

**TUTORIAL  
WATERJET 5 AXIS  
CUT**

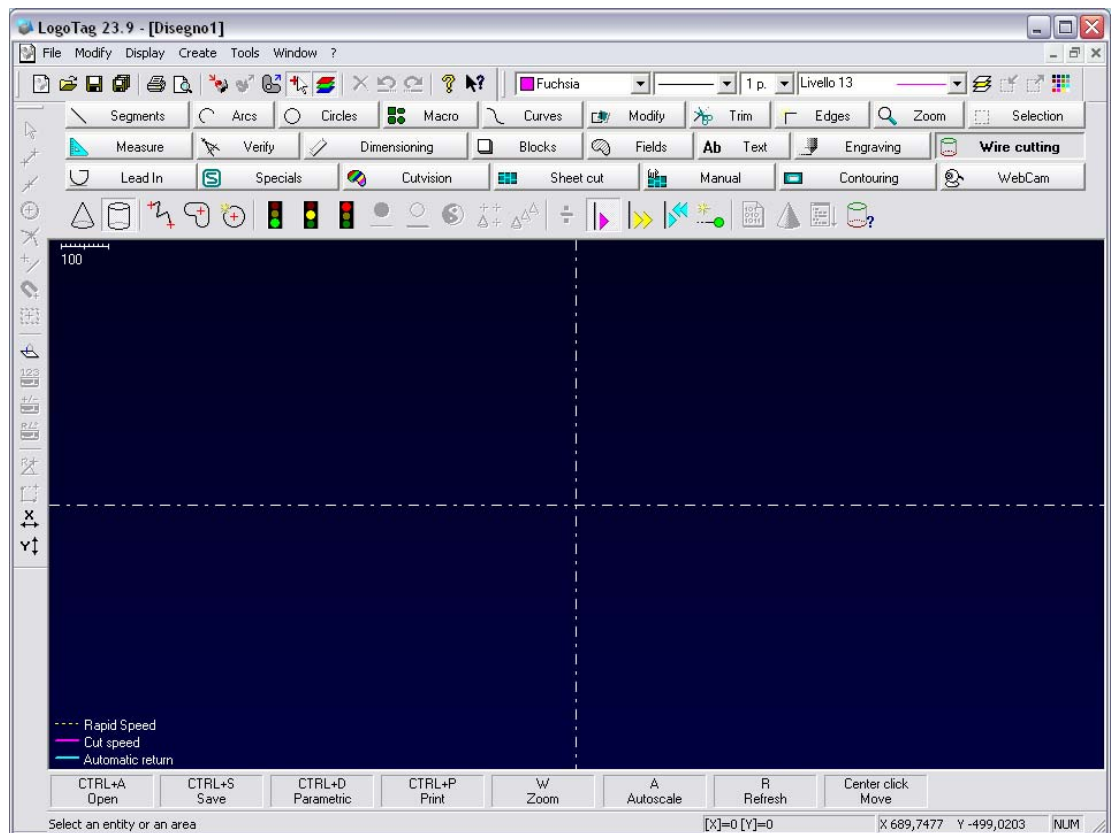
**VER. 23.X**

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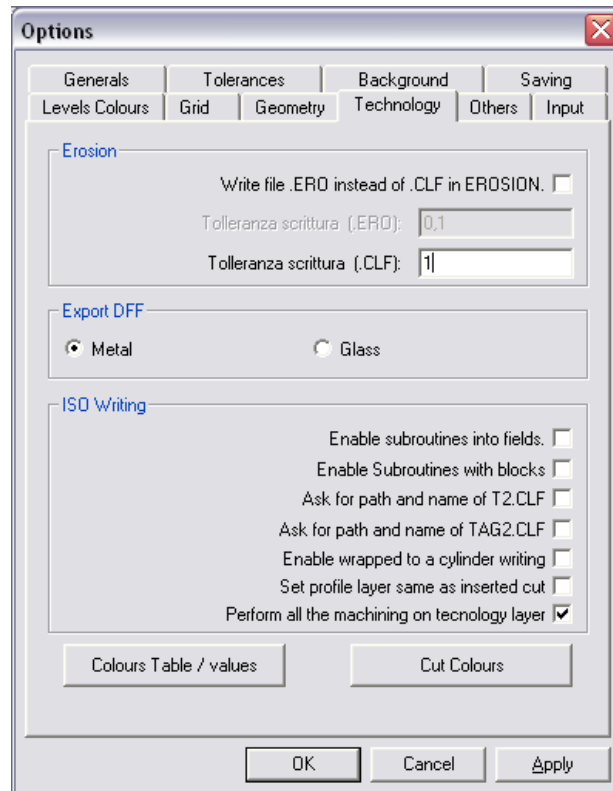
## 1. STARTING SET


Select Wire Cutting Bar  **Wire cutting**

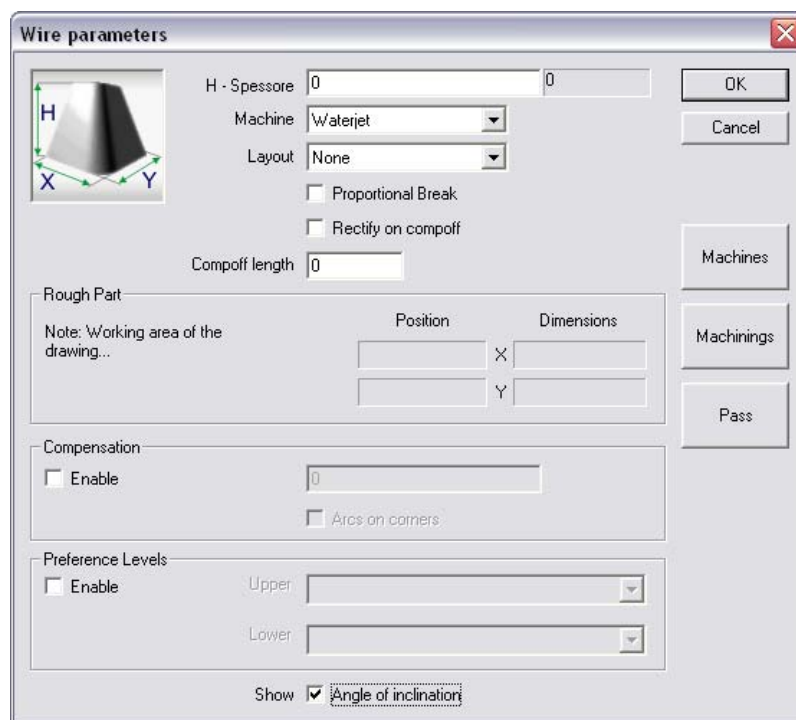


When you install you must set this parameter:

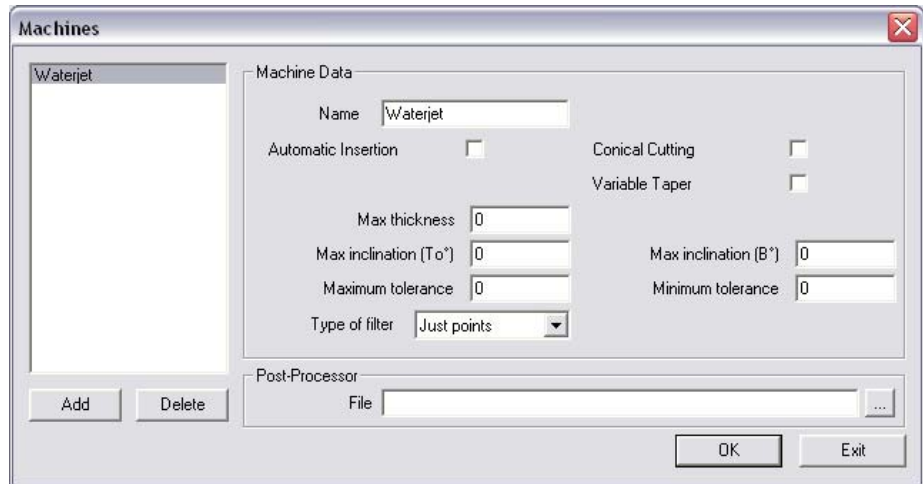
1. Go on Tools->Options, select Technology and write 1 on Writing CLF Tolerance and press OK



2. Go On Wire cutting toolbar, select Wire Parameter 

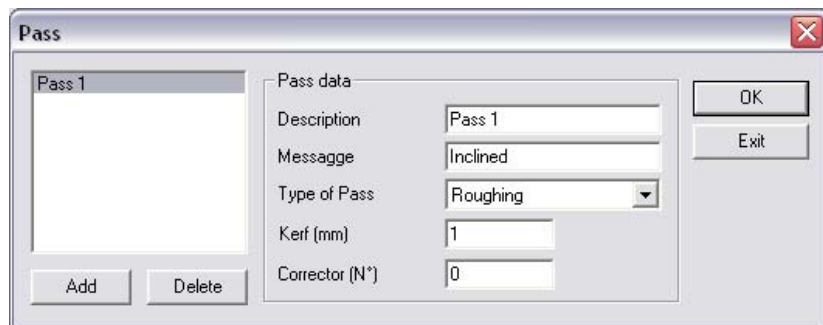


a. Press on MACHINES.



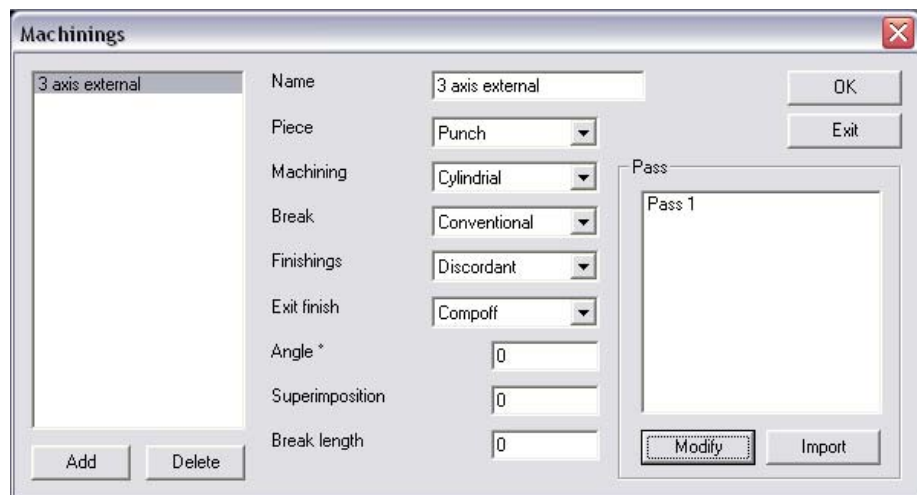
If you don't have any machine Add a new one. Check "Automatic Insertion", "Conical Cutting", "Variable Taper". Then the "Max Thickness" (Spessore Max), the Max Inclination A° the Max Inclination B° (both 45), the maximum tolerance (tolleranza massima) and the minimum tolerance (tolleranza minima) both at 0.001 and on Type of filter select Just Points. Select the right Postprocessor. At the end press on Ok

b. Press on PASS.



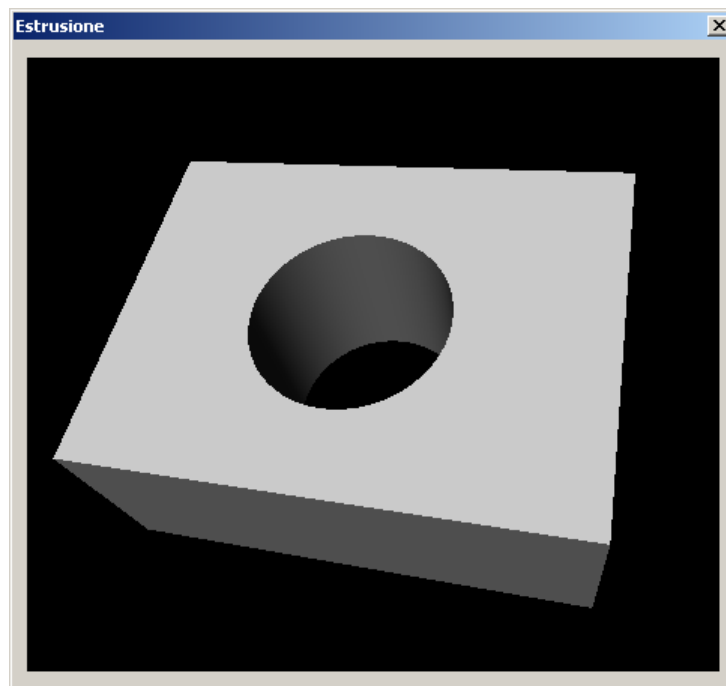
If you don't have press on add and it's important that on Type of Pass you select Roughing and that you write the right Kerf value (Radius of the tool)

c. Press on MACHINING.

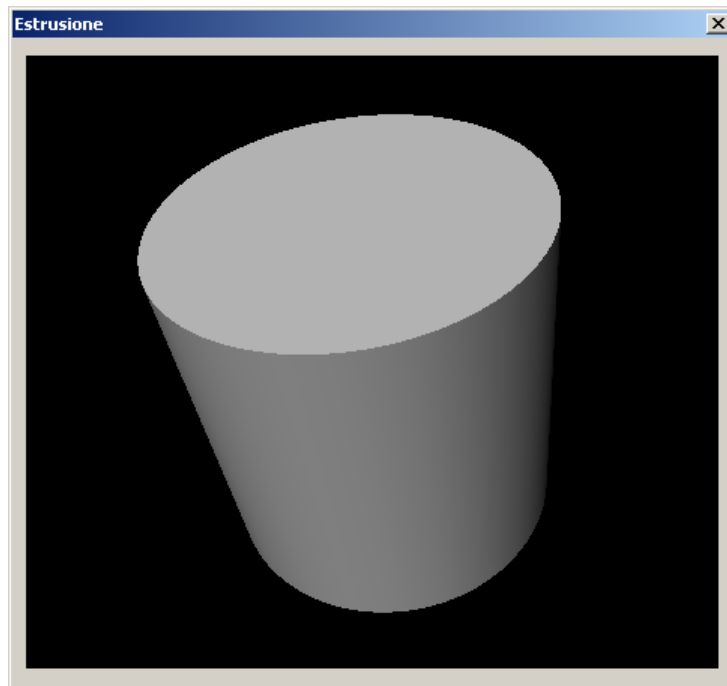


Press on Add, Press on import and select the pass you create before and the ok. Now write the name (for instance 3axis external) then on piece select matrix for internal profile or punch (punzone) for external profile and on machining select cylindrical for 3 axes cut and Variable taper for 5 axis cut. Repeat the same sequence for 3axis internal, 5 axis external, 5 axis internal and then press ok

MATRIX Example:



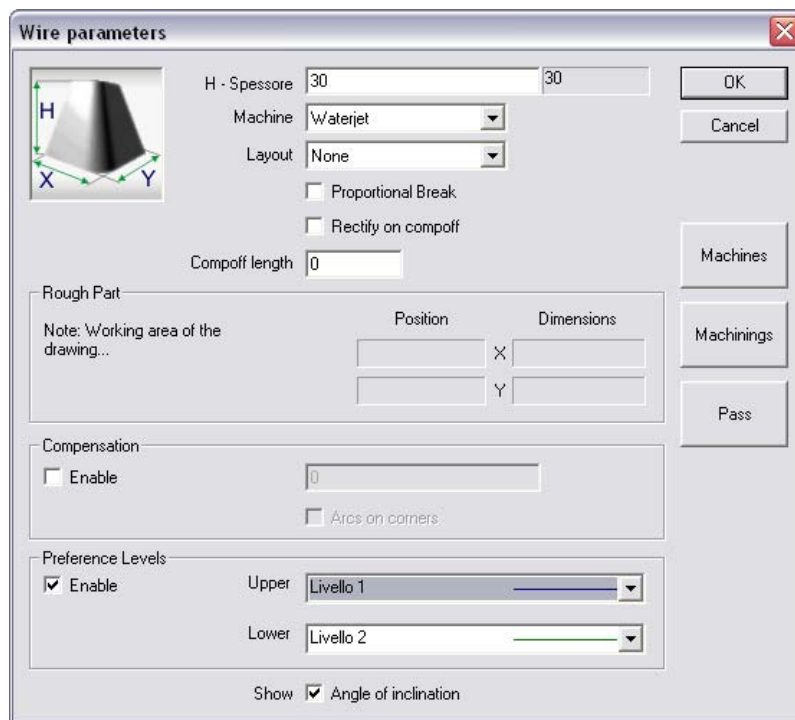
PUNCH example:



## 2. HOW TO WORK

1. Draw what you want to cut. If you want to cut in 5 axis you must draw the upper profile and the lower profile. It's better you draw the two profile on different layer

2. Press on WIRE PARAMETERS  :





Write the thickness, enable preference levels and select the level for the upper profile and for the lower profile

3. Select RAPID  , GO  , CYLINDRICAL CUTTING  and click on the piercing point

4. Now you have two ways:



### a. 3 Axis cut

I. Select WORK  , GO  , CYLINDRICAL CUTTING  and press the first point of the profile you want to cut.

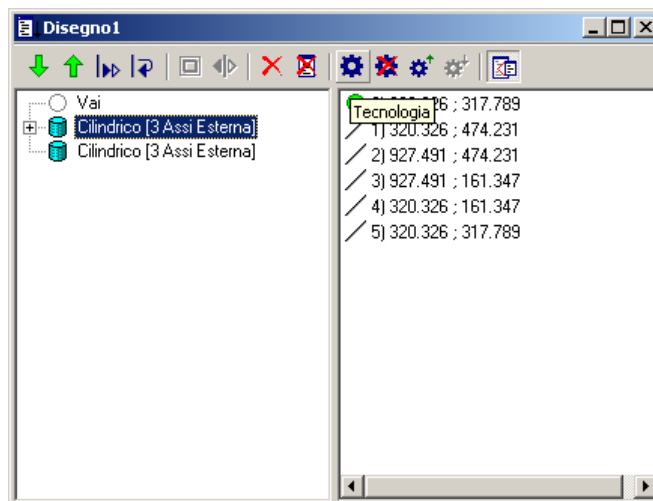
II. Select PROFILE , CYLINDRICAL CUTTING  and press on the first element and then on the last element of the profile you want to cut

## b. 5 Axis cut

I. Select WORK , GO , CONICAL CUTTING  e selezionate il primo punto del profilo superiore ed il primo punto del profilo inferiore che volete tagliare.

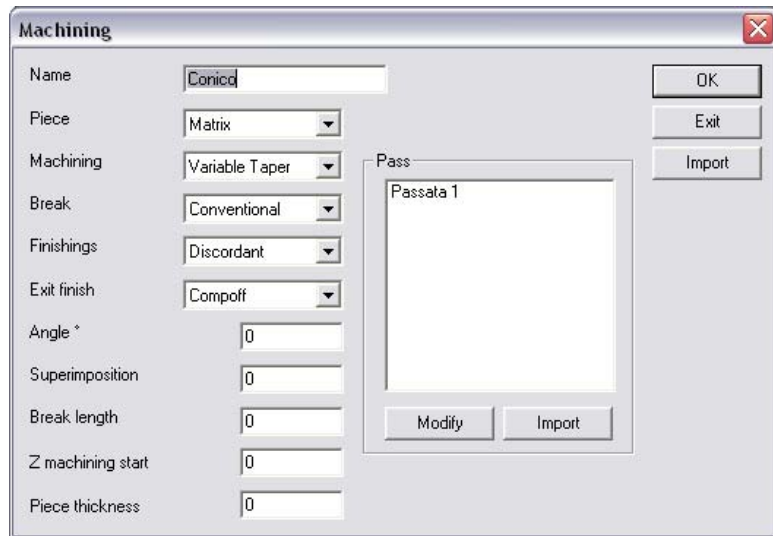
II. Select PROFILE  e CONICAL CUTTING  e cliccate sul primo elemento e poi sull' ultimo elemento del profilo superiore e sul primo elemento e poi sull' ultimo elemento del profilo inferiore che volete tagliare.

5. Click on DISPLAY SEQUENCE 



6. Select the first technology you have on the list (cylindrical or conical)

7. Press TECHNOLOGY BUTTON 



8. Press on import button you have on the upper right part of the windows and select the right technology

9. Press on GENERATION FILE POST PROCESSOR

