



p 1

The milling on the CNC-training machine FBZ 40-30



Due to their construction, the following points need to be paid attention to when machining the digital wood joints on a CNC-training machine FBZ 40-30 of the MBA GmbH (formerly Bosch GmbH):

1. The digital wood joints are designed so that they can be processed with an 8mm router bit. Due to the cutter line compensation in the FBZ CAD/CAM 2D software, it is necessary to choose a smaller router for some wood joints. Hard-tipped router bits with a positive spiral should be used. They allow for optimal chip ejection and guarantee a good cutting quality as well as little wear and tear.



p 2

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2. If the cutting depth is too deep when machining solid wood, the Z-axis of the FBZ 40/30 will be pushed away from the edge of the material. It should therefore be processed with a cutting depth of 1mm per machining cycle. This has already been taken into account in the CAD-files and SIM-files.
3. Depending on the kind of wood, the feed can be fixed between 600 and 800 mm/min.
4. The workpieces that are going to be processed are positioned and held down by means of a wooden template or a clamping device. To avoid a splintering of the material, it should be clamped together with appropriate cauls.
5. Please look up the dimensions of the stock part, as well as the diameter of the router bit, in the SIM-file header of the corresponding digital wood joint.

