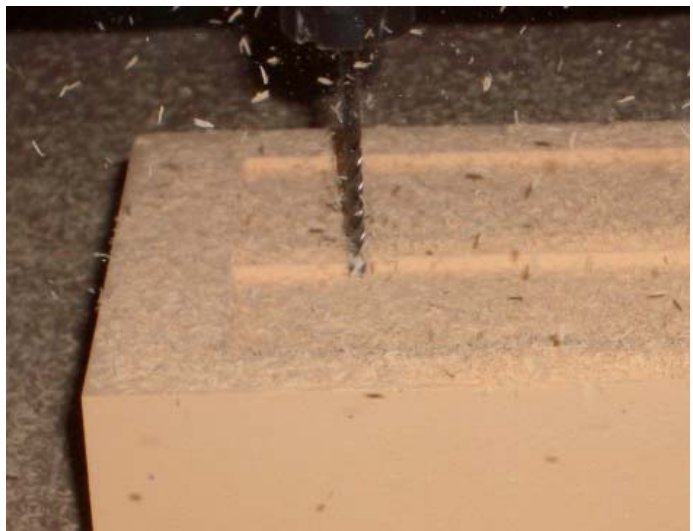
Place material stock securely on sacrificial base material using double sided tape.



Set Z zero.



Begin milling material stock.



## 2 Sided Part Alignment Using Sacrificial Base

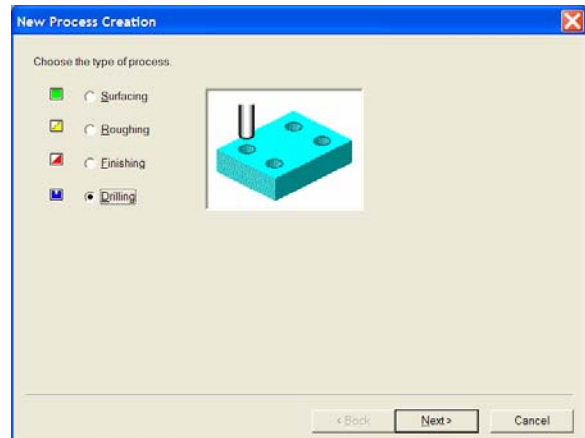
Milled, top surface.



Using MODELA Player 4 software, click on the “New Process” button to add drilling locations.

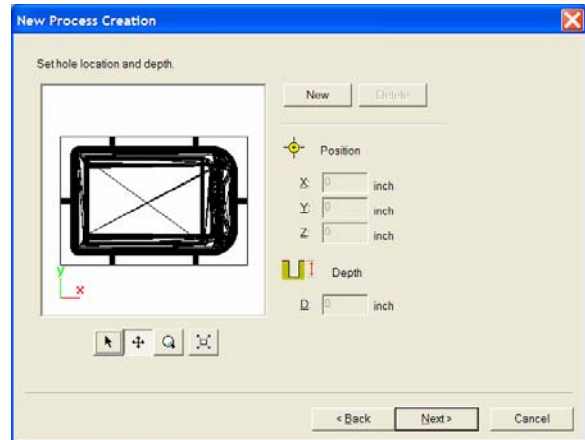


Select “Drilling” process and click “Next”. Also select appropriate cutting surface and drill size.

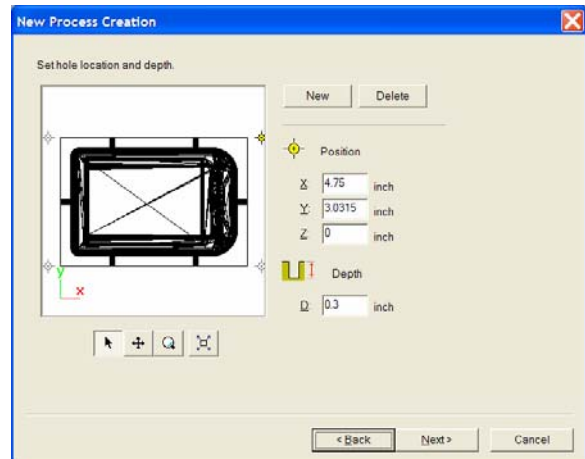


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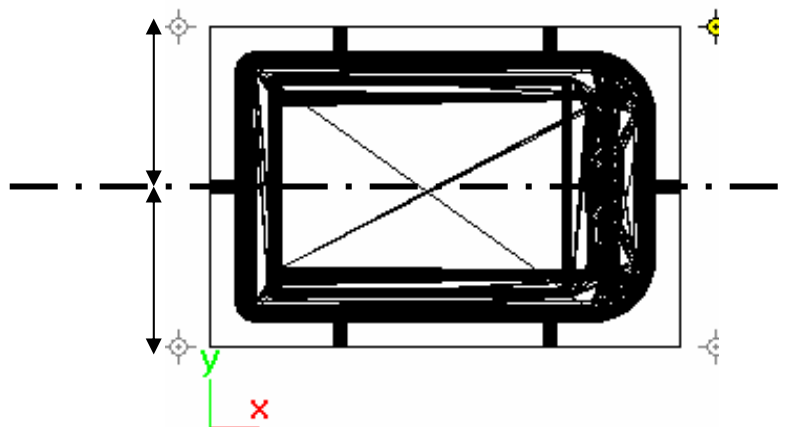
Click “New” button to add drilling positions.



Enter X, Y, positions and depth. Click “New” button to add more drilling hole locations.

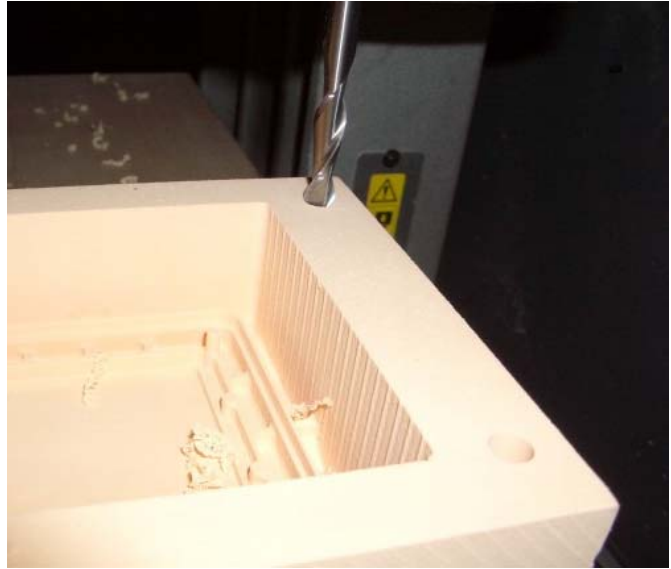


Please note when selecting location of holes, it is very important to locate the holes the same distance away from the center of the part, or axis of part rotation.

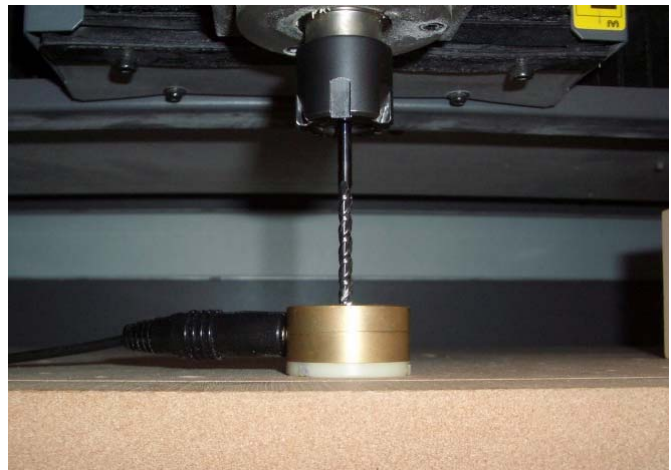


## 2 Sided Part Alignment Using Sacrificial Base

Change mills if necessary,  
and begin drilling holes in  
material



Remove milled material and  
set Z zero on sacrificial  
material.



Drill holes into sacrificial  
base material.



## 2 Sided Part Alignment Using Sacrificial Base

Add pins to sacrificial base material.



Align dilled holes with pins and carefully place milled material on top of pins. For extra rigidity, use double sided tape between board and material.

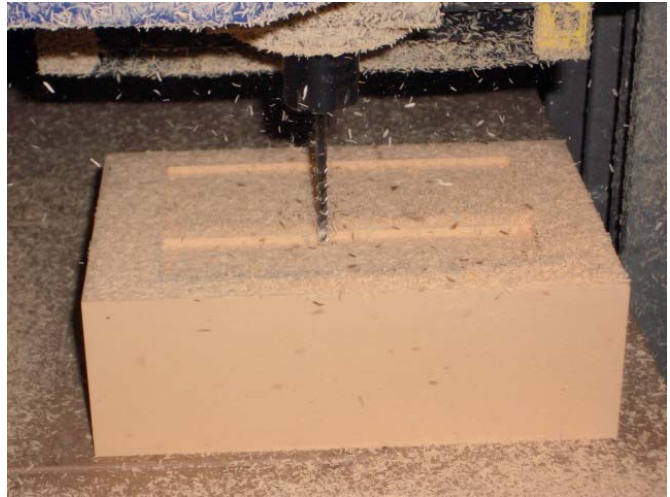


Change mills if necessary and set Z zero on milled material stock.



## 2 Sided Part Alignment Using Sacrificial Base

Continue cutting.



Finished, milled, 2 sided part.

