



Machine :

- MDX-540A & ZCL-540
- No T-Slot Table

Materials Required:

- White Acetal/Delrin Material (US-SRP-DEL)
 - 5.0" x 3.0" x 1.0" (0.5" material thickness recommended)
- 0.125 Ball End Mill (EMB-125-3F-125)
- 0.063 Ball End Mill (EMB-125-3F-063)
- 0.031 Ball End Mill (EMB-125-3F-031)
- 0.125(3.175mm) Collet
- SRP Player Software



Post Milling Clean up :

- Hack saw to cut part out
- 600 Grit sand paper to clean different parts (available @ home depot)

Special Notes:

- You may have to move the X-Origin to the right of the material more to avoid the clamp. Start the machine and set the feed rate to 10% and check the clearance as it runs. If you have 0.5" thick material, simply change the material thickness and recreate tool paths on step 3.