

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.

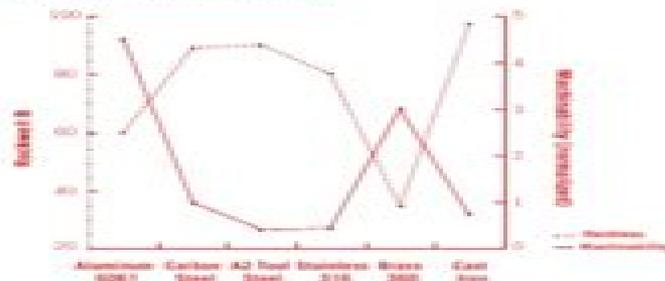
Stainless 316

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
M98		Call sub

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

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G Thomas



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