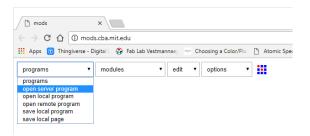
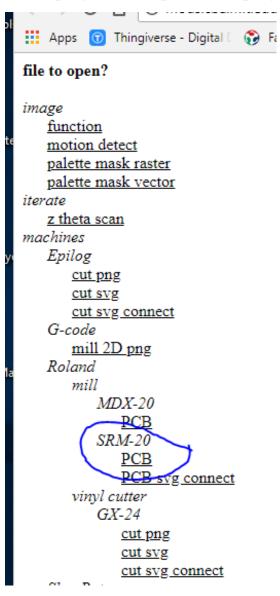
How to Mill a PCB with a Roland SRM-20 using Mods

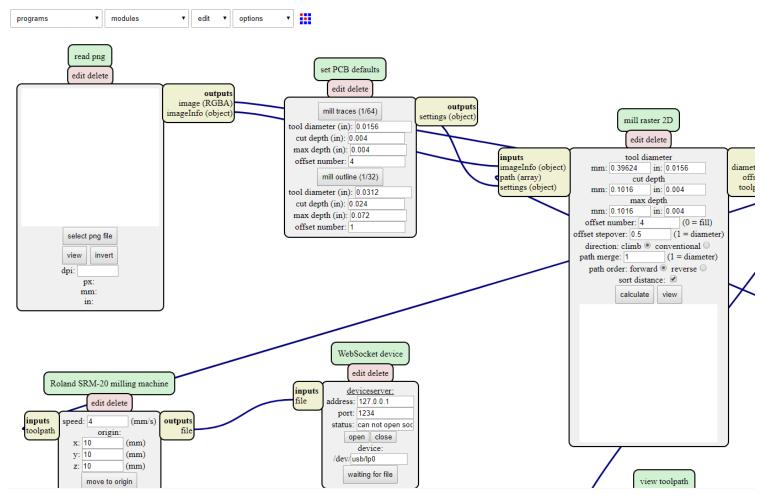
Start at the www address http://mods.cba.mit.edu/



Select programs -> open server program



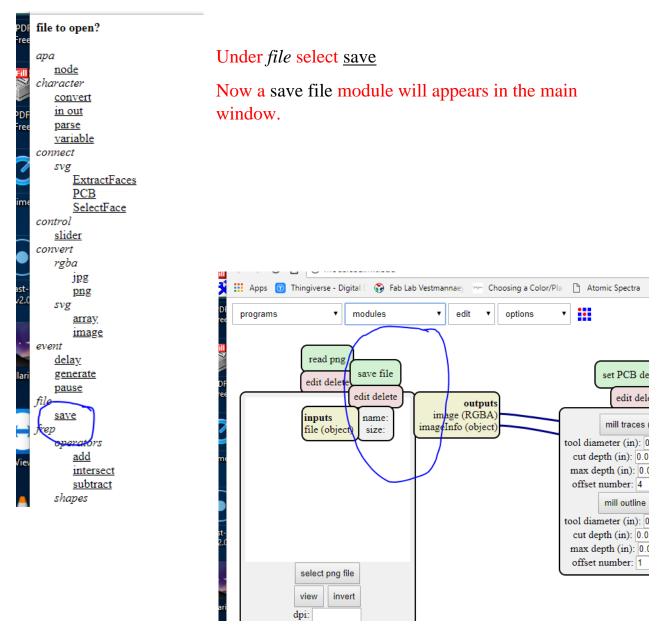
Below SRM-20 select PCB



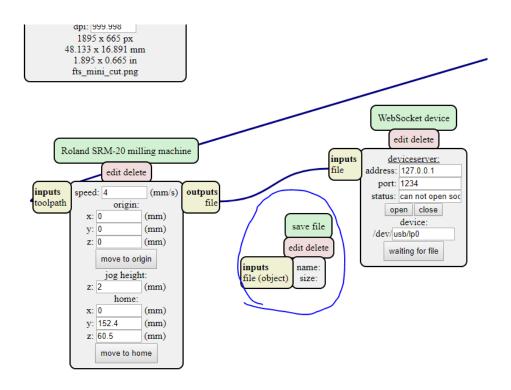
- 1. read png: Select png file
- 2. set PCB defaults: Select mill traces (1/64) or mill outline (1/32)
- 3. Roland SRM-20 milling machine: Sett origin x,y, and z to 0, 0, and 0

ograms	•	modules	•	edit	•	options	•	
		modules		L				
		add server module						
		add local module						
	read png	add remote module	•					
	edit delete			·				set PCB
	eun deleie				_			
				out	puts		_	edit d
			im	age (RG	BA)			
		ir	nage	Info (ob	ject)			mill trace

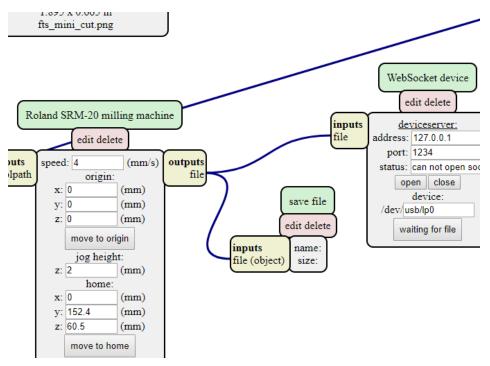


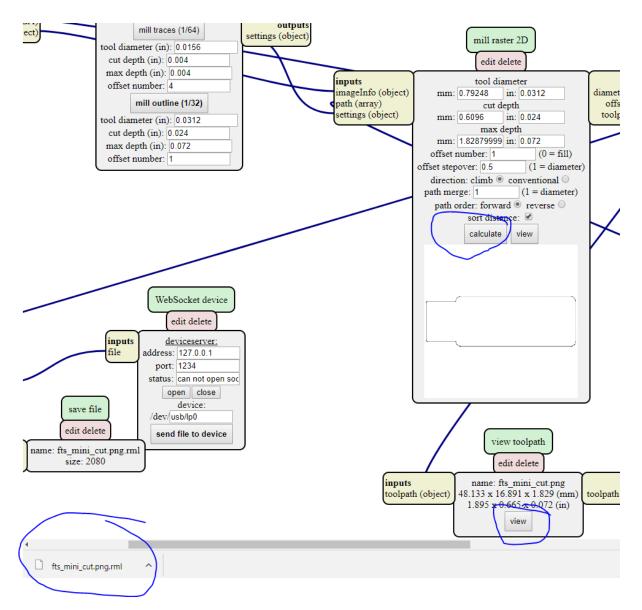


Left click and hold on the save file text, and move it down in between the Roland SRM-20 milling machine and the WebSocket device.



Use the mouse curser to go over the file in Roland SRM-20 milling machine **output** file, when the line that goes out from the square is highlighted, then left click; highlight the file(object) in save file **input** file(object) and left click.





In mods mill raster 2D click on calculate. Then a rml file will be downloaded to your Downloads directory (This happens every time you click on calculate). You can see the toolpath if you click on view in view toolpath mods.

The SRM-20

- 1. Start "VPanel for SRM-20" program
- 2. Set the Zero level for the SRM-20 cutter (own procedure)
- 3. Click on cut
- 4. Add the downloaded rml file
- 5. Click on Output, and the SRM-20 will start the cutting.

VPan	el for SRM-20		- 9 🔜
	Roland		VPenel for SRM-20 RML-1
Machine	Coordinate System	1	Set Drign Point User Coordinate System V
x	0.00 mm	A A	XX Z
Y	0.00	✓ -x +x ►	Adust
z	0.00 nm		Speed 100 ÷ s
Speed			
	0 mm/min.	Cursor Step	Spinde Speed
Spinde		Continue x100 x10 x1 Move Ta Drigin	Loui High
-	ope O	View X/Y Z Stop	(Selar) (Da) (Paulo Cana
-	IN OFF		

	Cut				
	Output File List :	Preview :			
0	C:\Users\vdg\Desktop\Sample.pm.txt	% 000000001 G91 G21 G92X0Y0Z0 G10P1R3.0 G00Z5.0 F800.056000M03 G17G41D01G00X8.0 G01Z-7.0			
2	Add Delete Delete Al 🖄	Ŧ Test			
8	Pause at Each File				
0	Save List View List	Output Cancel			