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|  | Title: | | Drawing No: | | | | Rev | |
| **Weld-On Thread Adapter** | | **CNMC1005-D7** | | | |  | |
| Machine: | | Program No.: | | | | | |
| **HAAS TL-15** | | **10063** | | | | | |
| Material Type (MC number): | Material Size: | | | | Material Bhn: | | |
| **P1.2.Z.AN** | **Pre-Machined Part** | | | | **150** | | |
| Workholding Device: | | | Operation(s): | | | | |
| **Soft Jaws** | | | **4** | of | | | **4** |
| Programmer: | | | | | | | |
| **Stephane Drouin-Moreland** | | | | | | | |

**Workholding Set-up**

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| **Work Coordinate Offset:** | **A:** | **B: 0.04** |

**Special Instructions:**

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| Operation: | **Rough Face and OD** | | | | | | | |
| Cutting Head ID: |  | | | | Insert ID: | DNMG-332 PM4325 | | |
| Cutting Unit ID: | C4-DDJNR-207050-12 | | | | Clamping Unit ID: |  | | |
| Turret Position | Offset # | | Tip Code | TNR (re) | Velocity (Vc) | RPM (n) | Feed Rate (fn) | DOC Range |
| **01** | **01** | | **3** | **.0313** | **990** | **-** | **0.05-0.0118in/rev** | **0.02-0.079-0.197** |
| Notes: |  |  | | | | | | |

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| Operation: |  | | | | | | | |
| Cutting Head ID: |  | | | | Insert ID: | DNMG-332 PM4325 | | |
| Cutting Unit ID: | C4-DDJNR-207050-12 | | | | Clamping Unit ID: |  | | |
| Turret Position | Offset # | | Tip Code | TNR (re) | Velocity (Vc) | RPM (n) | Feed Rate (fn) | DOC Range |
| **03** | **03** | | **3** | 0.0156 | **990** | **-** | 0.0118 | **0.01-0.016-0.059** |
| Notes: |  |  | | | | | | |

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| Operation: |  | | | | | | | |
| Cutting Head ID: |  | | | | Insert ID: | CCMT 3(2.5)1 PF4225 | | |
| Cutting Unit ID: | C4-SCLCR-13080-09 | | | | Clamping Unit ID: |  | | |
| Turret Position | Offset # | | Tip Code | TNR (re) | Velocity (Vc) | RPM (n) | Feed Rate (fn) | DOC Range |
| **05** | **05** | | **2** | 0.0156 | **990** |  | 0.004 | **0.004-0.014-0.079** |
| Notes: |  |  | | | | | | |

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| Operation: |  | | | | | | | |
| Cutting Head ID: |  | | | | Insert ID: | 266RG-16UN01C120M | | |
| Cutting Unit ID: | C4-266RFG-27050-16 | | | | Clamping Unit ID: |  | | |
| Turret Position | Offset # | | Tip Code | TNR (re) | Velocity (Vc) | RPM (n) | Feed Rate (fn) | DOC Range |
| **07** | **07** | | **--** | **-** | **640** | **1397** | 0.004 | **-** |
| Notes: |  |  | | | | | | |

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| Operation: |  | | | | | | | |
| Cutting Head ID: |  | | | | Insert ID: | N123G2-0310-0002-GF 1125 | | |
| Cutting Unit ID: | C4-RF123G20-27060B | | | | Clamping Unit ID: |  | | |
| Turret Position | Offset # | | Tip Code | TNR (re) | Velocity (Vc) | RPM (n) | Feed Rate (fn) | DOC Range |
| **09** | **09** | | **-** | **-** | **620** | **1353** | **0.083333** | **-** |
| Notes: |  |  | | | | | | |

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| Operation: |  | | | | | | | |
| Cutting Head ID: |  | | | | Insert ID: |  | | |
| Cutting Unit ID: |  | | | | Clamping Unit ID: |  | | |
| Turret Position | Offset # | | Tip Code | TNR (re) | Velocity (Vc) | RPM (n) | Feed Rate (fn) | DOC Range |
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| Notes: |  |  | | | | | | |

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| Operation: |  | | | | | | | |
| Cutting Head ID: |  | | | | Insert ID: |  | | |
| Cutting Unit ID: |  | | | | Clamping Unit ID: |  | | |
| Turret Position | Offset # | | Tip Code | TNR (re) | Velocity (Vc) | RPM (n) | Feed Rate (fn) | DOC Range |
|  |  | |  |  |  |  |  |  |
| Notes: |  |  | | | | | | |