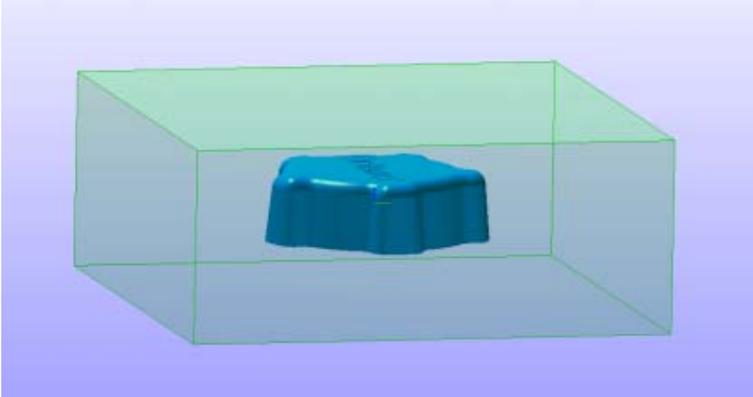


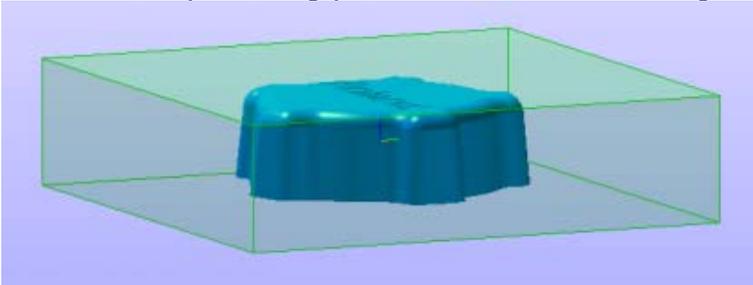
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Model: Roland MDX-540 series and MDX-40
Subject: SRP Player Tips
Date: 12/17/2007
Author: PG

The following document demonstrates how to optimize SRP Player software to minimize milling time. The complexity of a part, its size, and the material being cut will dictate how long it will take to cut on a machine. Here are some tips to keep in mind while setting up a part to cut on your machine.

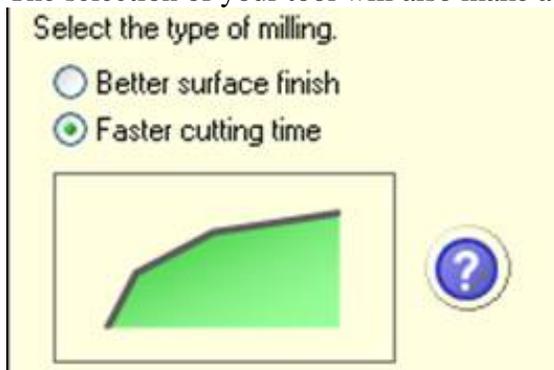
If your part is small, and your material thick, then this will add to the process time.



You want to try and keep your material as close to the part size as possible.



The selection of your tool will also make a big difference in time. If you select faster cutting time...



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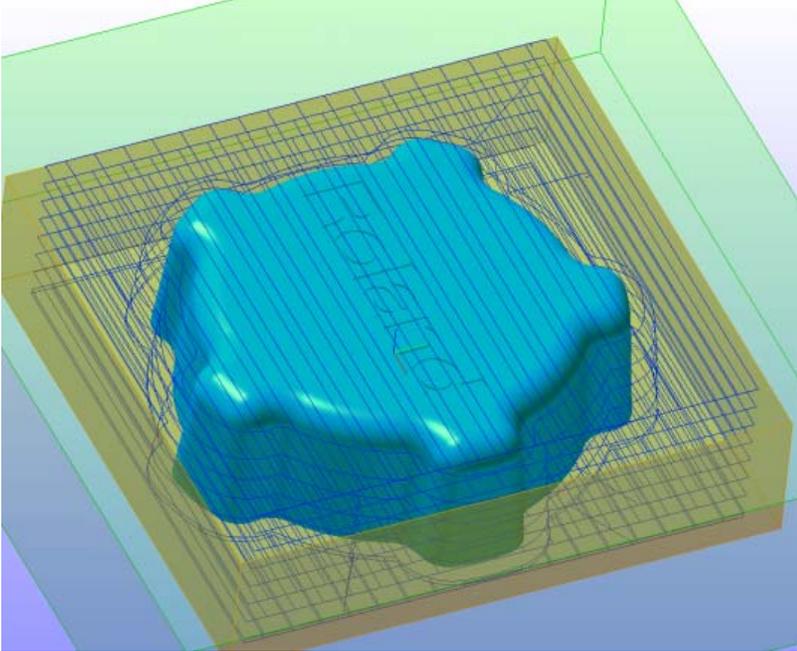
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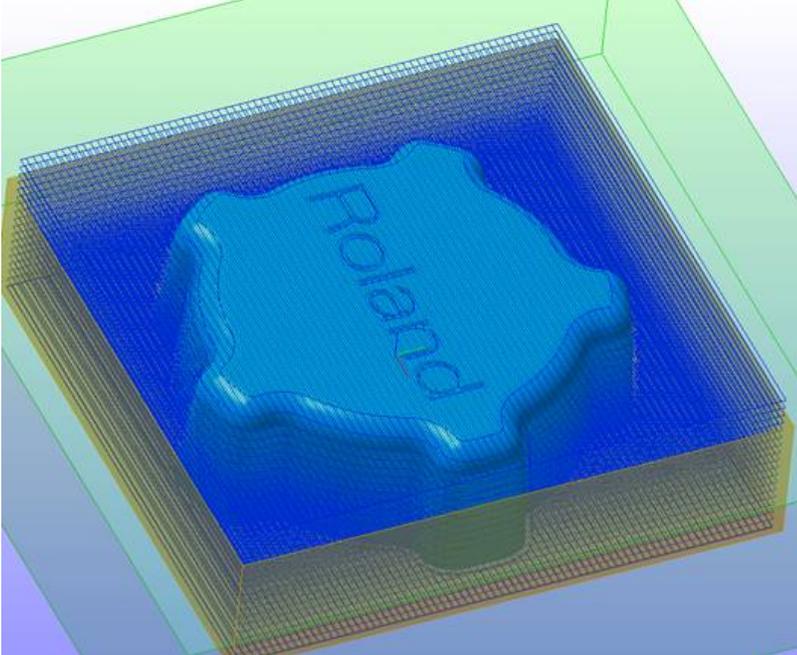
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...it will select the largest tool you have and cut faster



If you select better surface finish, then it will select a much smaller tool.



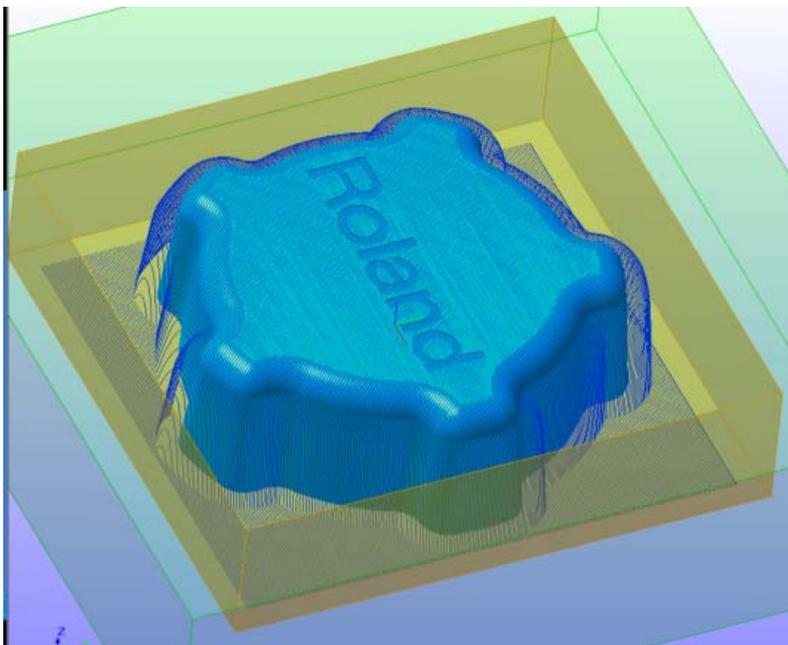
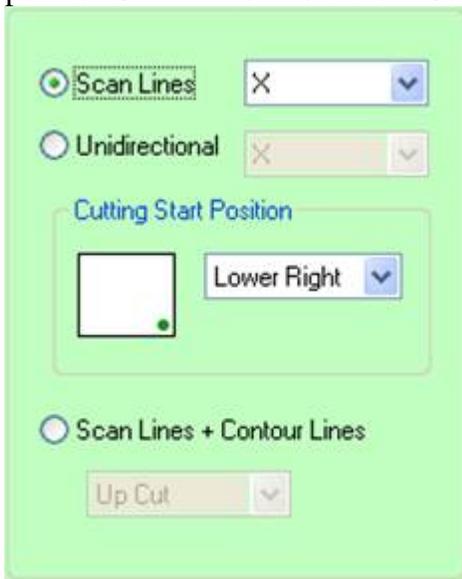


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When a smaller tool is selected, it will need more passes to remove the material. All the additional lines seen in the above picture translate to longer milling times.

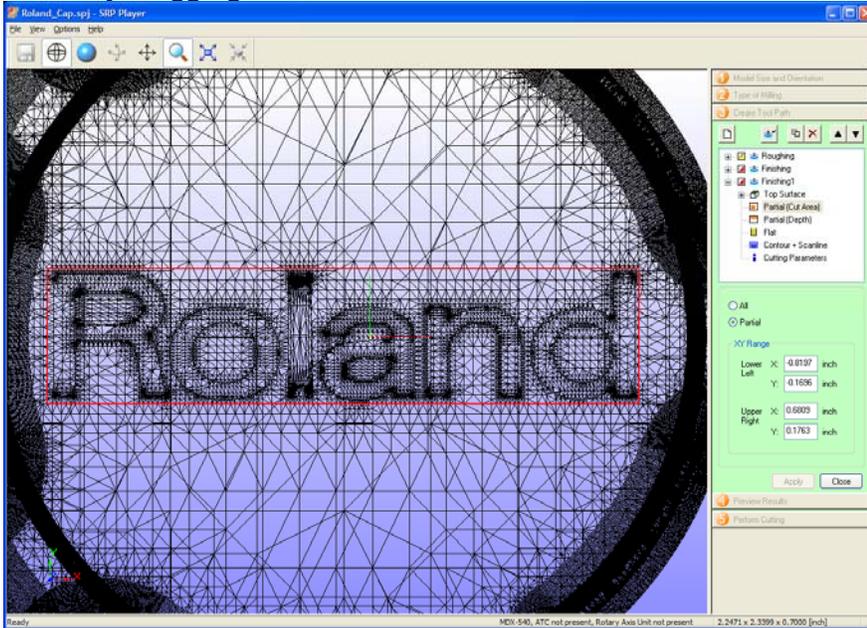
The best thing to do is select as big a tool as you can. If you need more detail, then select a smaller tool on the finishing portion of the program. To speed the process up even more, change the finishing tool path to “Scan Lines” instead of “Contour Lines”.



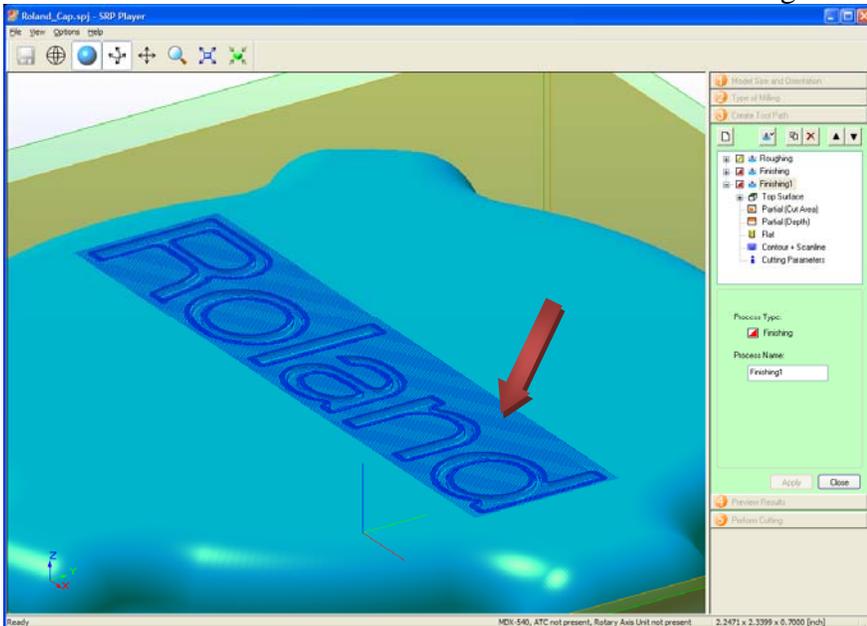
Disclaimer: All of the information contained in this document is based on the information available at the time of its creation. In no event will Roland ASD be liable to you for any damages, including damages for loss of business profits, business interruption, loss of business information and the like arising out of the use of or inability to use these materials.

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If you have small letters or small features in the part, cut the rest of the part with a larger tool and use a smaller tool just for the letters. Start by adding a finishing tool path. Set the cut area only around the letters by dragging the red box around the details. Next, select a tool that will fit in the letters.

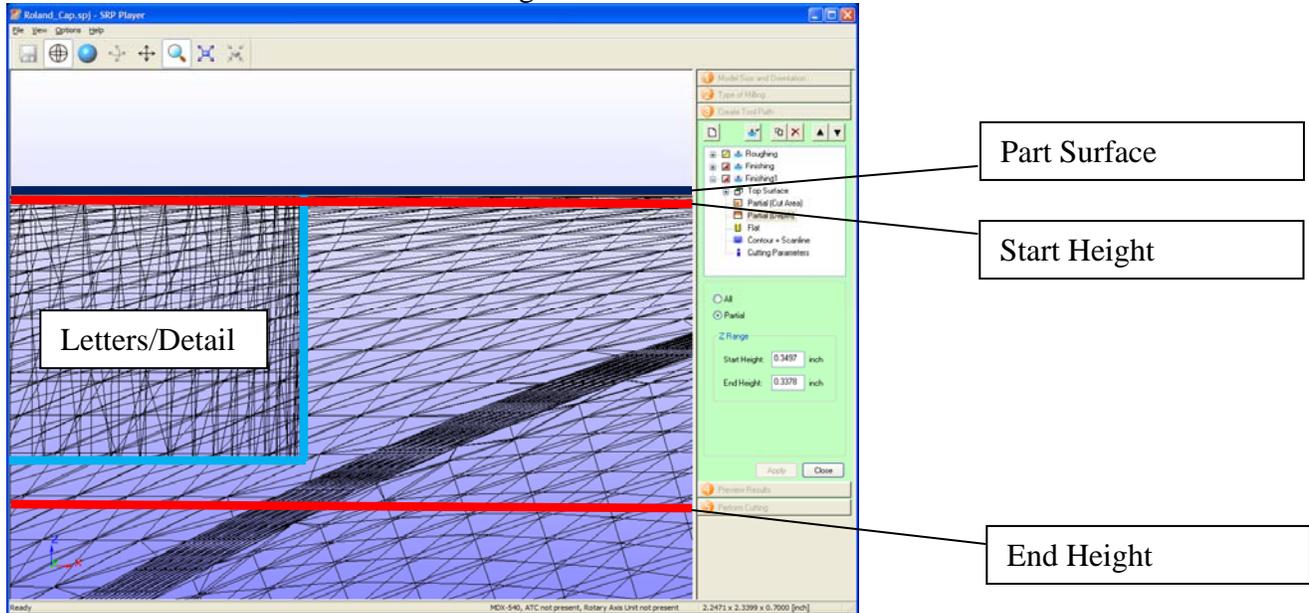


To avoid the additional surface lines shown in the below image...



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...set the start height so that it is just below the surface of the part. Usually about 0.001” to 0.002” below the surface of the material works great.



This will allow you to cut only the details required and not waste any additional time.

