

Compatible with the Current Version of



The Wine Bottle Holder feature an attractive design the sample was made using Walnut and Maple, however, you might use woods of your own choosing. We recommend using any suitable hardwood. This is a nice project to do over a weekend. The finished dimensions of the wine bottle holder is approximately 3/4" x 18" x 8."

The Instructions, crv. files and videos are found on Nextwave's Automation Website nextwaveautomation.com

This project is aimed at the woodworker with moderate to intermediate skills. You will need access to V-Carve 9.0 with updates, and the tools listed below.

With the V-Carve software, open the project CNC files. Carefully review all the toolpaths and make necessary changes to suit your tools and machine. The toolpaths are currently set with tool, feeds and speeds that were used in designing the original project. Don't use them directly until you review them for your machine. Edit the tools and change the settings to fit you own machine and requirements. It is very important to recalculate all toolpaths after

making any changes.

Once having recalculated for your own machine and tools, reset the preview, and then preview all toolpaths again to visually verify the project outcome. Then create the tap file for your machine using the correct post processor. Once satisfied with your settings, save the tool paths using the appropriate Post Processor for your machine. Check tool paths by air cutting the project or use rigid foam board to run a sample tool path. If satisfied with the outcome, now you're ready to make your own [Wine Bottle Holder!](#)

Project material list:

- 3/4"x8"x18" Hardwood Blank
- Various grade of sandpaper
- Polyurethane Clear

Project Tool List:

- 1/4" straight bit
- 1/4" dia. 60° V-Carve bit
- 1/4" Flush trim bit
- Sanding and finishing tools.

Project CNC Files:

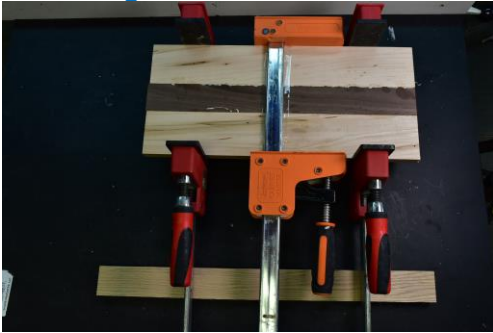
- [Simple Wine bottle holders.crv](#)

Video Files: [found on nextwaveautomation.com](http://nextwaveautomation.com)

- Wine Bottle Holder Design and tap files.mp4
- Wine Bottle Holder Finishing.mp4
- Wine Bottle Holder Machining.mp4

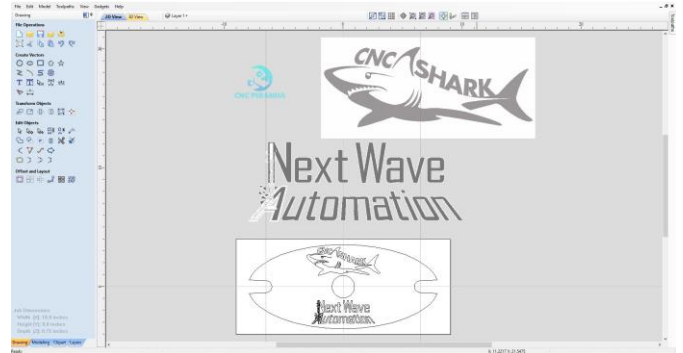
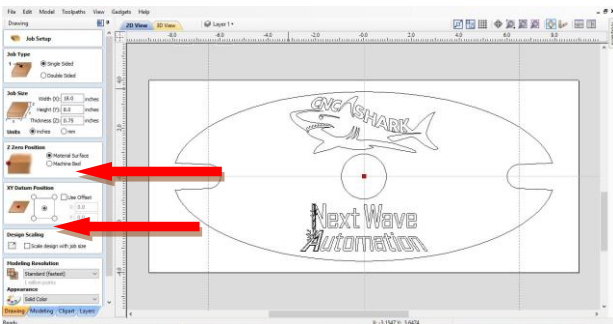
For more information on how to create the Wine bottle holder and how to modify the wine bottle holder, watch the video Wine bottle holder Design and tap files.

Creating the Blank:



Take a piece of 2"x18"x3/4" Walnut and glue it between 2 pieces of 3"x18"x3/4" Maple. Allow to cure over night. Clamp down to your blank to the spoil board I use screws in the corners. Now you are ready for machining.

Step 1: Creating Tap Files:



The first step in creating a tap file is to open the Simple Wine bottle holders.crv file. Make necessary changes for styles and personal taste. Carefully review all the toolpaths and change to suit your tools and machine. Use the correct corresponding post processor to save the tap files. For this project you should create 4 tap files. When everything is suitable, go over to the tool path menu and save each of the following tool paths.

- 1 Simple Wine V-Carve 1 [Pocket]
- 1 Simple Wine V-Carve 1
- 2 Simple Wine Hole
- 3 Simple Wine Profile

Make sure to have the following items checked in the Job setup menu to get the correct results.

Zero position, Material Surface
XY position Center

Step 2: Machining the Wine bottle holder Lettering and Logo

Step 3: Machining the Wine bottle holder Hole and Profile



Mount the material so it is square with the X and Y axis. Secure in the corners with screw or clamps as in the figure above. Make sure the clamps or screws do not obstruct the bit during machining. Install a 1/8" spiral up bit. Touch off the Z-axis on the "TOP of the Material" see [Reference Video](#). Load the [1 Simple Wine V-Carve 1 \[Pocket\].tap](#) file. Run the tap file with a router speed at 12,000 to 16,000 RPM.

Cutting Hole:

Vacuum the top of the fixture. Install the 1/4 straight bit. Touch off the Z-axis on the "TOP of the Material" see [Reference Video](#). Load the [2 Simple Wine Hole.tap](#) file. Run the tap file with a router speed at 12,000 to 16,000 RPM.



Cutting Profile:

Vacuum the top of the fixture. No need to touch off, we have not changed bits. Load the [3 Simple Wine Profile.tap](#) file. Run the tap file with a router speed at 12,000 to 16,000 RPM.

Clean the fixture of all debris. Install a 1/4" 60° V-bit. Touch off the Z-axis on the "TOP of the Material" see [Reference Video](#). Load the [1 Simple Wine V-Carve 1 tap](#) file. Run the tap file with a router speed at 12,000 to 16,000 RPM.

Step 4: Removing the tabs, Epoxy inlay and Sanding the Wine Bottle Holder:



Cutting Tabs:

Cut the Wine bottle holder free from the blank using a trim router and a 1/4" flush trim bit. The router bit will be a snug fit. Cut from the bottom side so the groove becomes your guide.

Epoxy Inlays:



Before completing epoxy inlays, always seal the project with shellac. This is so it seals the pores of the wood and the paint or epoxy doesn't migrate. Mix the epoxy first then add the colorant. Thoroughly mix together. When applying make sure to fill all of the voids and get out all of the air bubbles. Let cure for 24 hours. Carefully sand flush with the top surface of the Wine Bottle Holder.

Sanding:



Using an orbital sander with 180 grit sandpaper, sand and remove any unwanted material from the detailed areas of the Wine Bottle Holder. Be careful not to overdo, it will take away features away on your wine bottle holder. Sand everything down to with 240 grit sandpaper. Once satisfied with the sanding and detailing, of the wine bottle holder prepare for finishing.

Step 6: Finishing the Wine Bottle Holder:



Clean and prep the wine bottle holder for finishing. I tried a new finish, Alupalite epoxy resin. This coating is resistant to chemicals and cures to a mirror like finish. It is a 1 to 1 mixing of part A and B. When mixing make sure you thoroughly mix the part A and B or you will have a mix that will not cure. Take



Project Tutorial

August Project: Wine Bottle Holder

Designs by Rick Frazier

the mixture and evenly coat the entire surface, let it run over the sides. When you are satisfied with the surface, run your finger on the edges to smooth out. Use a propane torch to fan over the epoxy, this helps to release the bubbles from the epoxy. Allow to set for 24 hours, coat the other side with polyurethane and you are done.

Hope you enjoy the making of this project. So, keep your creative juices flowing and come back next month for another cool project.

Have and Happy Carving!
Rick Frazier