Using Delcam Powermill with the Rotary Table

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DM Lab Tutorial

The rotary table allows you to mill larger objects. Please note: you need to review the other two powermill tutorial BEFORE attempting to create a tool path utilizing the rotary table.

1. Place the model below the XY Ground Plane
2. Place the vertical center of the model on the Z Axis.

This coordinates the origin of the model with the base point created in Powermill.

Export your model and import it into Powermill.
Setup your model in powermill.

Import the model, create block and lock it to the size.

Refer to the basic Powermill tutorial for instructions on how to do this.

Note:

The turntable has a safe work plane above the turntable set to 20" above the floor. When you clamp your piece to the turntable the min height from the floor you can mill is 20", so you will need to allow extra material.

Setting up a work plane for the robot to position correctly on the turntable.

Create a new work plane, so that it is oriented to the side of the piece you need to cut.

Rotate the X axis in the positive 90 degree direction.
Rotate the Z axis in the negative 90 degree direction.

Move your work plane away from the center of the block so it is outside of the block. It is this location that the mill will make a rapid move to first before the mill start to cut the piece.

Click on tool path strategies
Click on Finishing
Choose: Rotary Finishing
Give a finish Name
Click on “Reset to Block Limits”
Choose Spiral finish
Direction: Choose method, see other tutorial for explanations.
Y offset: Set to 0.0
Choose you desired step over in MM, see other tutorial for explanation.
Set your Leads and Links, see other tutorial for explanation.
Click Apply to calculate tool path.

Generated Tool path
1. Verify that External Rotary Table is set to E-1 and Rotary Table Top.
2. Choose Millimeters/Minute.
3. Choose Segment to break up the Tap File.

Load files into the robot.

Set your basepoint to the top center of your stock piece and enjoy!