〈　藤工芸　opendesk 製作の注意事項　〉

2019年　10月　19日

CNCに関する注意事項

1．opendeskホームページから、LeanDeskデザインデータをダウンロード
2．デザインデータは、DWG形式かDXF形式の提供ファイルをCNCに
　読み込ませる。
3．CNC加工機に材料をしっかり固定し加工する。
　（固定が緩いと 材料のズレ及び飛散の危険性あり）
4．加工データの読み込ませ方・加工の仕方は、その機器のマニュアルに沿うこと。
5．篏合部の板厚を合わせるため補正が必要
6．作業時間：データ入力＝半日　　加工・補正＝1日

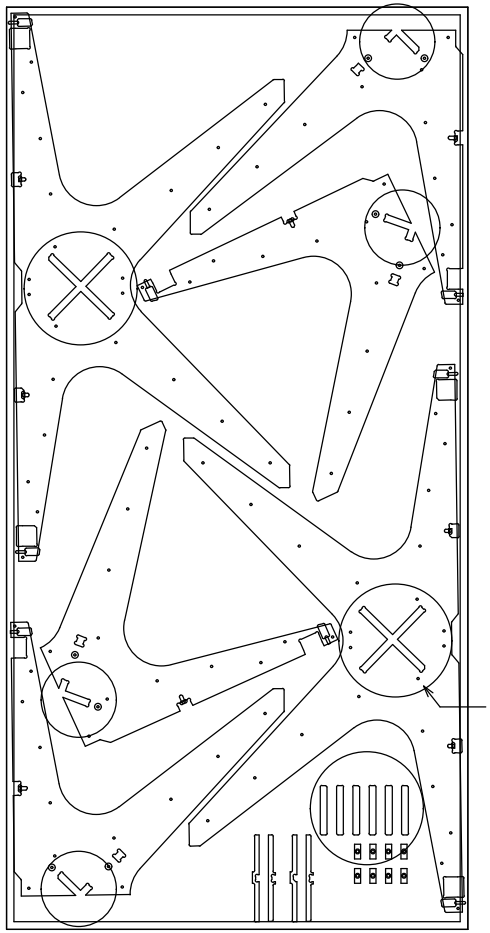
製作に関する注意事項

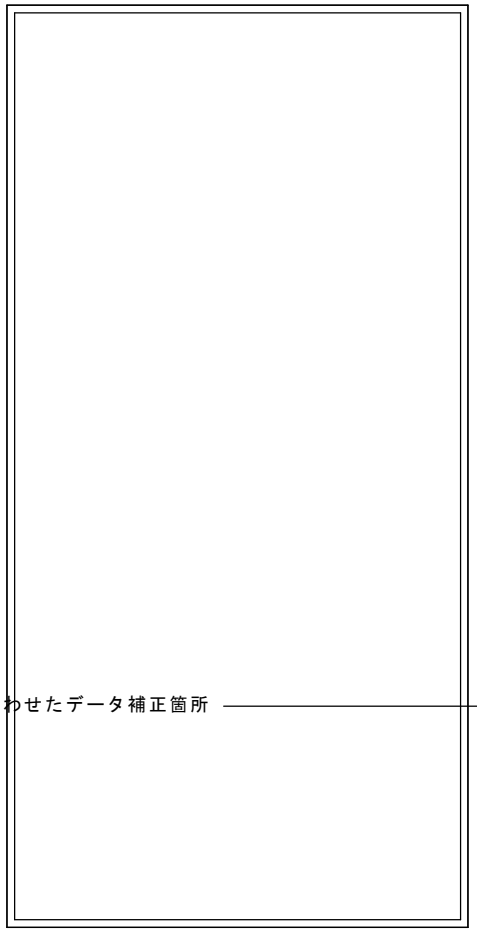
1．すべり止めの付いた軍手の使用が好ましい。
2．組み立ての際は、十分なスペースを確保する。
3．基本、二人以上で作業する。
4．板の張り合わせは、ボンドを使用しプレス機または、クランプにてよく締め
　厚さを統一する。　（ボンドの塗りすぎに注意）
5．ボルトは、強度を考慮し長さを変える。　＜別紙＞
6．誰が何処を触っても不快な思いをしないよう入念にヤスリをかけ、仕上げる。
7．作業時間：加工＝1日　塗装（3分ツヤ）＝2日　組み立て＝3名10分

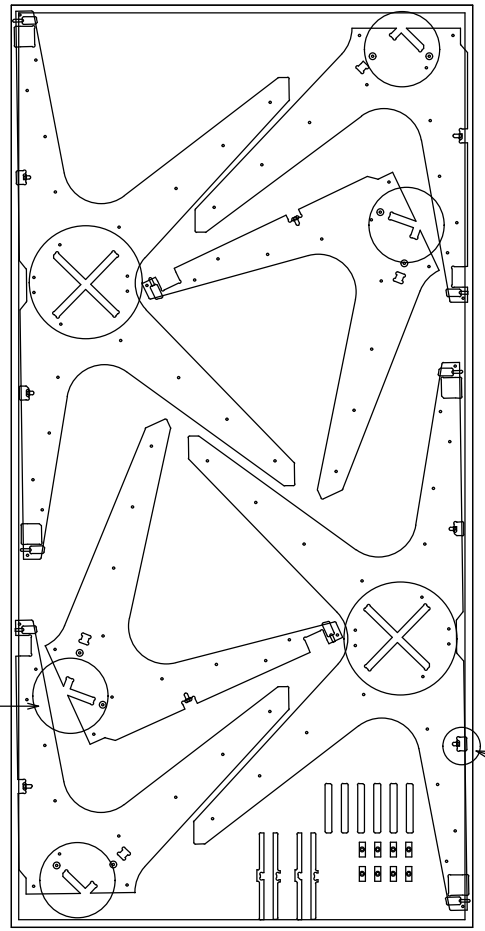
＜使用材料＞　　・ラワン合板 t12 4X8 ＊ 4
・シナベニヤ t2,5 4X8 ＊ 8
・6角ボルト M6-30 ＊ 30　M6-40 ＊ 8
・鬼目ナット M6-13 ＊38
・ダボ　6㎜-30 ＊ 70　6㎜-50 ＊ 20
・ウレタン塗料（クリア）

FUJI KOGEI

MIRROR LINE







FRONT FACE

REVERSE FACE

BOTH FACES

opendesk

Lean Lean Desk

Product: Standard

Fileset: 1600x2400x738_SA_AP @ 1.5.0

Sheet: Sheet 2

DESIGNERS:

DESIGNED FOR CNC-MILLING:

Sheet thickness: 0mmmm

Recommended drill bit (unless otherwise noted): 6mm (1/4")

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MODEL VERSION:
V1_5_0

USING THIS DRAWING

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All Opendesk drawings are drawn in 'Top' projection, and all vectors are arranged into suitably named layers describing the type and depth of cut required. All such cut depths are assumed to be measured from the top (maximum z-index) surface of the material. For example the layer 'TOP-POCKET-INSIDE_14MM' describes a pocketing inside-line cut of depth 14mm from the top surface of the material.*

All Opendesk drawings are provided in dxf format. After importing into your CNC-machine's CAM software you will need to ensure that all vectors are visible and all polylines are closed where necessary. A pdf version of the drawing is provided with each download for reference.

Layers with names beginning 'DO_NOPRINT' should not be milled. For convenience you can turn these layers off or delete their elements before setting up your CAM software.

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A minimum of 15mm tolerance is left between parts on Opendesk sheets when nested. This should be sufficient for most bit diameters.

* A pocket may be accompanied by a corresponding second line in, for example, 'TOP-POCKET-OUTSIDE_14MM', describing the limits of the associated pocket.

FABRICATION GUIDELINES

Before starting to cut your product please take account of the following guidelines. These reflect our personal research and learning and are by no means comprehensive. Please let us know if you have any recommendations for improved standards, and/or cutting methods:

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- Where designs include chamfering and pocketing it is strongly advisable to start with these cuts prior to full-depth cut-outs in order to avoid any slippage and misalignment in the material.

- Each Opendesk part can be cut using single of multi-pass cutting. Slower speeds and multiple passes will tend to produce higher quality cuts and reduce the need for sanding and finishing at the expense of cutting time. This is left to the discretion of the user based on their time and machine.

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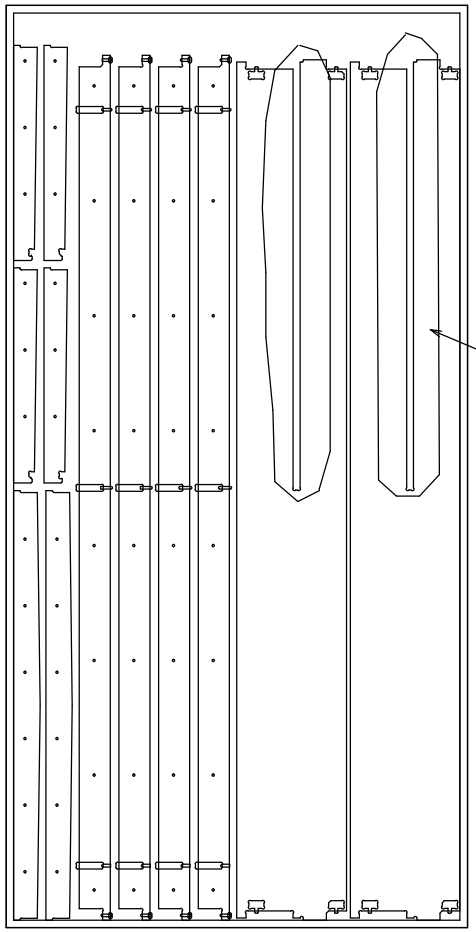
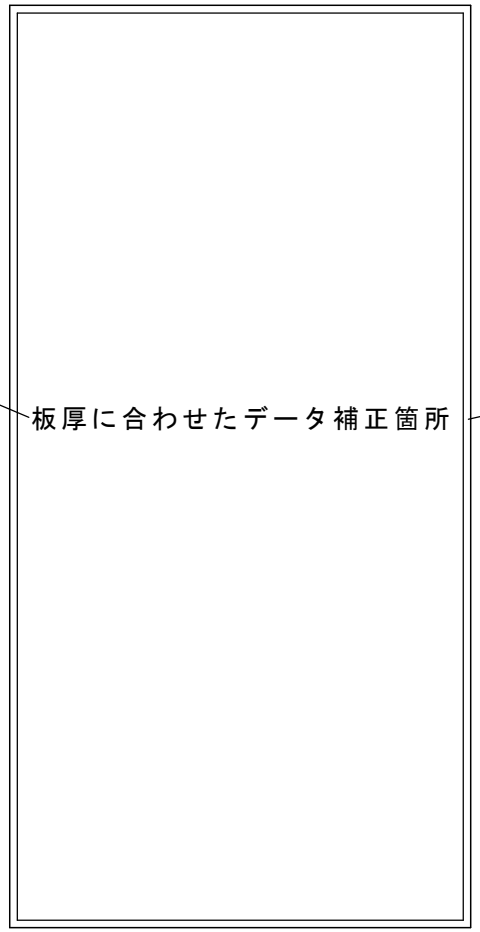
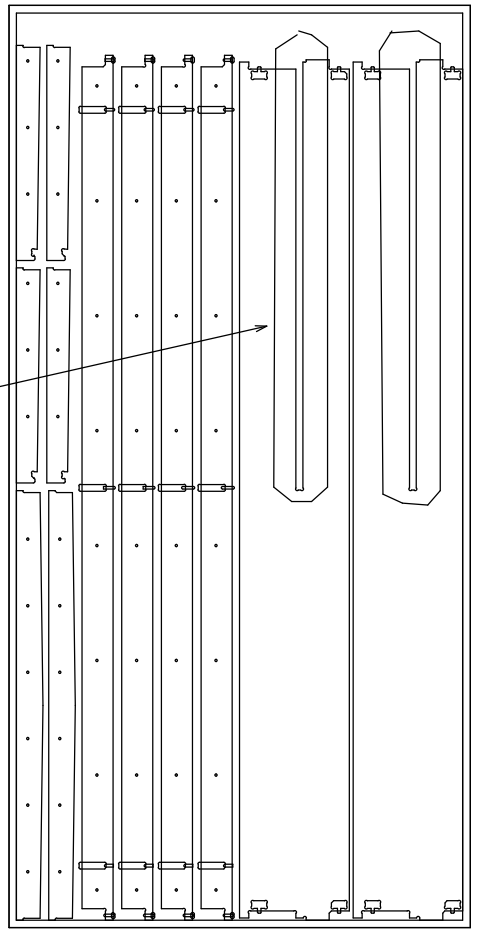
Welcome to the industrial revolution and thanks for trailblazing!

MIRROR LINE







FRONT FACE

REVERSE FACE

BOTH FACES

opendesk

Lean Lean Desk

Product: Standard

Fileset: 1600x2400x738_SA_AP @ 1.5.0

Sheet: Sheet 3

DESIGNERS:

DESIGNED FOR CNC-MILLING:

Sheet thickness: 0onemm

Recommended drill bit (unless otherwise noted): 6mm (1/4")

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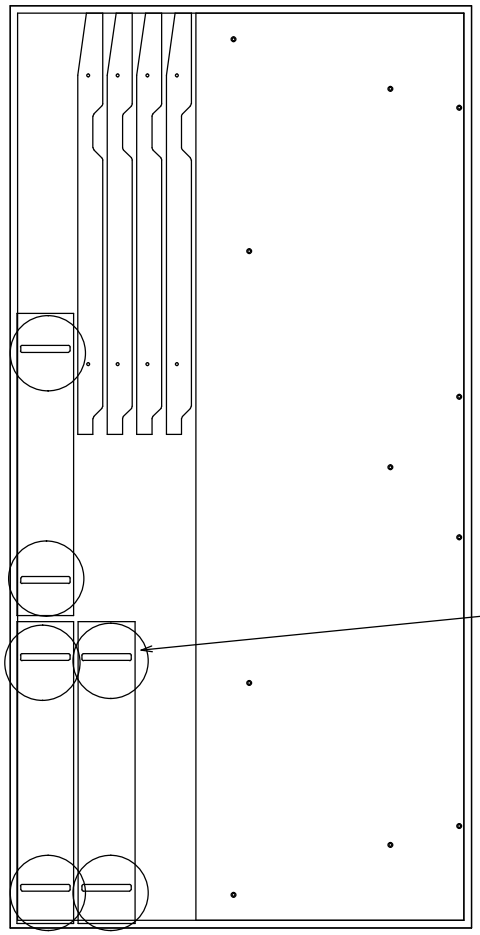

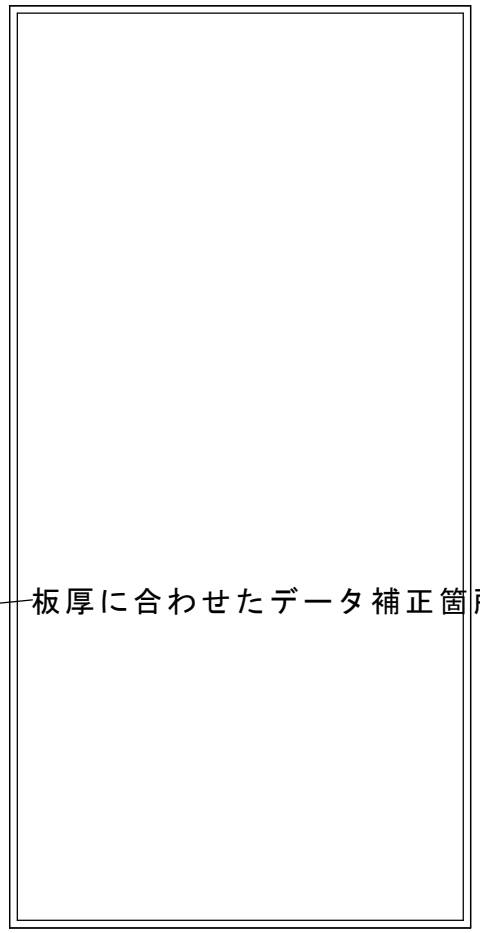

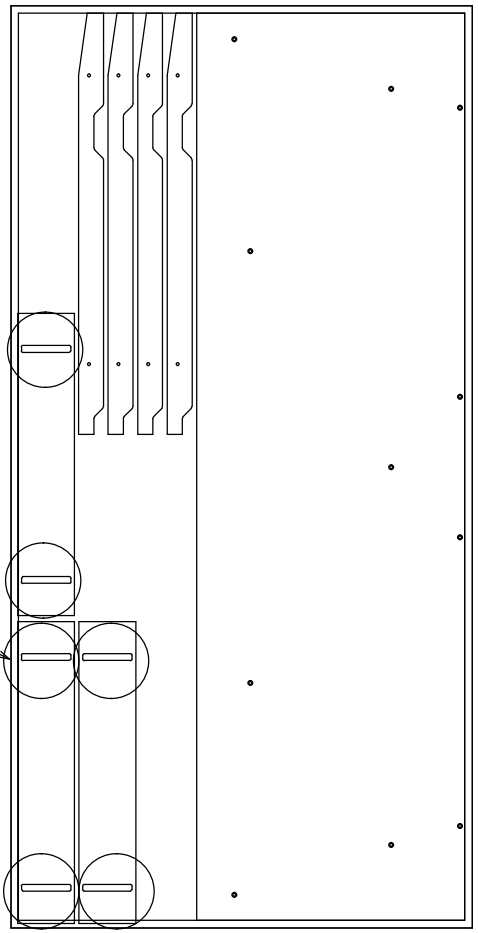

板厚に合わせたデータ補正箇所

FRONT FACE

REVERSE FACE

BOTH FACES

opendesk

Lean Lean Desk

Product: Standard

Fileset: 1600x2400x738_SA_AP @ 1.5.0

Sheet: Sheet 4

DESIGNERS:

DESIGNED FOR CNC-MILLING:

Sheet thickness: 0onemm

Recommended drill bit (unless otherwise noted): 6mm (1/4")

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