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SRP Player CAM Software



Installing SRP Player Software





NOTES:

•Place SRP Player CD into computer and an install window will open.

•Click on "Install" to begin software installation.



Installing SRP Player Software



NOTES:

No

~

Cancel

- Install Shield Wizard will start up, click on "Next".
- Read software license agreement and click on "Yes"
- •Click "Next" to accept default destination folder. (Recommended)
- •Click "Next" to accept default program folder name and continue software installation. (Recommended)



Installing SRP Player Software





- •Click on "Finish" to complete software installation.
- •Go to Windows Start Menu and click on SRP Player, right click over SRP Player, select "Send To" then "Desktop (create shortcut)"
- •This will create a shortcut on your desktop.





Installing SRP Player Software



Initialization	 This wizard helps you make the settings for the following items. Alake the settings for the connected cutting machine and installed options. Make the setting for the measurement unit used for lengths. Register the tool you're using in My Tools. Is the driver for the cutting machine installed? In chick [Cancel] to exit the wizard, then install the driver. 	
	To continue, click [Next].	
	< Back Next > Cance	əl

NOTES:

•Click on SRP Player shortcut to launch software.

•When you start the software for the first time or update the software, the initialization screen will appear. Click on "Next" to begin initialization.

•Software will look for installed machine.

•Select your machine.

Cancel

Initialization	Initialization
Seeking Please wait.	The following cutting machines are connected to the
Now searching for the cutting machine connected to the computer and any optional items installed.	Choose one of the connected cutting machines Choose a supported cutting machine not on the list MODELA MDX-650(RML-1) (Roland MODELA MDX-650(RML-1) MODELA MDX-15 (Roland MODELA MDX-15) If not on the list, do one of the following. I. Switch on the power to the cutting machine and click (Re-seek). Choose a supported cutting machine not on the list), then select the cutting machine.
< <u>Back</u> <u>N</u> ext > Cancel	< Back Net



Installing SRP Player Software

Initialization			\mathbf{X}
Cutting-machine Settings			
Model Name: MODELA	MDX-650(RML-1) (Roland MO	DELA MDX-650(RML-1))	
Spindle Unit:	ZS-650T/A	•	
<u>T</u> able:	Standard	∨	
Rotary Axis Unit:	ZCL-650(A)	~	
ATC (Auto Tool Chang	ger): ZAT-650	~	
No. of Ste	ocks: 4 🗸		
Printer Name: Rola	nd MODELA MDX-650(RML-1)		
	(< Back Cancel	



		1 11	
	DELA MDX-650(RM	L-1))	
1	IDX-650(RML-1)	IDX-650(RML-1)	IDX-650(RIML-1)



- •Verify machine and installed options then click "Next".
- •Software will indicate machine selected and options selected. Click "Next".
- •Select units desired. Click "Next"
- •Select tools in inventory then click "Next".
- •Click on "Finish" to complete the software initialization.

nitialization	×
This completes the Initialization	
The preference settings for the initial run are complete.	
	ack Finish cel



File - Preferences

OK Cancel Apply

Help

eral Cutting Machine Color Sch	eme	General Cutting Machine Color Scheme
it Imm inch inch inguage : inglish (United States)	Key Assignments +→ Botate: Shift+Ctrl +→ Move: Ctrl Q: Zoom: Shift	Machine Setup Model Name: MDX-540 Spindle Unit: Standard Table: Standard Rotary Axis Unit: ZCL-540 ATC: ZAT-540 No. of Stocks: 4
eferences General Cutting Machine Color Sc Wireframe: Shaging		No. of Stocks: 4 Printer Setup Printer Name: Roland MDX-540 Status: Power OFF Type: Roland MDX-540 Port: USB002
Modeling Eom: Support:	Background [Tgp]: Qamp: Background Background Bottom:	OK Cancel Apply Help

NOTES:

You can change your preferences, color scheme, verify machine and accessories by selecting File then Preferences.

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File	View	Options	Help
0	pen	С	trl+O
Si	ave	С	trl+S
Si	ave As.		
Pi	review	Cutting	
0	ut	С	trl+P
P	referen	ces	
R	ecent F	ile	
E	xit		



File – Preferences – Advanced Tab

Preferer	ices				
General	Cutting Machine	Color Scheme	Advanced		
	for ensuring Disable then characteristi understandir	ngs disable some of safe use of the cu n only after completics of the cutting n ng cutting machin between the spin	utting machin etely unders nachine. No e characteri dle and the	ne. tanding the cu t completely stics may cau rotary axis.	utting
	Disable <u>m</u> aterial siz	e restrictions on m	otary axis un	it	
	Disable <u>f</u> lute diame				
	Do not check <u>c</u> om		sories before	e cutting Apply	Help

NOTES:

•For software versions 1.15 and greater, there is an advanced tab that will allow you to disable certain safety features for advanced users.

- •Please be very familiar with the machine and any accessory before disabling these restrictions.
- •Failure to do so may cause a crash.



Options



ZHS (Square end mill(HSS)) ZUB (Ball end mill(Carbide)) ZUS (Square end mill(Carbide)) RDL (Square long end mill) RDB (Ball long neck) RPS (Square medium end mill) RHRS (Radius long neck) None/Ball (Ball) None/Square (Square) ZHB (Ball end mill(HSS)) ZCB (Ball end mill(Carbide)) OSG (Ball end mill(Carbide)) CPRB (Ball end mill(Carbide))



NOTES:

My Tool: Select what tools you have available

Add/Remove Tool: Add or remove additional tools than already installed.

Surfacing: Surfaces work material using available tools.





Main Screen



- •Start screen. Note you can't proceed until Step 1 is completed.
- •Red line demonstrates rotary axis rotation axis if available.



Step 1

Sample_1.spj - SRP Player	
Elle View Options Help	
	Model Size and Orientation Open model file, confirm size and orientation of model. Upen Enter/confirm size of model. Select top surface of model. Orient the model so that the first surface to cut is facing up. Choose orientation of model. This determines the direction of rotation for the model on the rotaty axis Choose orientation of model. This determines the direction of rotation for the model on the rotaty axis Choose orientation of model. This determines the direction of rotation for the model on the rotaty axis Choose orientation of model. This determines the direction of rotation for the model on the rotaty axis Choose orientation of model. This determines the direction of rotation for the model on the rotaty axis Choose orientation of model. This determines the direction of rotation for the model on the rotaty axis Choose orientation of model. This determines the direction of rotation for the model on the rotaty axis Choose orientation of model. This determines the direction of rotation for the model on the rotaty axis Choose orientation of model. This determines the direction of rotation for the model on the rotaty axis Choose orientation of model. This determines the direction of rotation for the model on the rotaty axis Choose orientation of model. This determines the direction of rotation for the model on the rotaty axis Choose orientation of model. This determines the direction of rotation for the model on the rotaty axis Choose orientation of model. This determines the direction of rotation for the model on the rotaty axis Choose orientation of model. This determines the direction of rotation for the model on the rotaty axis Choose orientation of model. This determines the direction of rotation for the model on the rotaty axis Choose orientation of model. This determines the direction of rotation for the model on the rotaty axis Choose orientation of model. This determines the direction of rotation for the model on the rotaty axis Choose orientation of model. This determines
Ready MDX-540, ATC present, Rotary Axis Unit present	49.92 x 55.00 x 18.33 [mm]

- •Import part by clicking on Open or dragging part onto screen.
- •Confirm size of part. •Modify if desired.
- •Check orientation of part.
- •Click on Step 2 when finished.



Step 2



- •You select what type of part you will be cutting by selecting the appropriate options.
- •Click on question mark for more information.
- •Click on Step 3 when finished.



Step 3



- •Select material from pull down list.
- •Enter material size.
 - •Must be greater than values in parenthesis.
- •Click Create Tool Path to process toolpath.
- •Click on Step 4 when finished.



Step 4



- •You can view what the sample part will look like with selected tooling by clicking on Preview Cutting.
- •You can view an estimated cutting time.
- •Click on Step 5 when finished.



Step 5



NOTES:

Click on Start Cutting to starting the cutting process.



Back to Step 3



NOTES:

If you would like to make changes to your program, click on Step 3.





Step 3 Modifications





- •Select Roughing process
- •Select Top Surface and click on + to view options.
- •You can rename the process
- •You can change its orientation and angle if available.
- •Click on Apply when finished.



Step 3 Modifications



- •Under Modeling Form, you can change the margins of the part.
- •Click on Add a margin
- •Click on Automatically
- •You only need to add a margin above and below the part.
- •You don't want to add a margin to the left or right.
- •Once finished click Apply.



Step 3 Modifications



NOTES:

•Completed margin modifications.



Step 3 Modifications



- •You can modify the Cutting Area if desired by selecting Partial.
- •You can enter values to specify the cutting area or drag the red box to the desired area.
- •Click on Apply when finished.



Step 3 Modifications



- •The cutting depth can be modified by selecting Partial.
- Enter a value or drag the red line to the desired depth.
- •Click on Apply when finished.



Step 3 Modifications

Model Size an		on
Zype of Milling		
👏 Create Tool Pa		1 1 1
	ъ <mark>×</mark>	
	al (Depth) our Lines ng Parame ing	
Tool to use for t		s
Tool to use for t		• •
Tool to use for t 1/8" Ball Tool Type: Material:	his proces Ball	s d carbide
Tool to use for t 1/8" Ball Tool Type: Material: Flute Diameter [d]:	his proces Ball	 Image: A state of the state of
Tool to use for t 1/8" Ball Tool Type: Material: Flute Diameter [d]: Flute Length [l]:	Ball Cemente 0.1252 0.3732	✓ d carbide
Tool to use for t 1/8" Ball Tool Type: Material: Flute Diameter [d]: Flute Length []: Corner Radius []:	Ball Cemente	d carbide
Tool to use for t 1/8" Ball Tool Type: Material: Flute Diameter [d]: Flute Length []]: Corner Radius [r]: Blade Width Wit:	Ball Cemente 0.1252 0.3732 0.0000	d carbide inch
Tool to use for t 1/8" Ball Tool Type: Material: Flute Diameter [d]: Flute Length [I]: Corner Radius [r]: Blade Width	Ball Cemente 0.1252 0.3732	d carbide inch inch inch
Tool to use for t 1/8" Ball Tool Type: Material: Flute Diameter [d]: Flute Length []: Corner Radius [r]: Blade Width [Wi: Blade Angle	Ball Cemente 0.1252 0.3732 0.0000 0.0000	d carbide inch inch inch inch deg
Tool to use for t 1/8" Ball Tool Type: Material: Flute Diameter [d]: Flute Length [l]: Corner Radius [f]: Blade Wridth [w]: Blade Angle [a]:	Ball Cemente 0.1252 0.3732 0.0000 0.000 0.00	d carbide inch inch inch inch
Tool to use for t 1/8" Ball Tool Type: Material: Flute Diameter [d]: Flute Length []: Corner Radius [r]: Blade Width [Wi: Blade Angle	Ball Cemente 0.1252 0.3732 0.0000 0.000 0.00	d carbide inch inch inch inch deg
Tool to use for t 1/8" Ball Tool Type: Material: Flute Diameter [d]: Flute Length [l]: Corner Radius [f]: Blade Wridth [w]: Blade Angle [a]:	Ball Cemente 0.1252 0.3732 0.0000 0.0000 0.000 0.000 0.000 0.000 0.000	d carbide inch inch inch inch deg
Tool to use for t 1/8" Ball Tool Type: Material: Flute Diameter [d]: Flute Length []: Corner Radius [[]: Blade Writh [w]: Blade Angle [a]: Preview Resul	Ball Cemente 0.1252 0.3732 0.0000 0.0000 0.0000 0.0000 0.0000 0.0000 0.0000 0.0000 0.0000 0.0000 0.0000 0.0000 0.0000 0.0000 0.0000 0.0000 0.000000	d carbide inch inch inch deg

	×
	_
Model Size and Orientation	
Z Type of Milling	_
A Roughing Top Surface All (Cut Area) Partial (Depth) Bal Contour Lines Cuting Parameters Z Finishing Z Roughing1	
Contour Lines Up Cut 💌	
Apply Close	
Preview Results	1
Perform Cutting	j
1.3406 x 1.6250 x 0.5430 [inch]	

Model Size and Orientation	Model Size and Orientation Type of Milling Create Tool Path Create Tool Path
Scan Lines Unidirectional Cutting Start Position Construct Position Construct Position Close	Eeed Rate: 1144.00 mm/min Spindle: 10000 rpm Cutting-in 0.0039 inch Bath Interval: 0.0039 inch Finish Margin: 0.0000 inch
Preview Results Perform Cutting	Preview Results Perform Cutting
1.3406 x 1.6250 x 0.5430 [inch]	1.3406 x 1.6250 x 0.5430 [inch]

NOTES:

- •You can select available Tool.
- •You can modify available process to desired process if available.
- •You can modify recommended feed rates if desired.
- •Click on Apply when finished.
- •Click on Close when all modifications have been completed.



Step 3 Modifications



- •Cutting parameters can be changed if desired.
- •Click on Apply and Close when finished.
- •Feed Rate is the speed the tool is moving.
- •Spindle speed is how fast the tool is spinning.
- •Cutting in amount is the depth of cut for that tool.
- •The Path interval is the distance between tool passes. Finishing passes are usually much smaller than roughing passes.



Step 3 Modifications



•Finish margin is the amount of material left on the model after that process has finished





Step 3 Advanced Modifications





- •Let's make some advanced modifications.
- •The part in questions has some holes that can't be milled from the top or the bottom.



- •We can turn the part at angle to mill the holes.
- •We simply add a new process, usually finishing.
- •Change the angle to 45 degrees and click apply to change the part.



Step 3 Advanced Modifications





Wireframe View

		Model Size and Orientation
		Type of Milling Create Tool Path
		Li Duting Parameters ○ All ○ Partial Z Range
		Start Height: 19.30 mm End Height: 4.44 mm
Y	IM	Apply Close

NOTES:

•As we only want to cut the holes, lets change the cutting area to cut only the holes.

- •Click on Partial and simply drag the box to an area outside the tools.
- •Click Apply when finished.
- •For the depth, click on the start cutting line and bring it so that it is right below the depth of the hole.
- •Bring the stop cutting line just below the holes so that the tool doesn't waste time cutting too deep.
- •You may want to change the view to Wireframe view to view the holes better.
- •Click Apply when finished.



Step 3 Advanced Modifications



NOTES:

To cut the other side, add another new finishing process.Change the angle to 315 degrees and click Apply.



Step 3 Advanced Modifications





Wireframe View

	Model Size and Orientation Type of Miling Create Tool Path Create Tool Path Crea
MDX-540, ATC present, Rotary Axis Unit present	49.92 x 55.00 x 18.33 [mm]

NOTES:

•Again, as we only want to cut the holes, lets change the cutting area to cut only the holes.

- •Click on Partial and simply drag the box to an area outside the tools.
- •Click Apply when finished.
- •For the depth, click on the start cutting line and bring it so that it is right below the depth of the hole.
- •Bring the stop cutting line just below the holes so that the tool doesn't waste time cutting too deep.
- •You may want to change the view to Wireframe view to view the holes better.
- •Click Apply when finished.
- •Click Close when finished editing.



Step 3 Advanced Modifications

Sample_1.spj - SRP Player	
Elle View Options Help	
	Model Size and Orientation Type of Milling Create Tool Path
	Choose workpiece material.
Processing Creating the tool path 33%	Prepare workpiece and enter its size. X: 140.00 mm (139.43-) Y: 75.00 mm (55.00-) Z: 20.00 mm (18.33-)
5%	Create tool path. Tool path generation may take a few minutes. Create Tool Path Edit
Z x	Mills Uncreased Experience remaining
× ¥	Preview Results Perform Cutting
Ready MDX-540, ATC present, Rotary Axis Unit present	49.92 x 55.00 x 18.33 [mm]

- •Click on Create Tool Path to generate the tool path.
- •Click on Step 4 when finished.



Step 4



- •You can view what the sample part will look like with selected tooling by clicking on Preview Cutting.
- •You can view an estimated cutting time.
- •Click on Step 5 when finished.



Step 5



NOTES:

•If you have an Automatic Tool Changer, you can Edit Magazine to specify tool location.

dit magazir	ne			1
Stock No.	Tool Name		Туре	D
1				
2	R1.5 Ball		Ball	3.00
3				
4				
		ОК		Cancel

•Click on Start Cutting to starting the cutting process.