

Flashcut / Sherline CNC Mill

Haley Holcomb 8/26/22

Flashcut / Sherline CNC Mill	
	
Tool Type: "CNC"	
Location: "mFL 3430"	
Supervisor	Tool Lead
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Description: "CNC Diamond Drill"	
Manufacturer: "Sherline"	

About

CNC diamond drill used to drill holes in glass slides. Uses FlashCut CNC software to interpret G-code and drill holes in programmed locations.

Detailed Specifications

Insert Text Here!

Safety Concerns

Insert Text Here!

Sample G-code

(Sample program to drill six holes on the Microfluidics Lab Drill)

(Dave Bothman, 2 July 2012)

(Change x,y coordinates of G73 commands for your hole coordinates)

(Setup blocks)

G21 (select mm units)

G49 G80 G90 (cancel offsets, cancel cycles, absolute coordinates)

G98 (Move the drill away from the part when drilling is finished)

G00 X0 Y0 Z5 (move to the lower left corner of slide, 5mm above)

(Hole drilling blocks)

G73 X22.5 Y12.5 Z-1.2 Q.1 R0.5 F5

G73 X29.5 Y4.5 Z-1.2 Q.1 R0.5 F5

G73 X45.5 Y4.5 Z-1.2 Q.1 R0.5 F5

G73 X52.5 Y12.5 Z-1.2 Q.1 R0.5 F5

G73 X45.5 Y20.5 Z-1.2 Q.1 R0.5 F5

G73 X29.5 Y20.5 Z-1.2 Q.1 R0.5 F5

(Closing block)

M30

Reference Documentation

[Drill Bits Information](#)

[FlashCut CNC 4.0 Tutorial](#)

[FlashCut CNC 4.5 Tutorial](#)

[CNC Drill Users Manual](#)

[Sample G-Code](#)

Training Documentation

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