

# Ordering Lasered Products From The UKF Group



Ideally, we require a 3D Parasolid file which we can import directly into the CAM software thus eliminating any possible errors in redrawing the part whilst also speeding up the process. This can be either .stp .iges or .xt. If this is not available then a detailed 2D drawing (PDF, DWG, DXF) would be needed so we can draw the part in-house, please bear in mind that this may incur an additional cost.

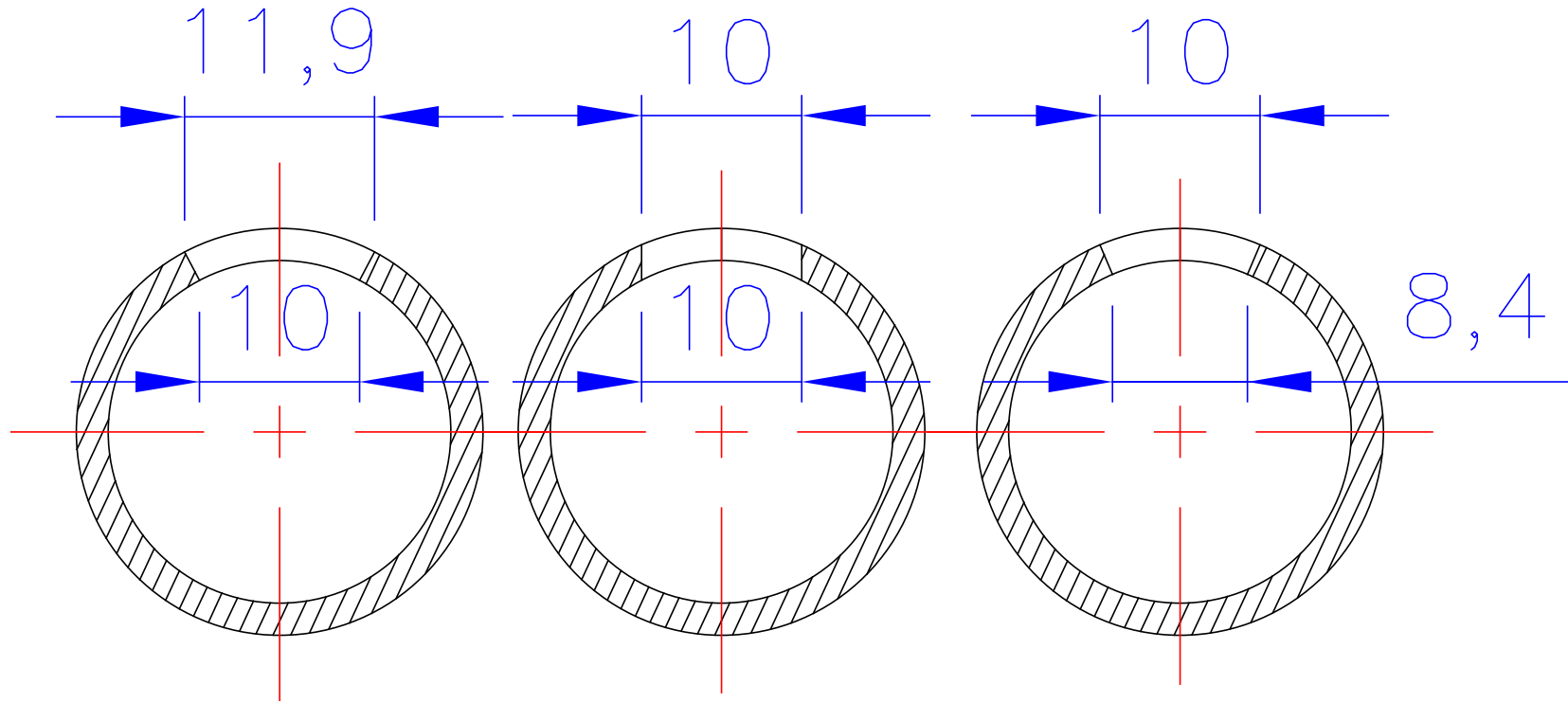
- Please indicate all instructions on your drawing or in writing e.g. weld seam positioning, hole type, etchings etc.
- If the part requires holes please specify which type of hole you require. Either XA or XY. As a default the laser will cut in the XA format. XY hole max around 1/3 of tube diameter.
- Our laser machine has a fixed 2D cutting head, therefore all cut surfaces are perpendicular to the tubes longitudinal direction. Therefore, on mitre cuts the tube will have a 'snub nose' effect & scalloped cuts will lose their 'points'. Please scroll down for drawing example.
- All of our laser machining is automated so although we will do our utmost, we cannot always guarantee a scratch free surface.
- A 6000mm parent tube will allow 5800mm of workable area, this is due to 200mm of clamp allowance.
- On all free issue orders please ensure all the dimensions of your parent bar are identical to your drawing. If the two do not correspond the part will have to be reprogrammed and this could cause delays in production and will incur a charge for the redraw.



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## Types of hole



XA CUT

XY CUT

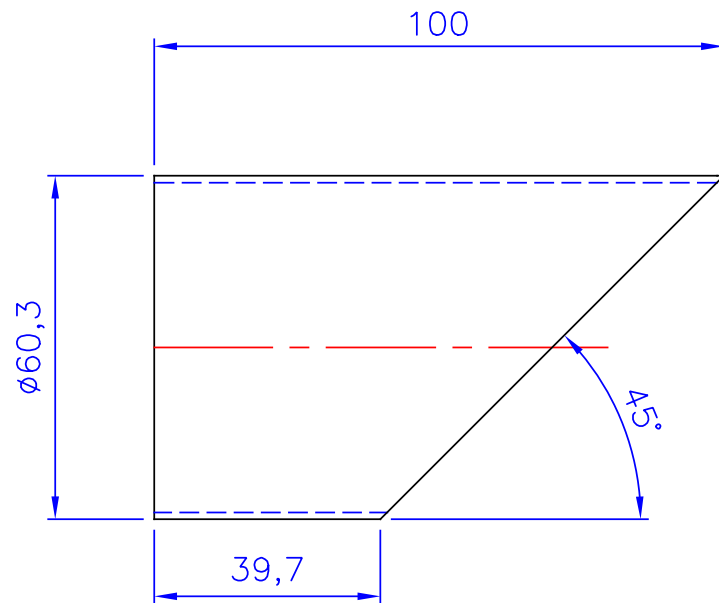
RESTING



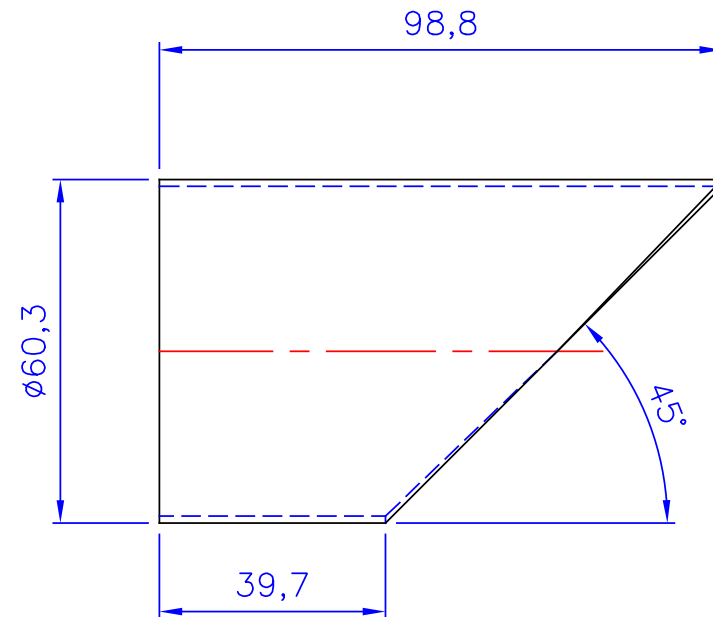
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## Typical Mitre Cut



Theoretical cut part

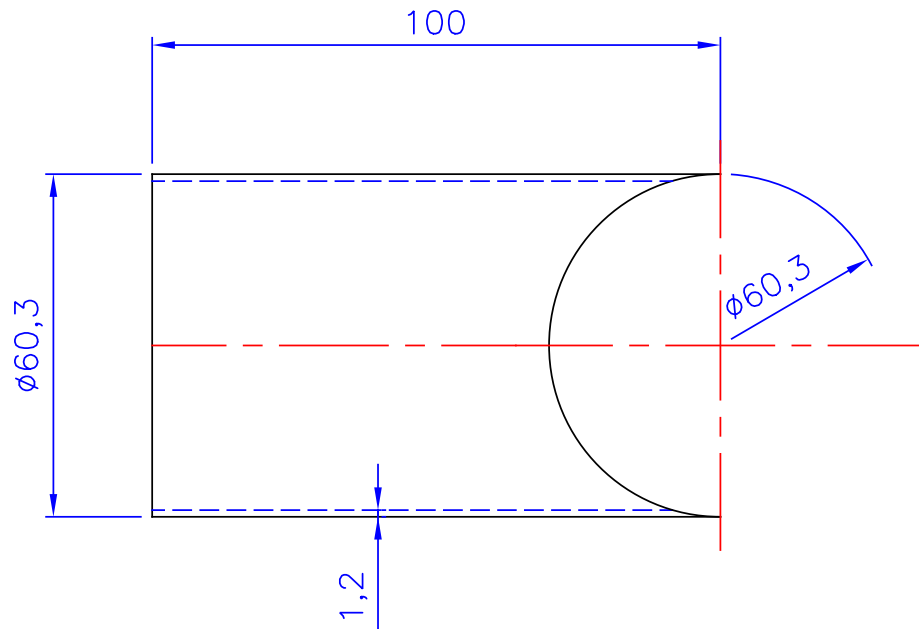


90 degree Laser cut part

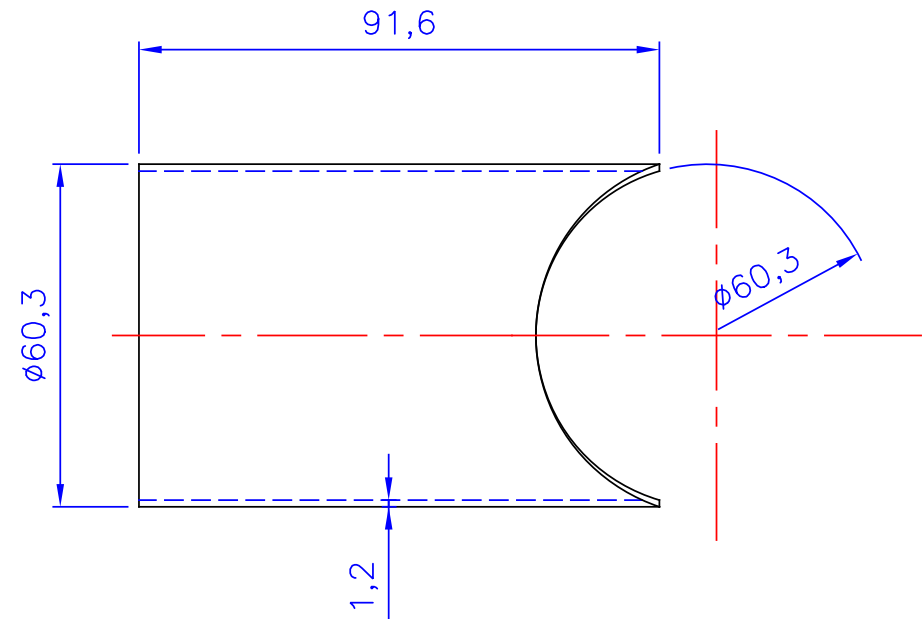
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## Typical 'Cod Mouth' Cut



Theoretical cut part



90 degree Laser cut part