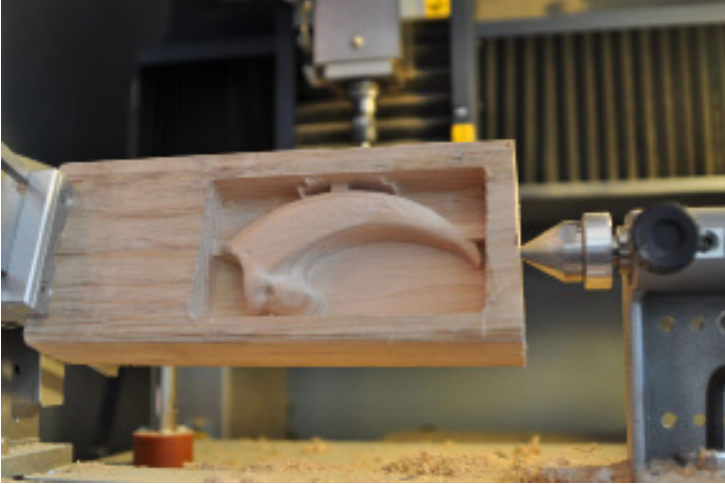




NextFab Studio  
3711 Market St  
Philadelphia, PA  
19104  
215-921-3649  
www.nextfabstudio.com



## Roland MDX-540

### Guide to Contract Services Offered by NextFab Studio

#### Roland CNC Milling Overview

NextFab Studio's Roland MDX-540 is a high-precision CNC Mill capable of machining 2D and 3D parts from plastic, wood, and soft metal materials. By moving a spinning cutter along its three axes, the mill can carve a 3D part from a solid block of material. The Roland CNC Mill can produce very high-quality surface finishes in most materials, and hold close machining tolerances.

The Roland CNC Mill is capable of machining parts that are 500mm x 400mm x 155mm on its flat bed, or fully 3D parts that are 100mm x 350mm x 150mm using its 4th-axis indexer attachment. Generally, parts cut on the flat bed are relief-style cuts or flat parts, machined from only one side. Fully 3D parts machined from multiple sides must be cut on the 4th-axis indexer attachment.

#### To request contract CNC machining services:

1. Submit your design in person, or by email to [quotes@nextfabstudio.com](mailto:quotes@nextfabstudio.com), per the guidelines in the File Setup section. We also offer a file creation service, if you'd prefer to submit your design on paper.
2. We will estimate job setup time, machine time, and material cost, then provide a quote for your approval.
3. Upon approval, we will run your job. We will notify you when your job is complete. See payment terms below.

#### Materials Suitable for CNC Milling:

- Brass
- Aluminum
- Machinable Wax
- High-Density Urethane Foam (HDU, Sign Foam, PrecisionBoard, DunaBoard)
- Plastics (ABS, Delrin, Acrylic, Polypropylene, etc.)
- Hardwoods (oak, walnut, cherry, etc.)
- Softwoods (pine, poplar, basswood, etc.)
- Fiberboard (MDF, LDF)

NextFab stocks a variety of wood, metal, plastic and prototyping materials. We can also source many other materials. Please contact us with your specific requirements.

#### Please include the following information in your request for contract CNC milling:

1. Your design, as a file or paper drawing;
2. Material specifications – please specify whether you will be providing material, or would like NextFab Studio to supply material for your job.
3. If 3D surfacing is needed, the level of surface refinement (fine, medium, coarse)
4. Desired completion date – typical job turnaround is 2-3 business days but is subject to change depending on job size and machine availability. Please keep in mind that NextFab Studio is currently closed on Mondays and Tuesdays.

## File Preparation

NextFab offers file creation services for the Roland MDX-540. However, if you'd like to set up your own file, here are some guidelines.

3D files should be submitted as an STL (.stl), IGES (.igs), or SolidWorks part file (.SLDPRT). Be aware that the Roland MDX-540 has a very high resolution and if a very fine surface finish is desired, the STL file must have a very fine mesh.

Please do not include any tabs, fixturing points, or a stock outline as they will be added by us. If tab positioning is critical to your item, please indicate placement in a separate file or in writing.



**Email questions, files and milling  
contract work to  
quotes@nextfabstudio.com.**

## Pricing / Payment Terms

Machine time, Job Setup and Post-Processing time and material figure into the cost of contract work done on the Roland MDX mill. The Job Setup fee includes verifying the file and part layout, generating toolpaths in CAM, and building any custom fixturing required to machine your job. Post-Processing includes removing tabs or fixture points, and any requested surface finishing, buffing, sanding, or special cleaning or packaging. The amount of machine time varies by job. Intricate cuts or 3D machining require much more machine time than simple profile cutting. Similarly, dense materials such as metals require more machine time than foam or wood products.

Jobs over \$500 require 25% deposit prior to initiation of work. Payment due in full upon delivery. All major credit cards accepted.

<b>Pricing</b>	<b>Member</b>	<b>Non-Member</b>
Job Setup / Post-Processing	\$30.00 per hour	\$50.00 per hour
File Preparation Services	\$30.00 per hour	\$50.00 per hour
Machine Time	\$30.00 per hour	\$45.00 per hour