|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  | Title: | | Drawing No.: | | | | | Rev. |
| **Flange Adapter** | | **CNCM1006-PE1** | | | | | **1** |
| Machine: | | Program No.: | | | | | |
| **Haas VF-1** | | **O20061** | | | | | |
| Material Type: | Material Size: | | | | Material Bhn: | | |
| **6061 T6** | **½” x 4” x 4” plate** | | | | **100** | | |
| Programmer: | | | Operation(s): | | | | |
| **Stephane Drouin-Moreland** | | | **1** | of | | **1** | |

**Workholding Set-up**

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| --- | --- | --- | --- |
| Workholding Device: | | | |
| **KURT Milling Machine Vise** | | | |
|  | | | |
| **WCO: 54** | **A: min .20”** | **B: .0** | **C: .132** |

**Workholding Instructions / Machine Settings:**

|  |
| --- |
| Datum C against the fixed jaw. |
| Adjust G54 Z by -.132 |
| Set Chamfer tool diameter offset to .1 (T12) |
| Set the wear offset for the spot drill to .05 and adjust to achieve the desired chamfer. |
| Use max 1/8” parallels, against the vise jaws. |
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**Tooling Information**

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| Tool Description: | | **3.0 CoroMill 245 6fl** | | | | | Operation: | | **Face** | |
| Manufacturer ID: | | **RA245-076R25-12M** | | | | | Insert ID: | | **R245-12 T3 E-AL H10** | |
| Holder Description: | | **C-Style Arbor (245 Face Mill)** | | | | | Holder ID: | | **AA305-40 25 051** | |
| T Code | H Code | | D Code | Teeth (z) | RPM (n) | Table Feed (vf) | | Cutting Depth (ap) | | Cutting Width (ae) |
| **03** | **03** | | **-** | **6** | **3247** | **175.33** | | **.02** | | **-** |
| Notes: |  | | | | | | | | | |
| Settings: | **Set as large tool** | | | | | | | | | |

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| Tool Description: | | **½ x ½ HSS 2fl End Mill** | | | | | Operation: | | **Various** | |
| Manufacturer ID: | | **Dormer 980 ½ x ½** | | | | | Insert ID: | | **-** | |
| Holder Description: | | **Short ER32 Collet Chuck** | | | | | Holder ID: | | **Lyndex C4007-0032** | |
| T Code | H Code | | D Code | Teeth (z) | RPM (n) | Table Feed (vf) | | Cutting Depth (ap) | | Cutting Width (ae) |
| **05** | **05** | | **05** | **2** | **7500** | **61.5** | | **.25 Max** | | **.25 Max** |
| Notes: |  | | | | | | | | | |
| Settings: |  | | | | | | | | | |

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| Tool Description: | | **¾ 90° Spot Drill** | | | | | Operation: | | **Spot drill** | |
| Manufacturer ID: | | **Dormer SPS90 ¾** | | | | | Insert ID: | | **-** | |
| Holder Description: | | **Short ER32 Collet Chuck** | | | | | Holder ID: | | **Lyndex C4007-0032** | |
| T Code | H Code | | D Code | Teeth (z) | RPM (n) | Table Feed (vf) | | Cutting Depth (ap) | | Cutting Width (ae) |
| **06** | **06** | | **-** | **-** | **832** | **4.74** | | **-** | | **-** |
| Notes: | **Set wear offset to .05 and adjust to achieve the desired chamfer.** | | | | | | | | | |
| Settings: |  | | | | | | | | | |

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| Tool Description: | | **37/64 HSS Jobber Drill** | | | | | Operation: | | **Drill rough .63 hole, Pocket start hole** | |
| Manufacturer ID: | | **Dormer R10** | | | | | Insert ID: | | **-** | |
| Holder Description: | | **#2 Morse Taper Adapter** | | | | | Holder ID: | | **Lyndex C4004-0002** | |
| T Code | H Code | | D Code | Teeth (z) | RPM (n) | Table Feed (vf) | | Cutting Depth (ap) | | Cutting Width (ae) |
| **07** | **07** | | **-** | **-** | **648** | **7.9** | | **-** | | **-** |
| Notes: |  | | | | | | | | | |
| Settings: |  | | | | | | | | | |

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| Tool Description: | | **5/16 Jobber Drill** | | | | | Operation: | | **Drill tapped holes** | |
| Manufacturer ID: | | **Dormer r10** | | | | | Insert ID: | | **-** | |
| Holder Description: | | **½” Precission Drill Chuck** | | | | | Holder ID: | | **Nikken CAT40-NPU13-10SU** | |
| T Code | H Code | | D Code | Teeth (z) | RPM (n) | Table Feed (vf) | | Cutting Depth (ap) | | Cutting Width (ae) |
| **10** | **10** | | **-** | **-** | **1198** | **10.42** | | **-** | | **-** |
| Notes: |  | | | | | | | | | |
| Settings: |  | | | | | | | | | |

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| Tool Description: | | **3/8-16UNC-2B Tap** | | | | | Operation: | | **Drill .58 Hole** | |
| Manufacturer ID: | | **Dormer E027 3/8** | | | | | Insert ID: | | **-** | |
| Holder Description: | | **Rigid Tapping Head** | | | | | Holder ID: | | **GS CAT40 #1-3.02”** | |
| T Code | H Code | | D Code | Teeth (z) | RPM (n) | Table Feed (vf) | | Cutting Depth (ap) | | Cutting Width (ae) |
| **11** | **11** | | **-** | **-** | **1171** | **7.9** | | **-** | | **-** |
| Notes: |  | | | | | | | | | |
| Settings: |  | | | | | | | | | |

**Tooling Information**

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| Tool Description: | | **8mm CoroMill Plura Chamfering End Mill** | | | | | Operation: | | **Chamfer** | |
| Manufacturer ID: | | **R215.85-02000-AC30G 1620** | | | | | Insert ID: | | **-** | |
| Holder Description: | | **Short ER32 Collet Chuck** | | | | | Holder ID: | | **Lyndex C4007-0032** | |
| T Code | H Code | | D Code | Teeth (z) | RPM (n) | Table Feed (vf) | | Cutting Depth (ap) | | Cutting Width (ae) |
| **12** | **12** | | **12** | **-** | **7500** | **30.0** | | **-** | | **-** |
| Notes: |  | | | | | | | | | |
| Settings: | **Set diameter offset to 0.1** | | | | | | | | | |