

# CNC MACHINIST REFERENCE CHART

## MATERIAL CONSIDERATIONS

### ABS

Acrylonitrile butadiene styrene is a terpolymer, meaning a combination of three polymers. ABS is a versatile, impact-resistant material that is easy to add color to and construct things with.

### Aluminum 6061

Aluminum is a lightweight, durable, and corrosion-resistant metal that is electrically conductive. The most commonly used, general-purpose alloy is 6061 aluminum, which offers a great blend of strength and machinability.

### Carbon Steel

As defined by AISI, carbon steel contains a carbon content up to 2.1% by weight. Lower carbon steels suitable for machining include C1010 and C1018.

### HDPE

HDPE stands for high-density polyethylene. It's an inexpensive, lightweight, chemical-resistant, food-safe plastic that has a high strength-to-density ratio, making it well suited for many applications.

### Titanium

Titanium has a low density but high strength and can be alloyed with aluminum and iron among other elements. It has a low heat conductivity requiring lower cutting speeds in order to prolong tool life.

### Acrylic

Acrylic is a transparent thermoplastic derived from natural gas, more brittle than polycarbonate but more scratch resistant and available in many colors and textures.

### Brass

Brass is an alloy of primarily copper and zinc. It's often called free-machining brass because it's hard enough to hold its shape but soft enough to machine easily.

### Delrin

Delrin is the brand name for acetal homopolymer resin, which is a very hard, high-strength engineering plastic. It can withstand temperatures from -40°F to 248°F and mills easily.

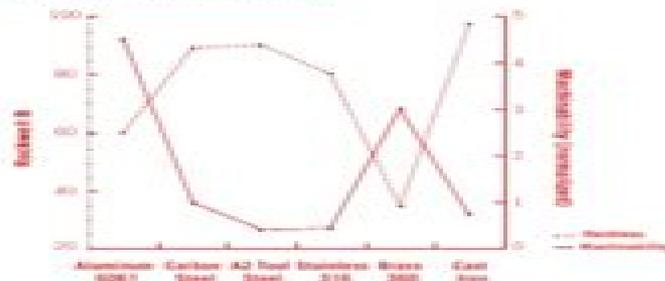
### Stainless 316

Stainless steel is a steel alloy with a minimum of 10.5% chromium. The presence of chromium creates a thin, microscopic layer preventing corrosion and rust. Stainless 316 is more resistant to acids than its 304 counterpart.

### Tool Steel

Tool steel contains a carbon content between .5% and 1.5%. The presence of carbides play a dominant role in the quality of tool steel, and the resistance to abrasion make it well suited for hard tools and machine dies.

Metal Machinability vs. Hardness



Plastic Hardness vs. Melting Point



"Take pride in your work and life. It's about the outcome, not the income."

— John Saunders, machinist & educator

## G-CODE REFERENCE

Gcode	Parameters	Command
G0	axis	Rapid traverse
G1	axis, F	Straight feed
G4	P	Dwell
G20		Inch unit mode
G21		mm unit mode
G28.3	axis	Select absolute position
G53		Select absolute coordinates
G54-G59		Select coordinate system 1-6
G90		Absolute positioning mode
G91		Incremental positioning mode

Gcode	Parameters	Command
M3	S	Spindle on CW
M4	S	Spindle on CCW
M5		Spindle off
M6		Tool change
M30		Program end

## HEX NUT SIZING CHART



## SURFACE FEET PER MINUTE

Material	HSS	Carbide
Aluminum	600	800
Brass	175	175
Delrin	400	800
Polycarbonate	300	500
Stainless Steel (303)	80	300
Steel	70	350

## COMMON CALCULATIONS

# Machinist Cnc Reference Guide

**Yolanda A. Johnson, Sonya D. Hill, Julie  
A. Mitchell**

## **Machinist Cnc Reference Guide:**

7 Easy Steps to CNC Programming . . . Book II David S. Hayden,2003 7 Easy Steps to CNC Programming Book II Beyond the Beginning is the second book in a series of introductory books on CNC Programming This book picks up where Easy Steps to CNC Programming A Beginner s Guide leaves off This books has a Frequently Asked Questions sections advanced information on Coordinates systems NURBS how to select a CAM system How to hire programmers etc *American Machinist* ,1980 *Machine Shop Trade Secrets* James A. Harvey,2005 Written by an experienced machinist and plastic injection mold maker this groundbreaking manual will have users thinking and producing like experienced machinists it provides practical how to information that can immediately be used to improve one s machining skills craftsmanship and productivity *American Machinist & Automated Manufacturing* ,1991-07 U.S. Industry Profiles Diane M. Sawinski,1995 *CNC Programming* Michael J. Peterson,2008-06-11 This book is a new up and coming all in one Reference book for the CNC machinist This book covers basic Mill and Lathe G Code CNC programming In addition to basic programming this book has many useful formulas and charts for everyday use for the CNC Machinist Counterbore Centerdrill Countersink and Internal and External Thread Charts Trig reference page Drill point countersink diameter formulas and also Surface Footage formula with Chart Please check out my complimentary books CNC Programming Basics Tutorial CNC Programming Basics Tutorial Textbookwww cncprogrammingbook comwww cncbasics com Projects Discounts

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many disciplines including road racing and drag racing *Proceedings, the Second International Conference on Industrial & Engineering Applications of Artificial Intelligence & Expert Systems*, 1989 **Machining Processes and Machines**

Zainul Huda, 2020-12-14 Machining is one of the eight basic manufacturing processes This textbook covers the fundamentals and engineering analysis of both conventional and advanced non traditional material removal processes along with gear cutting manufacturing and computer numerically controlled CNC machining The text provides a holistic understanding of machining processes and machines in manufacturing it enables critical thinking through mathematical modeling and problem solving and offers 200 worked examples calculations and 70 multiple choice questions on machining operations as well as on CNC machining with the eBook version offered in color This unique book is equally useful to both engineering degree students and production engineers practicing in the manufacturing industry Modern Engine Blueprinting Techniques

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## **Table of Contents Machinist Cnc Reference Guide**

1. Understanding the eBook Machinist Cnc Reference Guide
  - The Rise of Digital Reading Machinist Cnc Reference Guide
  - Advantages of eBooks Over Traditional Books
2. Identifying Machinist Cnc Reference Guide
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Machinist Cnc Reference Guide
  - User-Friendly Interface
4. Exploring eBook Recommendations from Machinist Cnc Reference Guide

- Personalized Recommendations
  - Machinist Cnc Reference Guide User Reviews and Ratings
  - Machinist Cnc Reference Guide and Bestseller Lists
5. Accessing Machinist Cnc Reference Guide Free and Paid eBooks
    - Machinist Cnc Reference Guide Public Domain eBooks
    - Machinist Cnc Reference Guide eBook Subscription Services
    - Machinist Cnc Reference Guide Budget-Friendly Options
  6. Navigating Machinist Cnc Reference Guide eBook Formats
    - ePub, PDF, MOBI, and More
    - Machinist Cnc Reference Guide Compatibility with Devices
    - Machinist Cnc Reference Guide Enhanced eBook Features
  7. Enhancing Your Reading Experience
    - Adjustable Fonts and Text Sizes of Machinist Cnc Reference Guide
    - Highlighting and Note-Taking Machinist Cnc Reference Guide
    - Interactive Elements Machinist Cnc Reference Guide
  8. Staying Engaged with Machinist Cnc Reference Guide
    - Joining Online Reading Communities
    - Participating in Virtual Book Clubs
    - Following Authors and Publishers Machinist Cnc Reference Guide
  9. Balancing eBooks and Physical Books Machinist Cnc Reference Guide
    - Benefits of a Digital Library
    - Creating a Diverse Reading Collection Machinist Cnc Reference Guide
  10. Overcoming Reading Challenges
    - Dealing with Digital Eye Strain
    - Minimizing Distractions
    - Managing Screen Time
  11. Cultivating a Reading Routine Machinist Cnc Reference Guide
    - Setting Reading Goals Machinist Cnc Reference Guide
    - Carving Out Dedicated Reading Time
  12. Sourcing Reliable Information of Machinist Cnc Reference Guide

- Fact-Checking eBook Content of Machinist Cnc Reference Guide
  - Distinguishing Credible Sources
13. Promoting Lifelong Learning
    - Utilizing eBooks for Skill Development
    - Exploring Educational eBooks
  14. Embracing eBook Trends
    - Integration of Multimedia Elements
    - Interactive and Gamified eBooks

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