

3D PRINTING

SIEMENS NX

STL- FILES

MAGNETS (Ø4MM X 2MM)

FILAMENT

3D- PRINTER (OR 3D-HUB)

INJECTION MOLDING

STEP-Files of the two cavities or fusion 360 – files (containing the milling simulation)

2 pieces of aluminium

Granulates (PP)

Duc tape (closing the mold)

Some small pieces of wood

Injection molding machine (we used the TRAVIN MINI MOULDER TP1)

CNC- machine (we used the OPTIMILL F4)

Milling heads

Part 1:

1. Face Mill Ø50mm
2. Flat End Mill Ø6mm (ALU-6-HSS)
3. Flat End Mill Ø20mm (ALU-20-HSS)
4. Ball End Mill Ø4mm (ALU-4-MG)
5. Dril Ø4mm (ALU-4)
6. Countersink Ø12.4mm 90°

Part 2:

1. Face Mill Ø50mm
2. Flat End Mill Ø20mm (ALU-20-HSS)
3. Flat End Mill Ø6mm (ALU-6-MG)
4. Ball End Mill Ø4mm (ALU-4-MG)
5. Flat End Mill Ø4mm (ST-4-3L)

Part 3:

1. Face Mill Ø50mm
2. Flat End Mill Ø6mm (ALU-6-HSS)
3. Ball End Mill Ø6mm (ALU-6-MG)