

FINAL YEAR PROJECT REPORT

CNC WOOD ENGRAVING AND CUTTING MACHINE

In fulfillment of the requirement For degree of BEE (Electronics)

By

BASIT NOOR KHAN MUHAMMAD OMAIR HIBA FATIMA 25349 BEE(ELECTRONICS) 25426 BEE(ELECTRONICS) 25487 BEE(ELECTRONICS)

SUPERVISED

BY

ENGR. MR TAIMUR ALVI

BAHRIA UNIVERSITY (KARACHI CAMPUS) 2011-2015

ACKNOWLEDGEMENTS

We would like to thank everyone who had contributed to the successful completion of this project. We would like to express our gratitude to our respected teachers, Specially Sir Taimur Alvi, Sir Adnan, Sir Umair Arif, Sir Wajid and all who helped us in the journey of completing this project with their guidance and their enormous patience throughout the development of the research.

In addition, we would also like to express our gratitude to our loving parents and friends who had helped and given me encouragement.

ABSTRACT

The objective of the project is to design and fabricate a computer controlled wood engraving and cutting machine for optimized wood cutting to achieve cost effectiveness and maintain the required accuracy and reliability for complex shapes.

Wood routing and cutting is an electromechanical process in which a drill is used to cut or engrave the wood and its directions are controlled by the computer. Such cutting machines are generally classified into two categories, namely, large scale (fixed) and small scale (portable) machines. The target is to develop a small scale setup with limited cutting size.

The drawings shall be generated on standard platforms with fixed limits. The application software analyses the drawing, which then extracts the coordinates and sends in the form of specific command to the embedded system through the serial/USB port.

The system then controls the stepper motors to achieve the required movement and the desired position. Gantry type arrangement is used to assist motors for movement in X,Y and Z direction (3-Dimensional).

The backbone of the system is a cleverly designed but equally simple mechanical assembly, resulting in great accuracy.

The project includes significant study of design principles and technical details of the CNC machine aimed for best performance.

V

TABLE OF CONTENTS

DECLARATION	i
APPROVAL FOR SUBMISSION	ii
ACKNOWLEDGEMENTS	iv
ABSTRACT	v
TABLE OF CONTENTS	vi
LIST OF FIGURES	xi
LIST OF SYMBOLS / ABBREVIATIONS	xiii

CHAPTER

1

INTRO	DUCTIO	ON					1
1.1	INTROI	DUCTIO	ON	OF	CC	MPUTER	AIDED
MANUI	FACTUR	RING (C	AM)				1
1.2	FLOW	OF A	СОМІ	PUTER	AIDE	D MANUF	ACTURING
SYSTE	M						1
	1.2.1	GEOM	ETRIC	C MODI	ELLIN	G	2
	1.2.2	Tool m	otion	definitio	n		2
	1.2.3	Data pr	ocessi	ng			2
	1.2.4	Post pr	ocesso	r			3
	1.2.5	Data tra	ansmis	ssion			3
1.3	WHAT	IS NUM	1ERIC	AL CO	NTRO	L?	3
1.4	BASIC	СОМРО	DNEN	ETS OF	NC S	YSTEM	3
	1.4.1	Program	n of Ir	nstructio	ns		4
	1.4.2	Contro	ller Ur	nit			4
	1.4.3	Machir	ne Too	1			5
1.5	TYPES	OF	NC	SYSTE	MS	(MOTION	CONTROL
SYSTE	MS):						5
	1.5.1	Point-t	o-Poin	t NC			6
	1.5.2	Straigh	t Cut]	NC			7
	1.5.3	Contou	ring N	IC			7

vi

2

3

INTRODUCTION TO CNC Computer Numeric Control (CNC) 2.1 2.1.1 Basic Working Principle The CNC Process 2.2 2.2.1 Motion Control in CNC:

	2.2.1	Motion control in circo.			
	2.2.2	Flow of Computer-Aided CNC Processing:	10		
2.3	Advanta	ages of CNC over NC:	10		
	2.3.1	Disadvantages of CNC	12		
2.4	Loop Sy	stems for Controlling Tool Movement	12		
	2.4.1	Open Loop System	12		
	2.4.2	Closed Loop System	12		
2.5	Specifications of CNC Controllers				
2.6	Functions of CNC controls in machine tool:				
2.7	Axis and Motion Nomenclature				
	2.7.1	Cartesian coordinate system	15		
2.8	Machin	e axis designation:	16		
2.9	Dimens	ion systems	18		
	2.9.1	Incremental Systems:	18		
	2.9.2	Absolute System:	18		

DESIGN AND METHODOLOGY

DESIG	N AND I	METHODOLOGY	20
3.1	CNC LI	NEAR SLIDE AND ITS COMPONENTS	20
	3.1.1	Features of CNC linear slide:	20
	3.1.2	Flexible coupling	21
	3.1.3	Linear slide bearing:	23
	3.1.4	Lead screw engineering:	23
3.2	POWER	SCREWS	24
	3.2.1	Terminology of lead screw systems:	26
	3.2.2	Lead screws:	28
	3.2.3	CALCULATIONS OF LEAD SCREW SYSTEM	29
	3.2.4	Force calculations on lead screw	30
	3.2.5	Selecting and Sizing Screw Drive Systems	32

8

8

8

8

9

3.3	СОМР	ARISION BETWEEN STEPPER AND SER	vo	
мотс	ORS		35	
	3.3.1	WORKING PRINCIPLE OF STEPPER MOTOR	R:36	
	3.3.2	TYPES OF STEPPER MOTOR:	36	
3.4	TYPES	S OF WINDING AND LEAD-OUT:	41	
3.5	STEPP	PING MODES:	42	
	3.5.1	Wave drive:	43	
	3.5.2	Full Drive:	43	
	3.5.3	Half Drive:	43	
IMPL	MENTA	TION	44	
4.1	DRIVI	E TECHNOLOGY FOR MOTION CONTROL:	44	
4.2	CONN	IECTIONS	50	
	4.2.1	RKD514L-A (DRIVE FOR Y-AXIS MOTOR)	52	
4.3	MOTO	DRS CONNECTION	53	
4.4	PREC	AUTIONS FOR INSTALLATION.	55	
4.5	CADM	10DEL CAD	55	
4.6	INTRO	DDUCTION OF PARALLEL PORT	56	
	4.6.1	Parallel Port Modes:	56	
	4.6.2	Hardware:	57	
	4.6.3	Parallel Port Registers:	58	
	4.6.4	Parallel Port Interfacing of Machine Using M	ach3:	
		58		
4.7	INTRO	DDUTION TO MACH3	59	
	4.7.1	Main Display	59	
	4.7.2	Data Entry to DRO	60	
	4.7.3	Tool path Display	61	
	4.7.4	Other Screen Features	61	
	4.7.5	Mach3Characteristics	61	
4.8	PROG	RAMER HEADER:	64	
4.9	PREPARATORY COMMANDS: 65			
4.10	GEOMETRIC CODES 6:			
4.11	MISC	ELLANEOUS FUNCTION	67	
			viii	

4

4.12	DESCR	IPTION AND PURPOSE	67
4.13	MACHI	INE RELATED FUNTION	67
4.14	PROGR	AM RELATED FUNTION	68
RESUL		D DISCUSSIONS	70
5.1		LOOP POSITIONING SYSTEMS	70
	5.1.1	Open Loop Systems	70
	5.1.2	Calculations of an Open Loop System	n 71
5.2	PRECIS	SION IN NC POSITIONIONG	(OPEN-LOOP
CONTR	ROLSYS	STEM)	75
	5.2.1	Control Resolution	75
5.3	Control	Resolution	76
5.4	Accurac	ey:	78
5.5	Repeata	bility:	78
CONC	LUSION	AND RECOMMENDATIONS	79
6.1	Frame		80
6.2	LINEAL	R MOTION EQUIPMENT	80
	6.2.1	X-Axis Movement	80
	6.2.2	Y-Axis Movement	80
6.3	MOTOR	RS	81
	6.3.1	X-Axis	81
	6.3.2	Y-Axis	81
	6.3.3	Z-Axis	81
6.4	CONTR	ROL BOX	81
	6.4.1	X-Axis	81
	6.4.2	Y-Axis	81
6.5	COMPL	JTER SYSTEM	81
6.6	CONCL	USION	82

REFERENCES

5

6

83