



Basic CNC List
Petteri Heiskari
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ARCHILOGS BASIC CNC LIST

This document contains list of CNC-codes that fixed price CNC-code production includes. Additional codes can tailored.

File header

File header may contain any fixed information and in addition these variables:

- Log type
- Log size (width and height)
- Text from ArchiCAD project info or from LogProject object:

NUMBER		12345
CUSTOMER	Customer name	
MATERIAL		4
WIDTH		150
HEIGHT		200
WALL		AA

Example definition:

MATERIAL [Material from LogProject object]
CUSTOMER [Customer name]
WIDTH [Log width]
HEIGHT [Log height]
[Empty line]

Wall header

Before every wall it is possible to write a wall header. It may contain any fixed information and wall ID. For example:

! *** NEW WALL *** (Fixed text)
WALL [Wall ID]

Log header and footer

At the beginning of the log there is usually a header line for single log. It may contain this information:

- Log ID
- Log length
- Log batch number
- Log quality class/usage parameter
- Any log object parameter including examples above
- Consecutive number

For example at beginning of a log:

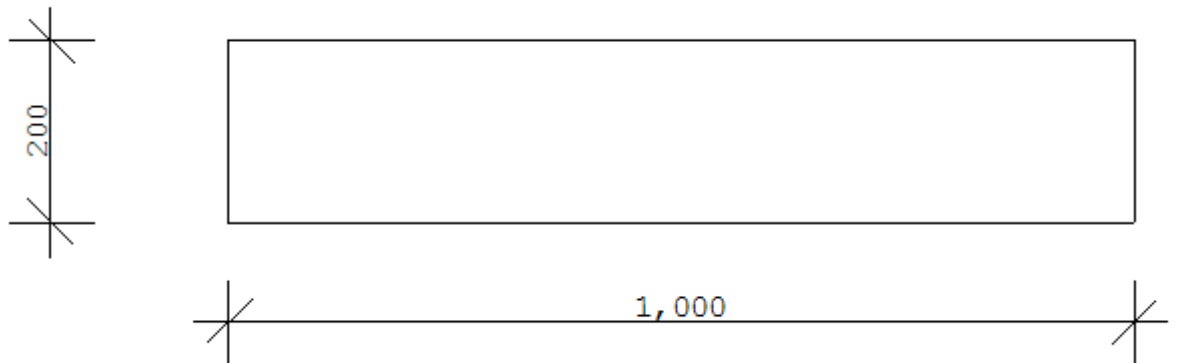
LOG [Log ID] [Length] [Batch number]

And at the end of a log:
[Empty line]

Log ending types

List CNC for example log that is 100 mm thick, 200 mm high and 1000 mm long for all cases.

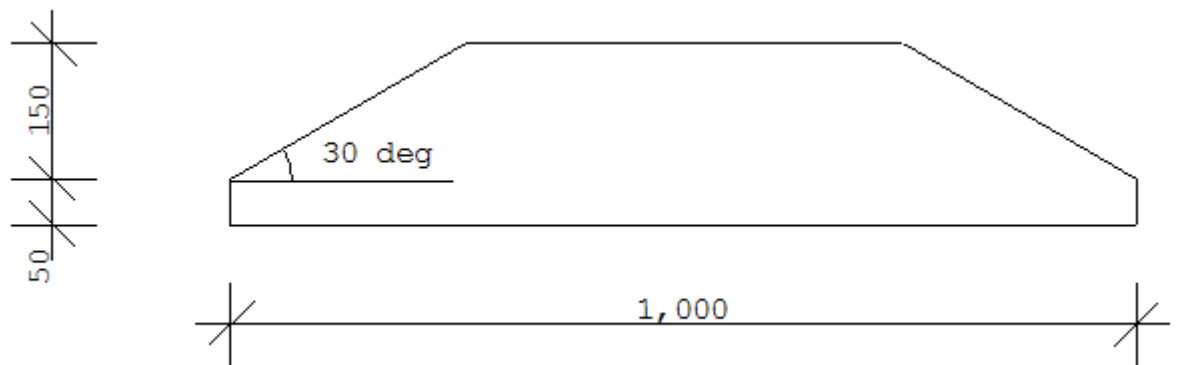
Straight ending



Beginning (example MACHINING 0,CUT):

End (example MACHINING 1000,CUT)::

Angled ending 1



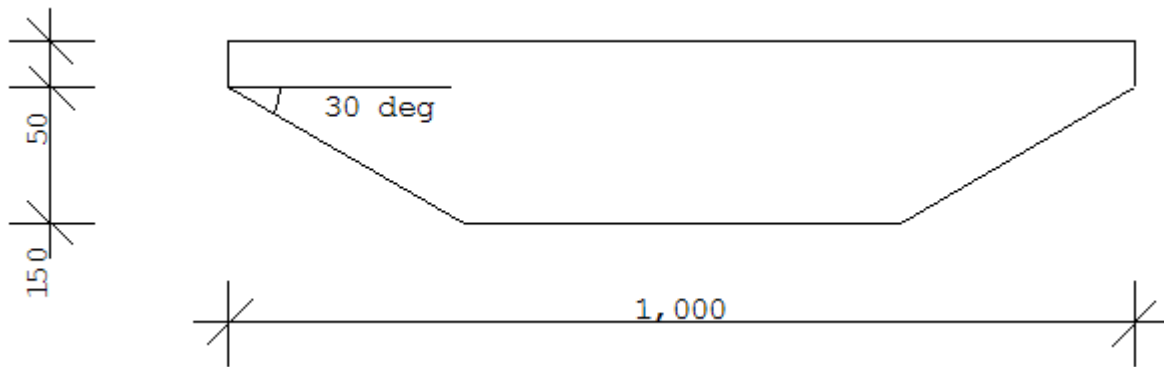
Beginning (example MACHINING 0,50,30,ANGLEDLEG):

End (example MACHINING 1000,50,30,ANGLEDEND):

Angled ending 2

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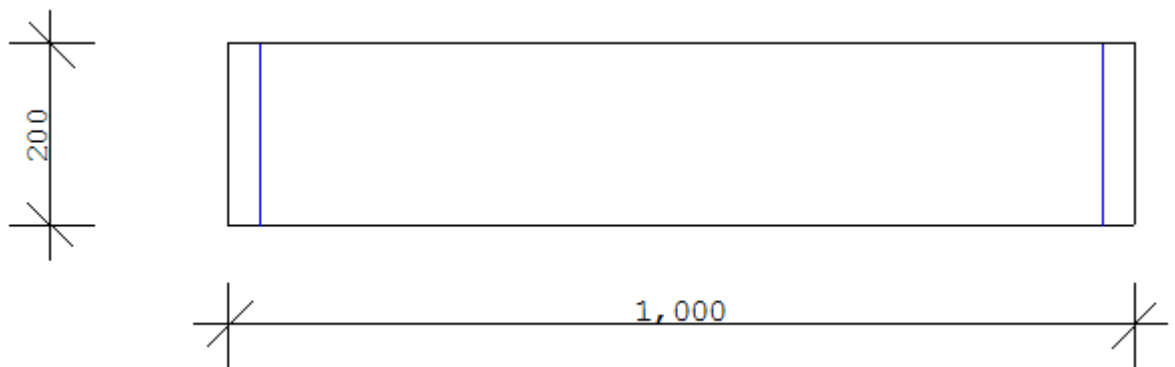
Mannerheimintie 15aB
00260 Helsinki
puh. 020 7419700
fax (09) 4555091
<http://www.mad.fi>



Beginning (example MACHINING 0,150,-30,ANGLEDSEG):

End (example MACHINING 1000,150,-30,ANGLEDEND):

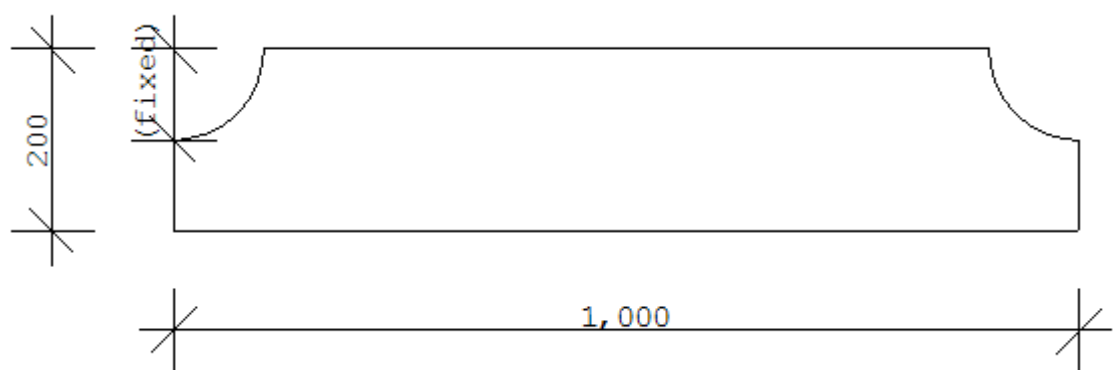
Window tongue



Beginning (example MACHINING 0,10,WINGROOVE):

End (example MACHINING 1000,20,WINGROOVE):

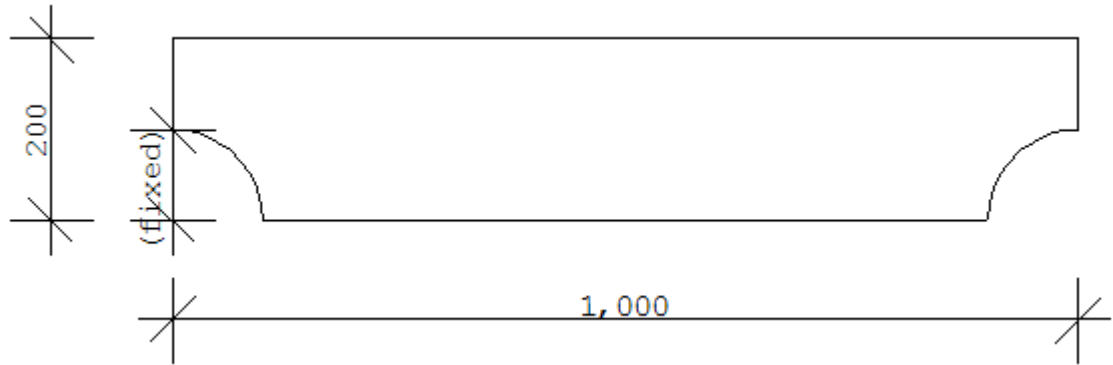
Round log decoration 1



Beginning (example MACHINING 0,10,ROUNDTOP):

End (example MACHINING 1000,20,ROUNDTOP):

Round log decoration 2



Beginning (example MACHINING 0,10,ROUNDBOT):

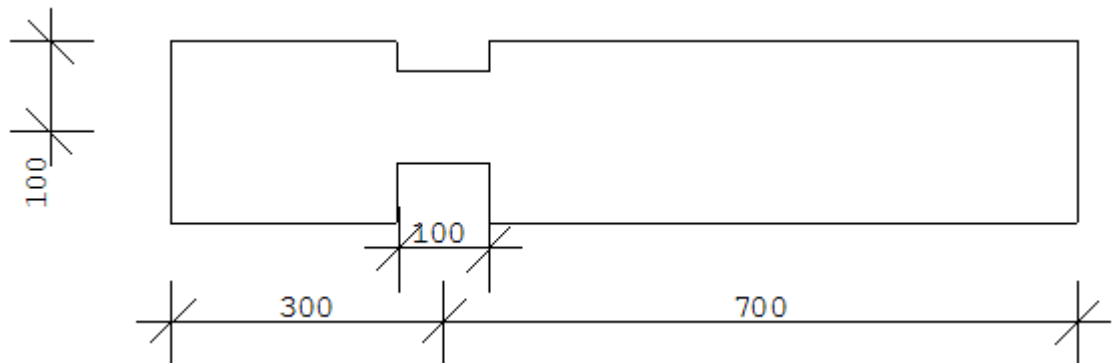
End (example MACHINING 1000,20,ROUNDBOT):

Log halving

Upper half (example MACHINING 0,UPPER):

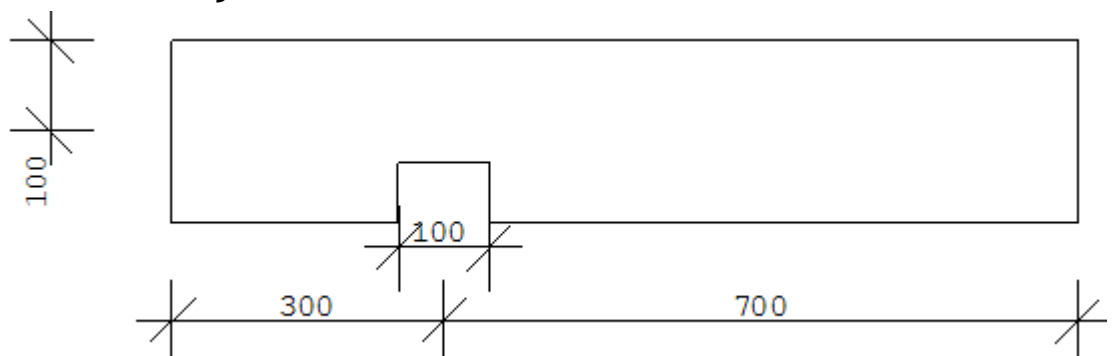
Lower half (example MACHINING 0,LOWER):

Normal full joint



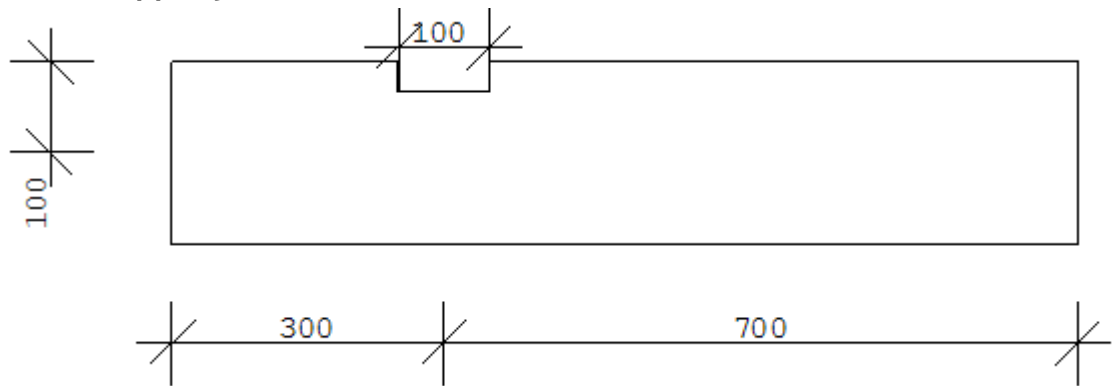
For example MACHINING 300,100,[angle],JOINT

Normal lower joint



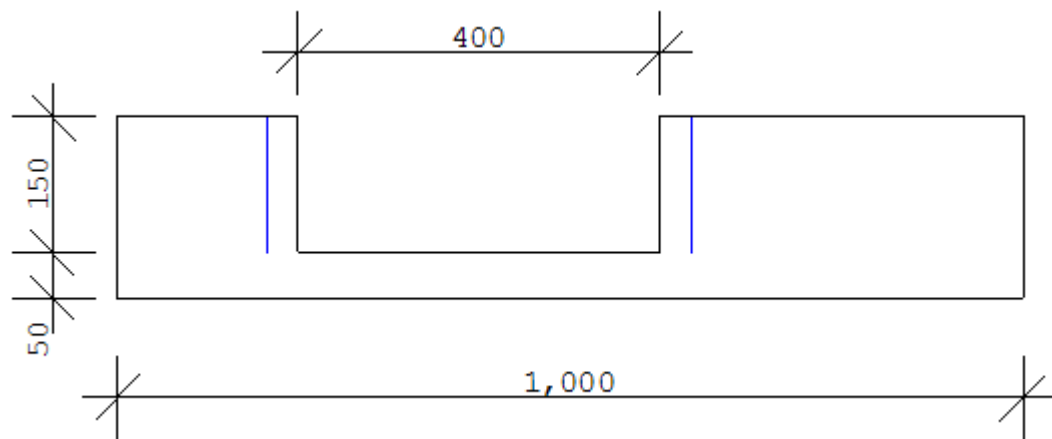
For example MACHINING 300,100, [angle],JOINTBOT

Normal upper joint



For example MACHINING 300,100, [angle],JOINTTOP

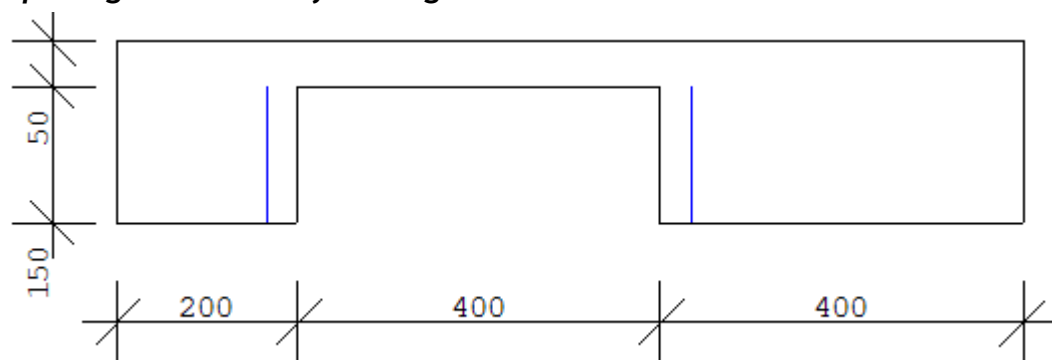
Opening at top of the log



With window grooves (for example MACHINING 200,400,150,1,HOLETOP):

Without window grooves (for example MACHINING 200,400,150,0,HOLETOP):

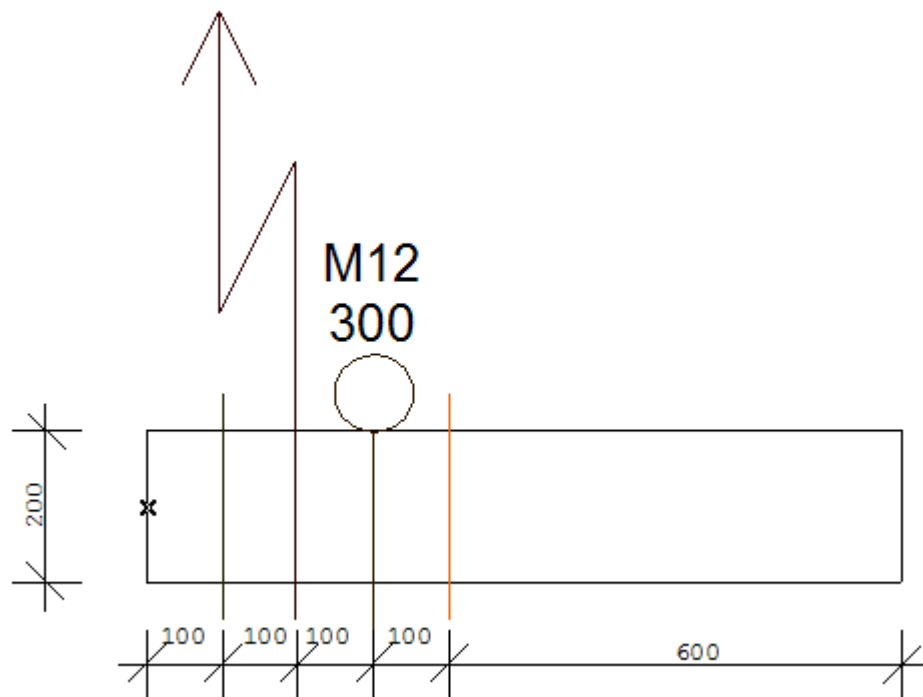
Opening at bottom of the log



With window grooves (for example MACHINING 200,400,150,1,HOLEBOT):

Without window grooves (for example MACHINING 200,400,150,0,HOLEBOT):

Drillings



Peg drilling (for example MACHINING 100,1,DRILLFULL):

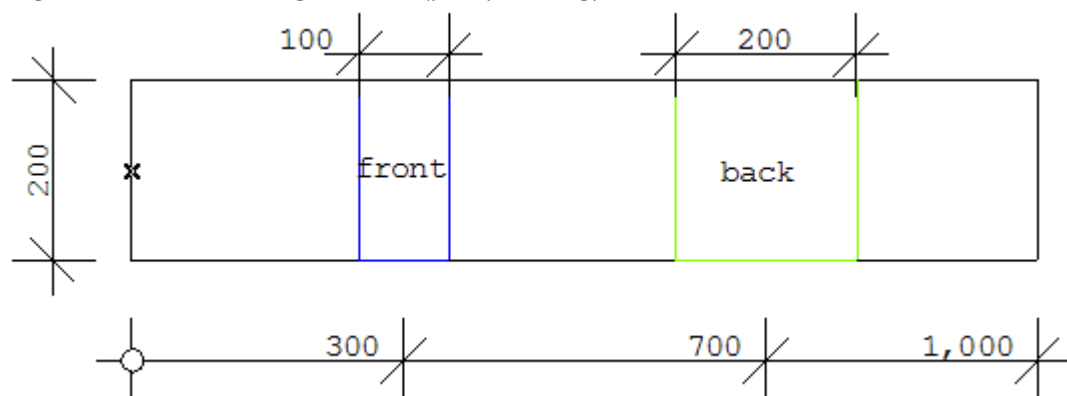
Electricity drilling (for example MACHINING 200,2,DRILLFULL):

Bolt drilling (for example MACHINING 300,3,DRILLFULL):

Special drilling (for example MACHINING 400,4,DRILLFULL):

(Specify also partial drillings to top or bottom side of the log if available.)

Light or brick wall grooves (for full log)



Front side (for example MACHINING 300,100,GROFRONT):

Back side (for example MACHINING 700,200,GROBACK):

M.A.D. Oy

Mannerheimintie 15aB
00260 Helsinki
puh. 020 7419700
fax (09) 4555091
<http://www.mad.fi>



Customer specific codes

In addition to the codes specified here you may choose up to 10 more codes you need. To enable the programming, please provide similar drawings as presented here.

These codes can be for example L-corners, T-joints, round openings etc.

M.A.D. Oy

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