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| --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  | Title: | | Drawing No.: | | | | | Rev. |
| **Adapter Plate** | | **MACH20X-A** | | | | | **0** |
| Machine: | | Program No.: | | | | | |
|  | | **O10065** | | | | | |
| Material Type: | Material Size: | | | | Material Bhn: | | |
| **6061 T6** | **Pre-Machined Part** | | | | **100** | | |
| Programmer: | | | Operation(s): | | | | |
| **Stephane Drouin-Moreland** | | | **1** | of | | **1** | |

**Workholding Set-up**

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| --- | --- | --- | --- |
| Workholding Device: | | | |
|  | | | |
|  | | | |
| **WCO: 54** | **A: 0** | **B: .200 +/- .02** | **C:** |

**Workholding Instructions / Machine Settings:**

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| --- |
| Datum B against he fixed jaw. |
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**Tooling Information**

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| Tool Description: | | **¾” x 90deg HSS Spot Drill** | | | | | Operation: | | **Spot Drill** | |
| Manufacturer ID: | | **Dormer SPS903/4** | | | | | Insert ID: | | **-** | |
| Holder Description: | | **Short ER32 Collet Chuck** | | | | | Holder ID: | | **GS CAT40 ER32-3.13”** | |
| T Code | H Code | | D Code | Teeth (z) | RPM (n) | Table Feed (vf) | | Cutting Depth (ap) | | Cutting Width (ae) |
| **02** | **02** | | **-** | **-** | **567-851** | **7.07** | | **-** | | **-** |
| Notes: | **Set wear offset to .25 and adjust to achieve the appropriate chamfer diameter** | | | | | | | | | |
| Settings: |  | | | | | | | | | |

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| Tool Description: | | **37/64 Jobber Drill** | | | | | Operation: | | **Drill .58 Hole** | |
| Manufacturer ID: | | **Dromer 209** | | | | | 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) |
| **03** | **03** | | **-** | **-** | **647** | **7.9** | | **-** | | **-** |
| Notes: |  | | | | | | | | | |
| Settings: |  | | | | | | | | | |

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| Tool Description: | | **U Jobber Drill** | | | | | Operation: | | **Drill Tap 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) |
| **04** | **04** | | **-** | **-** | **1017** | **10.58** | | **-** | | **-** |
| Notes: |  | | | | | | | | | |
| Settings: |  | | | | | | | | | |

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| Tool Description: | | **3/8-16UNC-2B Tap** | | | | | Operation: | | **Tap Holes** | |
| Manufacturer ID: | | **Dormer E0271/4** | | | | | 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) |
| **05** | **05** | | **-** | **-** | **1171** | **73.21** | | **-** | | **-** |
| Notes: |  | | | | | | | | | |
| Settings: |  | | | | | | | | | |

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| Tool Description: | |  | | | | | Operation: | |  | |
| Manufacturer ID: | |  | | | | | Insert ID: | |  | |
| Holder Description: | |  | | | | | Holder ID: | |  | |
| T Code | H Code | | D Code | Teeth (z) | RPM (n) | Table Feed (vf) | | Cutting Depth (ap) | | Cutting Width (ae) |
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| Notes: |  | | | | | | | | | |
| Settings: |  | | | | | | | | | |

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| Tool Description: | |  | | | | | Operation: | |  | |
| Manufacturer ID: | |  | | | | | Insert ID: | |  | |
| Holder Description: | |  | | | | | Holder ID: | |  | |
| T Code | H Code | | D Code | Teeth (z) | RPM (n) | Table Feed (vf) | | Cutting Depth (ap) | | Cutting Width (ae) |
|  |  | |  |  |  |  | |  | |  |
| Notes: |  | | | | | | | | | |
| Settings: |  | | | | | | | | | |