

CUSTOMER	PART # / REVISION	DESCRIPTION	PROGRAM NAME
TITANS of CNC	TITAN-1M	BUILDING BLOCKS	
OPERATION	MATERIAL	SIZE	CREATED BY / DATE
1	ALUMINUM	1X2 BAR CUT 4.1 +.03/-0	TITANS of CNC 12/01/19

TOOL LIST			
	DESCRIPTION	FLUTES	KENNAMETAL PRODUCT ID
1	<u>STELLRAM 5720 3" SHELL MILL</u>	4	5673338
	<u>CARBIDE MILLING INSERT</u>		5665949
2	<u>.3/8" X 1" X 3" END MILL</u>	3	3870468
3	<u>.1/4" CHAMFER MILL</u>	2	6464004
4	<u>.01772" SOLID CARBIDE DRILL</u>	2	4150202
5	<u>10-32 UNC ROLL TAP</u>	4	5945352

NOTES
USE PARALLELS INSIDE OF HARD JAWS
MATERIAL IS 1.0 HIGH - HOLD .100 TO .200 IN THE HARD JAWS - MAKE SURE YOU HAVE ENOUGH STOCK ABOVE THE JAWS TO PROFILE AROUND THE PART AT Z-.76 DEEP WITHOUT HITTING THE TOOL INTO THE JAW - SOFT JAWS WILL ALSO WORK
X-AXIS 0 IS LEFT EDGE - MOVE IN .050 FROM ROUGH STOCK AND RE-ZERO Y-AXIS IS ON THE BACK DEAD JAW - MOVE IN Y -.050 AND RE-ZERO Z-AXIS IS TOP OF PART - ZERO TOP AND DROP Z -.020 FOR FACING OP

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TITANS of CNC	TITAN-1M	BUILDING BLOCKS	
OPERATION	MATERIAL	SIZE	CREATED BY / DATE
2	ALUMINUM	1X2 BAR CUT 4.1 +.03/-0	TITANS of CNC 12/01/19

**TOOL LIST**

	DESCRIPTION	FLUTES	KENNAMETAL PRODUCT ID
1	<u>STELLRAM 5720 3" SHELL MILL</u>	4	5673338
	<u>CARBIDE MILLING INSERT</u>		5665949
2	<u>1/4" CHAMFER MILL</u>	2	6464004

**NOTES**

THE XY 0 IS UP/LEFT

Z 0 IS TOP OF FINISHED PART (.750 ABOVE PARALLELS)

PART FLIPPED 180 DEGREES FROM LEFT TO RIGHT  
WITH A LEFT/HAND STOP

HOLD .500 DEEP IN HARD JAWS (1.75 HIGH HARD JAWS WITH 1.25 PARALLELS)