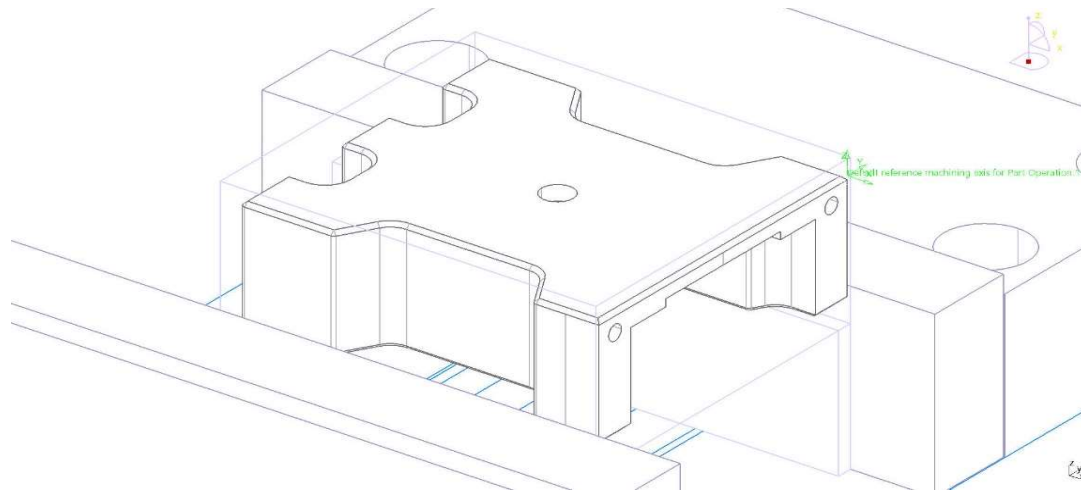
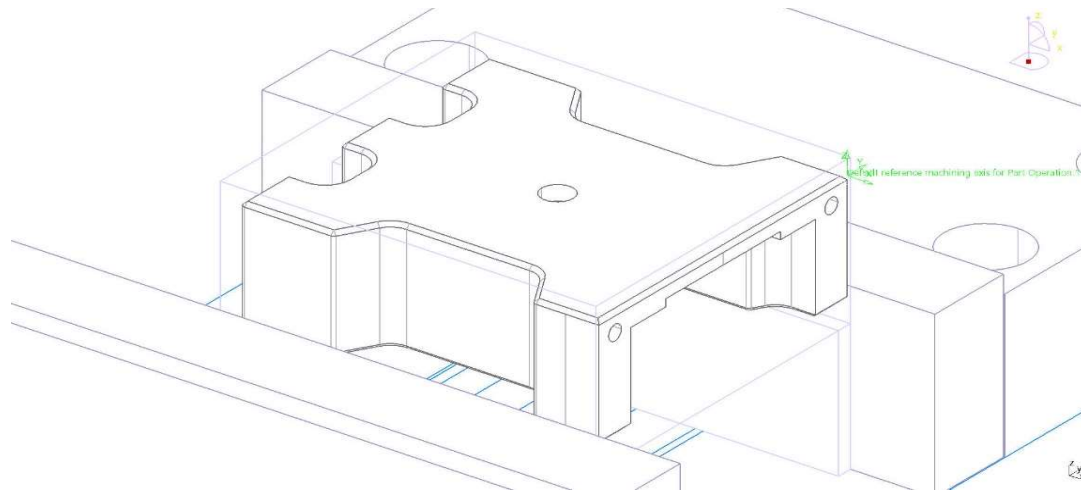


## Clock Body

Op #	Activity	Tool #	Feedrate (IPM)	Spindle Speed (RPM)	Approach Feed (IPM)	Retract Feed (IPM)	Finishing Feed (IPM)	Machining Time	Total Time
	<b>Tool Change.1</b>	10	<b>Tool Desc: T10 Face Mill D 2" Carbide</b>				<b>Tool Stickout:</b>		
1	Facing.1	10	80	3500	11.811	60	20	2' 45"	3' 6"
	<b>Tool Change.2</b>	2	<b>Tool Desc: T2 End Mill D1/2" Carbide 4 Flutes</b>				<b>Tool Stickout:</b>		
2	Pocketing.1	2	160	6000	11.811	60	20	20"	1' 26"
3	Profile Contouring.5	2	160	6000	11.811	60	20	22"	1' 26"
4	Pocketing.10	2	160	6000	11.811	60	20	4"	1' 8"
5	Pocketing.11	2	160	6000	11.811	60	20	4"	1' 8"
6	Pocketing.4	2	160	6000	11.811	60	20	20"	1' 25"
7	Profile Contouring.2	2	160	6000	11.811	60	20	3' 1"	4' 5"
	<b>Tool Change.3</b>	9	<b>Tool Desc: T9 Countersink D 1/4"</b>				<b>Tool Stickout:</b>		
8	Curve Following.2	9	60	6000	11.811	60	60	19"	24"
	<b>Tool Change.4</b>	3	<b>Tool Desc: T3 Center Drill #4 HSS</b>				<b>Tool Stickout:</b>		
9	Spot Drilling.2	3	10	6000	10	39.37		9"	10"
10	Curve Following.3	3	60	6000	10	60	10	31"	35"
11	Curve Following.5	3	60	6000	10	60	10	5"	14"
	<b>Tool Change.5</b>	4	<b>Tool Desc: T4 Center Drill #2 HSS</b>				<b>Tool Stickout:</b>		
12	Curve Following.6	4	60	6000	10	60	10	32"	51"
	<b>Tool Change.6</b>	5	<b>Tool Desc: T5 Drill D 3/8" HSS</b>				<b>Tool Stickout:</b>		
13	Drilling.1	5	10	4000	10	39.37		4"	5"
								8' 35"	16' 2"



Op #	Activity	Tool #	Feedrate (IPM)	Spindle Speed (RPM)	Approach Feed (IPM)	Retract Feed (IPM)	Finishing Feed (IPM)	Machining Time	Total Time
	<b>Tool Change.11</b>	10	<b>Tool Desc: T10 Face Mill D 2" Carbide</b>				<b>Tool Stickout:</b>		
14	Facing.5	10	80	3500	11.811	60	20	2' 45"	3' 6"
	<b>Tool Change.12</b>	2	<b>Tool Desc: T2 End Mill D1/2" Carbide 4 Flutes</b>				<b>Tool Stickout:</b>		
15	Pocketing.20	2	160	6000	11.811	60	20	20"	1' 26"
16	Profile Contouring.9	2	160	6000	11.811	60	20	22"	1' 26"
17	Pocketing.22	2	160	6000	11.811	60	20	4"	1' 8"
18	Pocketing.23	2	160	6000	11.811	60	20	4"	1' 8"
19	Pocketing.21	2	160	6000	11.811	60	20	20"	1' 25"
20	Profile Contouring.8	2	160	6000	11.811	60	20	3' 1"	4' 5"
	<b>Tool Change.13</b>	9	<b>Tool Desc: T9 Countersink D 1/4"</b>				<b>Tool Stickout:</b>		
21	Curve Following.10	9	60	6000	11.811	60	60	19"	24"
	<b>Tool Change.14</b>	3	<b>Tool Desc: T3 Center Drill #4 HSS</b>				<b>Tool Stickout:</b>		
22	Spot Drilling.3	3	10	6000	10	39.37		9"	10"
23	Curve Following.11	3	60	6000	10	60	10	31"	35"
24	Curve Following.12	3	60	6000	10	60	10	5"	14"
	<b>Tool Change.15</b>	4	<b>Tool Desc: T4 Center Drill #2 HSS</b>				<b>Tool Stickout:</b>		
25	Curve Following.13	4	60	6000	10	60	10	32"	51"
	<b>Tool Change.16</b>	5	<b>Tool Desc: T5 Drill D 3/8" HSS</b>				<b>Tool Stickout:</b>		
26	Drilling.2	5	10	4000	10	39.37		4"	5"
								8' 35"	16' 2"



Op #	Activity	Tool #	Feedrate (IPM)	Spindle Speed (RPM)	Approach Feed (IPM)	Retract Feed (IPM)	Finishing Feed (IPM)	Machining Time	Total Time
	<b>Tool Change.7</b>	10	<b>Tool Desc: T10 Face Mill D 2" Carbide</b>				<b>Tool Stickout:</b>		
27	Facing.4	10	80	3500	11.811	60	20	3' 26"	3' 53"
	<b>Tool Change.8</b>	2	<b>Tool Desc: T2 End Mill D1/2" Carbide 4 Flutes</b>				<b>Tool Stickout:</b>		
28	Pocketing.15	2	160	6000	11.811	60	20	23"	1' 37"
29	Profile Contouring.7	2	160	6000	11.811	60	20	25"	1' 37"
30	Pocketing.14	2	160	6000	11.811	60	20	4"	1' 17"
31	Pocketing.13	2	160	6000	11.811	60	20	4"	1' 17"
32	Pocketing.12	2	160	6000	11.811	60	20	23"	1' 36"
33	Profile Contouring.6	2	160	6000	11.811	60	20	3' 16"	4' 29"
34	Pocketing.17	2	300	6000	11.811	60	20	2' 22"	3' 53"
35	Pocketing.18	2	300	6000	11.811	60	20	2' 4"	2' 26"
36	Pocketing.19	2	300	6000	11.811	60	20	37"	1' 2"
	<b>Tool Change.10</b>	9	<b>Tool Desc: T9 Countersink D 1/4"</b>				<b>Tool Stickout:</b>		
37	Curve Following.9	9	60	6000	11.811	60	60	25"	31"
38	Curve Following.7	9	60	6000	11.811	60	10	4"	13"
								13' 34"	23' 51"

