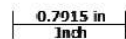




## GENERAL INFORMATION

REVISION:

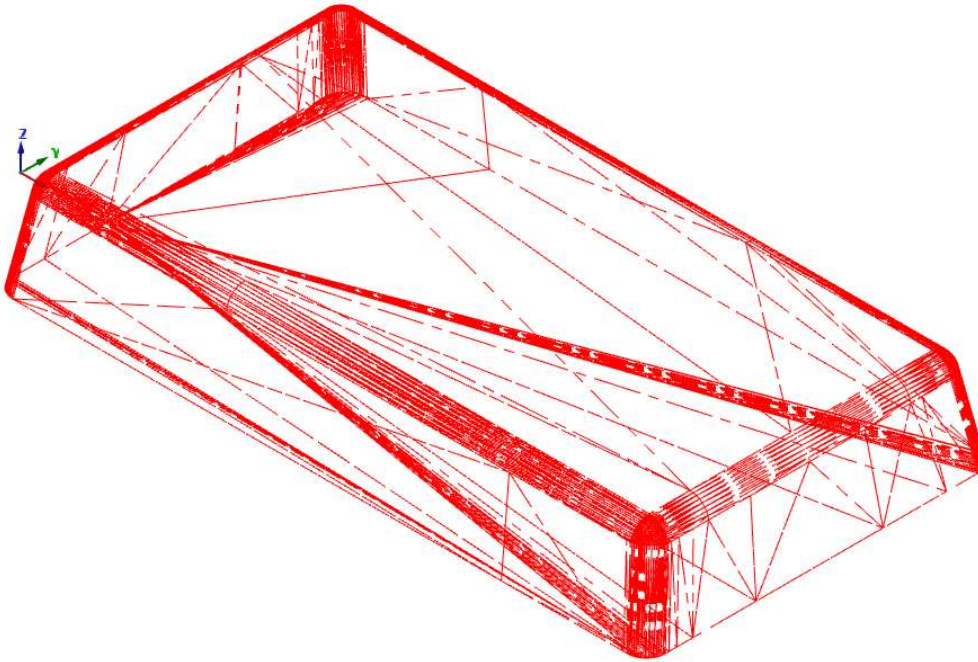


## COMMENTS

[illegible]

STOCK

---



STOCK:	YES
SHAPE:	Solid
SIZE:	8.2935, 4.4555, 1.25
RADIUS:	
LENGTH:	
AXIS:	NA
FILE:	
IDN:	6949

C:\USERS\WESTONSHAKESPEAR\DOCUMENTS\MY

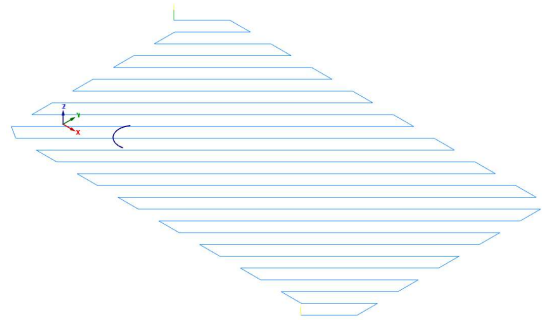
CYCLE TIME: 0 HOURS, 8 MINUTES, 28 SECONDS

### OPERATION LIST

OPERATION INFO 1 - Facing

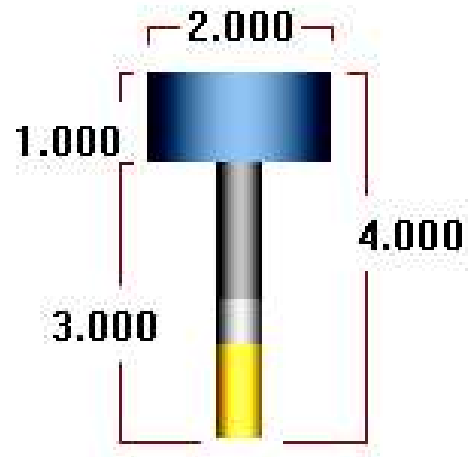
CYCLE TIME: 0 HOURS, 1 MINUTES, 30 SECONDS  
COMMENT:

PROGRAM NUMBER: 0  
SPINDLE SPEED: 4966 RPM  
FEEDRATE: 60.0 inch/min  
CLEARANCE PLANE: 2.0  
RETRACT PLANE: 0.125  
FEED PLANE: 0.05  
DEPTH: 0.0  
STOCK TO LEAVE: 0.0  
COMP TO TIP: YES  
WORK OFFSET: 0



TOOL INFO 1/2 FLAT ENDMILL

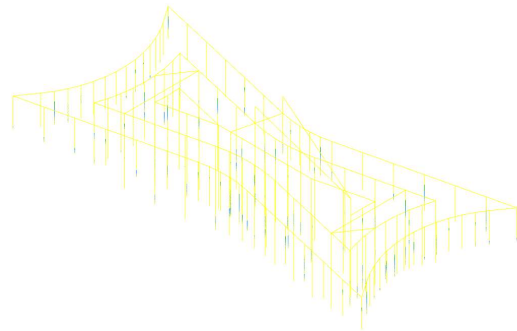
TYPE: Flat endmill  
NUMBER: 1  
DIAMETER: 0.5  
CORNER RADIUS: 0.0  
LENGTH OFFSET: 1  
DIAMETER OFFSET: 1  
MATERIAL: HSS  
NUMBER OF FLUTES: 4  
FPT: 0.0025 SFM: 650.0  
MFG CODE:  
ASSEMBLY:  
HOLDER: Default Holder  
TIME: 00:01:30



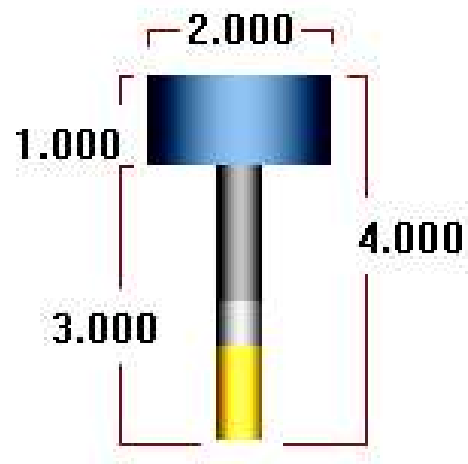
**OPERATION INFO****3 - Surface Rough Plunge**

CYCLE TIME: 0 HOURS, 2 MINUTES, 5 SECONDS  
COMMENT:

PROGRAM NUMBER: 0  
SPINDLE SPEED: 4966 RPM  
FEEDRATE: 50.0 inch/min  
CLEARANCE PLANE: 0.25  
RETRACT PLANE: 0.125  
FEED PLANE: 0.05  
DEPTH: NA  
STOCK TO LEAVE: 0.0 0.02  
COMP TO TIP: YES  
WORK OFFSET: 0

**TOOL INFO****1/2 FLAT ENDMILL**

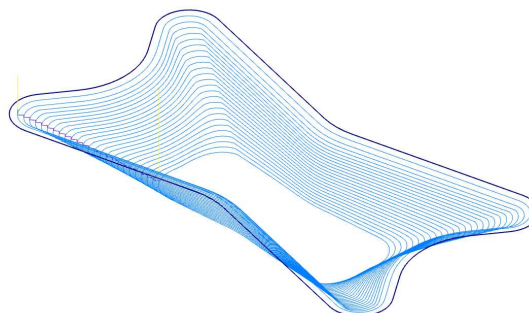
TYPE: Flat endmill  
NUMBER: 1  
DIAMETER: 0.5  
CORNER RADIUS: 0.0  
LENGTH OFFSET: 1  
DIAMETER OFFSET: 1  
MATERIAL: HSS  
NUMBER OF FLUTES: 4  
FPT: 0.0025 SFM: 650.0  
MFG CODE:  
ASSEMBLY:  
HOLDER: Default Holder  
TIME: 00:02:05



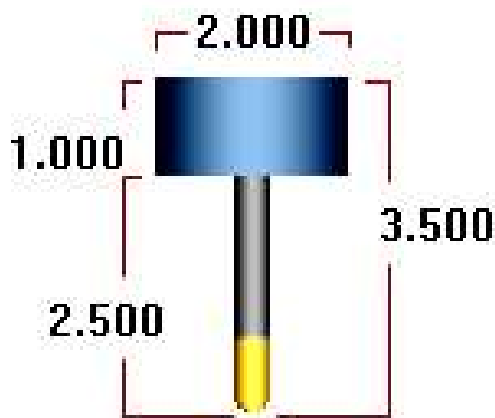
**OPERATION INFO****4 - Surface Finish Contour**

CYCLE TIME: 0 HOURS, 4 MINUTES, 26 SECONDS  
COMMENT:

PROGRAM NUMBER: 0  
SPINDLE SPEED: 6621 RPM  
FEEDRATE: 45.0 inch/min  
CLEARANCE PLANE: 0.25  
RETRACT PLANE: 0.125  
FEED PLANE: 0.05  
DEPTH: NA  
STOCK TO LEAVE: 0.0  
COMP TO TIP: YES  
WORK OFFSET: 0

**TOOL INFO****3/8 BALL ENDMILL**

TYPE: Ball endmill  
NUMBER: 2  
DIAMETER: 0.375  
CORNER RADIUS: 0.1875  
LENGTH OFFSET: 2  
DIAMETER OFFSET: 2  
MATERIAL: HSS  
NUMBER OF FLUTES: 4  
FPT: 0.0011 SFM: 139.9869  
MFG CODE:  
ASSEMBLY:  
HOLDER: Default Holder  
TIME: 00:04:26

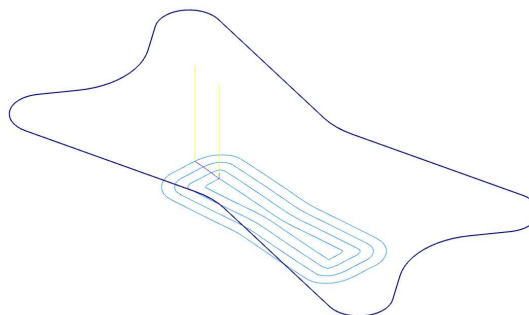


# *OPERATION INFO*

## *5 - Surface Finish Shallow*

CYCLE TIME: 0 HOURS, 0 MINUTES, 19 SECONDS  
COMMENT:

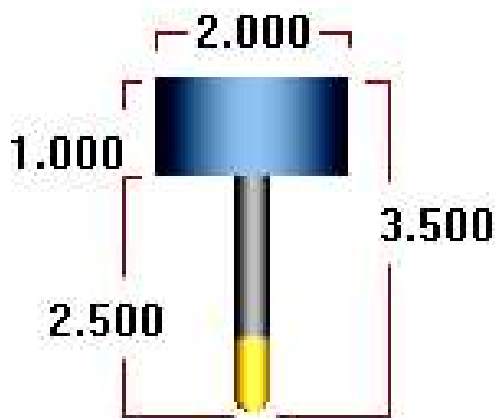
PROGRAM NUMBER: 0  
SPINDLE SPEED: 4966 RPM  
FEEDRATE: 50.0 inch/min  
CLEARANCE PLANE: 0.25  
RETRACT PLANE: 0.125  
FEED PLANE: 0.05  
DEPTH: NA  
STOCK TO LEAVE: 0.0  
COMP TO TIP: YES  
WORK OFFSET: 0



# *TOOL INFO*

## *3/8 BALL ENDMILL*

TYPE: Ball endmill  
NUMBER: 2  
DIAMETER: 0.375  
CORNER RADIUS: 0.1875  
LENGTH OFFSET: 2  
DIAMETER OFFSET: 2  
MATERIAL: HSS  
NUMBER OF FLUTES: 4  
FPT: 0.0011 SFM: 139.9869  
MFG CODE:  
ASSEMBLY:  
HOLDER: Default Holder  
TIME: 00:00:19

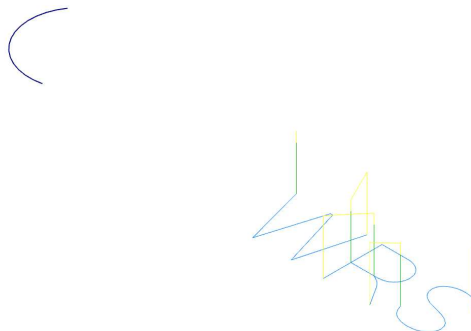


# OPERATION INFO

## 6 - Contour (2D)

CYCLE TIME: 0 HOURS, 0 MINUTES, 6 SECONDS  
COMMENT:

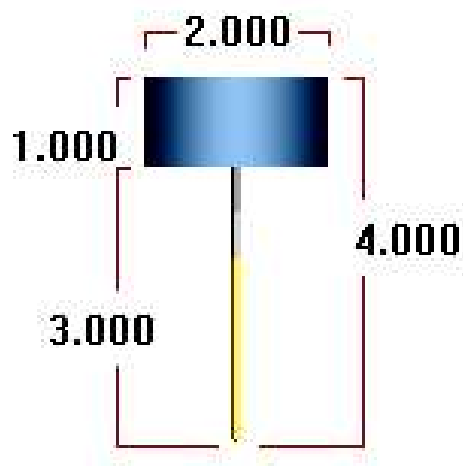
PROGRAM NUMBER: 0  
SPINDLE SPEED: 10000 RPM  
FEEDRATE: 35.0 inch/min  
CLEARANCE PLANE: 2.0  
RETRACT PLANE: 0.25  
FEED PLANE: 0.2  
DEPTH: -0.02  
STOCK TO LEAVE: 0.0  
COMP TO TIP: YES  
WORK OFFSET: 0



# TOOL INFO

## 1/8 SPOTDRILL

TYPE: Spot drill  
NUMBER: 3  
DIAMETER: 0.125  
CORNER RADIUS: 0.0  
LENGTH OFFSET: 3  
DIAMETER OFFSET: 3  
MATERIAL: HSS  
NUMBER OF FLUTES: 2  
FPT: 0.0024 SFM: 162.5  
MFG CODE:  
ASSEMBLY:  
HOLDER: Default Holder  
TIME: 00:00:06

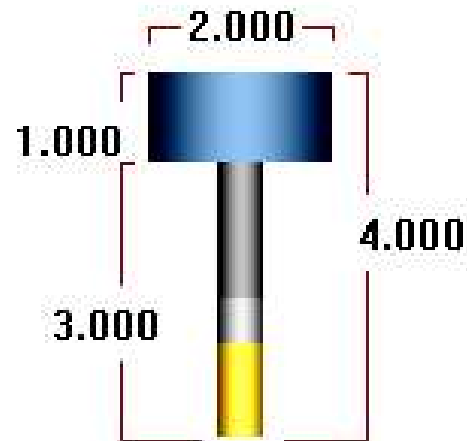


**TOOL LIST**

Sorted: NO

**TOOL INFO****1/2 FLAT ENDMILL**

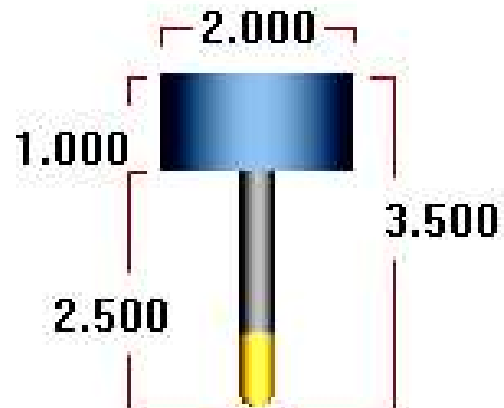
TYPE: Flat endmill  
NUMBER: 1  
DIAMETER: 0.5  
CORNER RADIUS: 0.0  
LENGTH OFFSET: 1  
DIAMETER OFFSET: 1  
MATERIAL: HSS  
NUMBER OF FLUTES: 4  
FPT: 0.0025 SFM: 650.0  
MFG CODE:  
ASSEMBLY:  
HOLDER: Default Holder  
TIME: 00:03:35



USED BY OPERATION: # 1 1 - Facing  
USED BY OPERATION: # 3 3 - Surface Rough Plunge

**TOOL INFO****3/8 BALL ENDMILL**

TYPE: Ball endmill  
NUMBER: 2  
DIAMETER: 0.375  
CORNER RADIUS: 0.1875  
LENGTH OFFSET: 2  
DIAMETER OFFSET: 2  
MATERIAL: HSS  
NUMBER OF FLUTES: 4  
FPT: 0.0011 SFM: 139.9869  
MFG CODE:  
ASSEMBLY:  
HOLDER: Default Holder  
TIME: 00:04:45

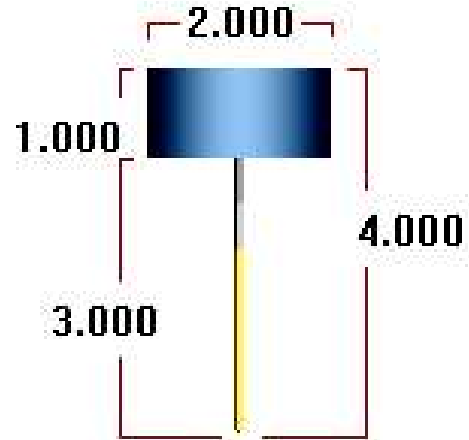


USED BY OPERATION: # 4 4 - Surface Finish Contour  
USED BY OPERATION: # 5 5 - Surface Finish Shallow



**TOOL INFO****1/8 SPOTDRILL**

TYPE:	Spot drill
NUMBER:	3
DIAMETER:	0.125
CORNER RADIUS:	0.0
LENGTH OFFSET:	3
DIAMETER OFFSET:	3
MATERIAL:	HSS
NUMBER OF FLUTES:	2
FPT: 0.0024	SFM: 162.5
MFG CODE:	
ASSEMBLY:	
HOLDER:	Default Holder
TIME:	00:00:06



USED BY OPERATION:	# 6	6 - Contour (2D)
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**WORK OFFSETS****OFFSET INFO**

NUMBER: 0	PLANE: Top	ORIGIN: 0.0, 0.0, 0.0
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USED BY OPERATION:	# 1	1 - Facing
USED BY OPERATION:	# 3	3 - Surface Rough Plunge
USED BY OPERATION:	# 4	4 - Surface Finish Contour
USED BY OPERATION:	# 5	5 - Surface Finish Shallow
USED BY OPERATION:	# 6	6 - Contour (2D)