



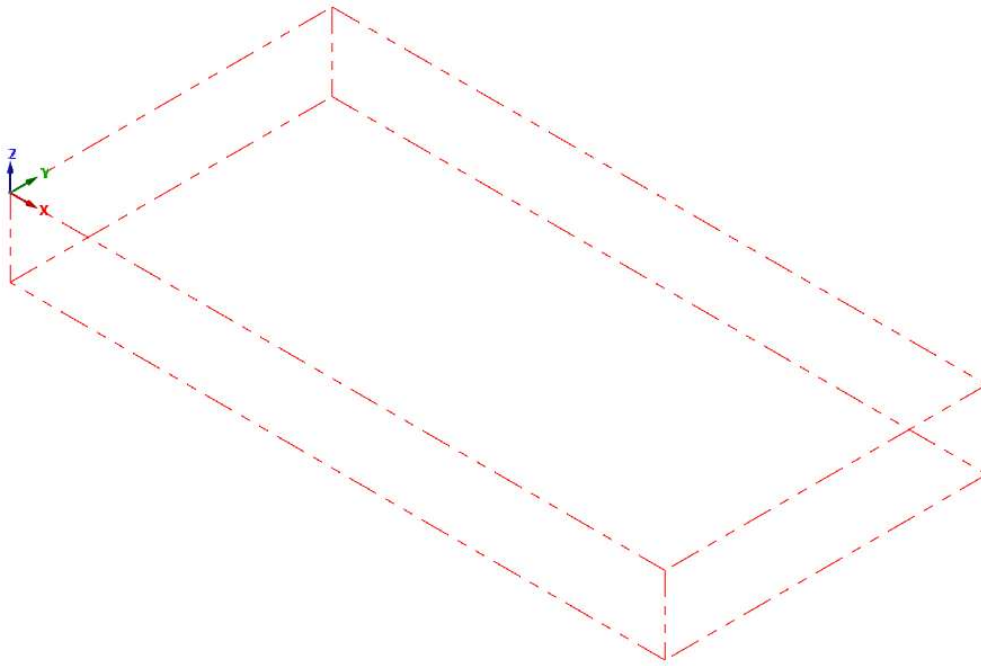
GENERAL INFORMATION

REVISION:

0.8807 in
Inch

COMMENTS

[illegible]



STOCK:	YES
SHAPE:	Box
SIZE:	7.375, 3.625, 0.875
RADIUS:	NA
LENGTH:	
AXIS:	NA
FILE:	
IDN:	NA

C:\USERS\WESTONSHAKESPEAR\DOCUMENTS\MY

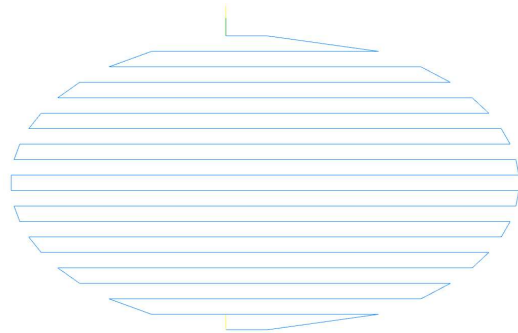
CYCLE TIME: 0 HOURS, 17 MINUTES, 35 SECONDS

OPERATION LIST

OPERATION INFO 1 - Facing

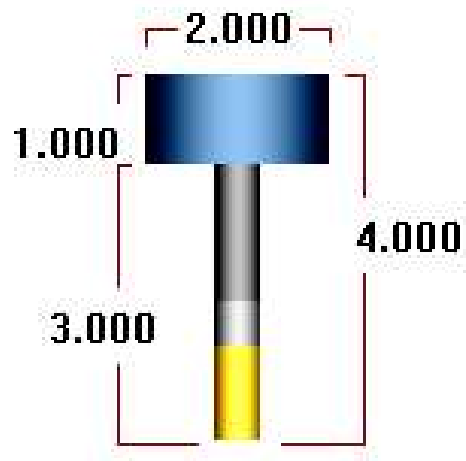
CYCLE TIME: 0 HOURS, 1 MINUTES, 10 SECONDS
COMMENT:

PROGRAM NUMBER: 0
SPINDLE SPEED: 5000 RPM
FEEDRATE: 49.0 inch/min
CLEARANCE PLANE: 2.0
RETRACT PLANE: 0.125
FEED PLANE: 0.025
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: 0.0015 SFM: 139.9215
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:01:10

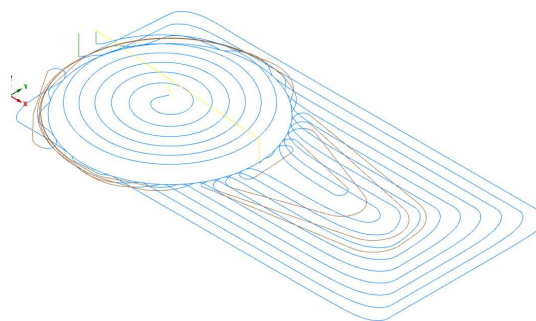


OPERATION INFO

2 - 2D High Speed (2D Dynamic Mill)

CYCLE TIME: 0 HOURS, 3 MINUTES, 43 SECONDS
COMMENT:

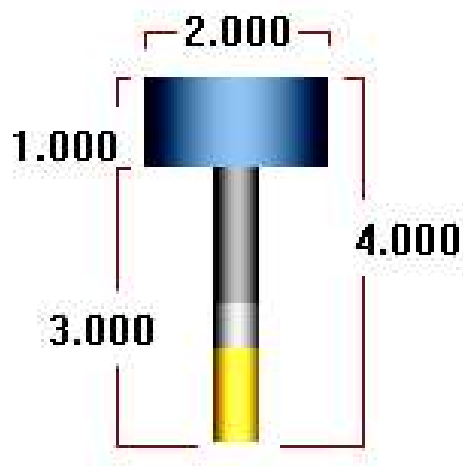
PROGRAM NUMBER: 0
SPINDLE SPEED: 4966 RPM
FEEDRATE: 49.0 inch/min
CLEARANCE PLANE: 0.0
RETRACT PLANE: 0.125
FEED PLANE: 0.1
DEPTH: 0.0
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET: 0



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: 0.0015 SFM: 139.9215
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:03:43

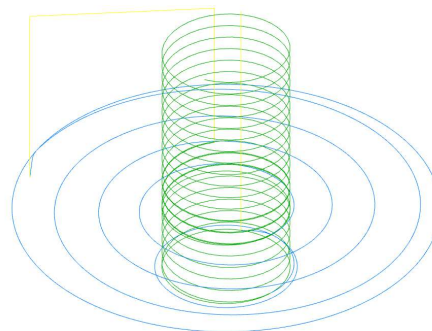


OPERATION INFO

3 - 2D High Speed (2D Dynamic Rest Mill)

CYCLE TIME: 0 HOURS, 1 MINUTES, 2 SECONDS
COMMENT:

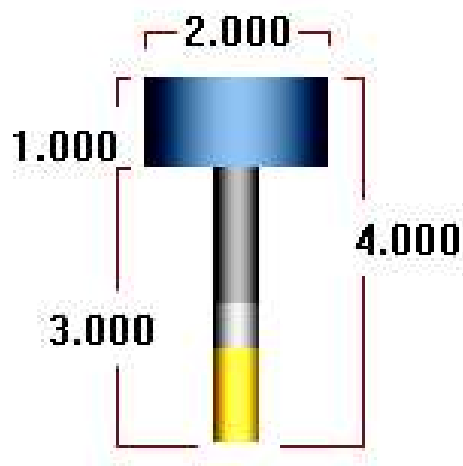
PROGRAM NUMBER: 0
SPINDLE SPEED: 4966 RPM
FEEDRATE: 49.0 inch/min
CLEARANCE PLANE: 0.0
RETRACT PLANE: 0.125
FEED PLANE: 0.1
DEPTH: 0.0
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET: 0



TOOL INFO

1/2 FLAT ENDMILL

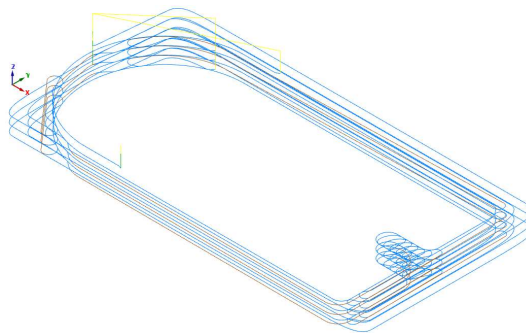
TYPE: Flat endmill
NUMBER: 1
DIAMETER: 0.5
CORNER RADIUS: 0.0
LENGTH OFFSET: 1
DIAMETER OFFSET: 1
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.0015 SFM: 139.9215
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:01:02



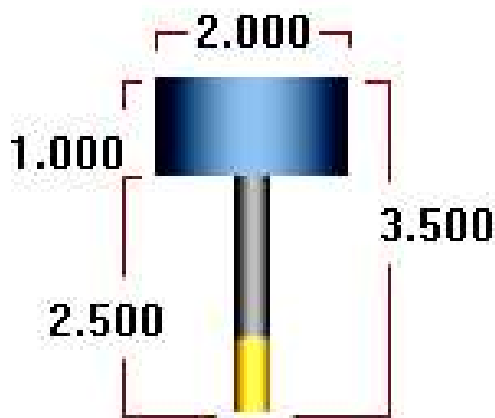
OPERATION INFO**4 - 2D High Speed (2D Dynamic Rest Mill)**

CYCLE TIME: 0 HOURS, 5 MINUTES, 51 SECONDS
COMMENT:

PROGRAM NUMBER: 0
SPINDLE SPEED: 6621 RPM
FEEDRATE: 49.0 inch/min
CLEARANCE PLANE: 0.0
RETRACT PLANE: 0.125
FEED PLANE: 0.1
DEPTH: 0.0
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET: 0

**TOOL INFO****3/8 FLAT ENDMILL**

TYPE: Flat endmill
NUMBER: 2
DIAMETER: 0.375
CORNER RADIUS: 0.0
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: 00:05:51

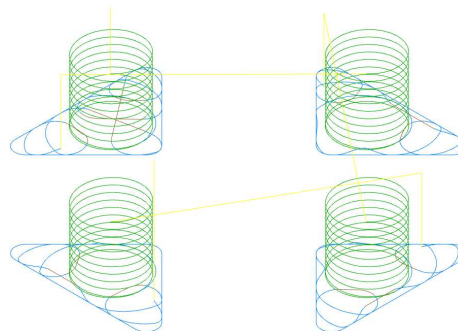


OPERATION INFO

5 - 2D High Speed (2D Dynamic Rest Mill)

CYCLE TIME: 0 HOURS, 1 MINUTES, 24 SECONDS
COMMENT:

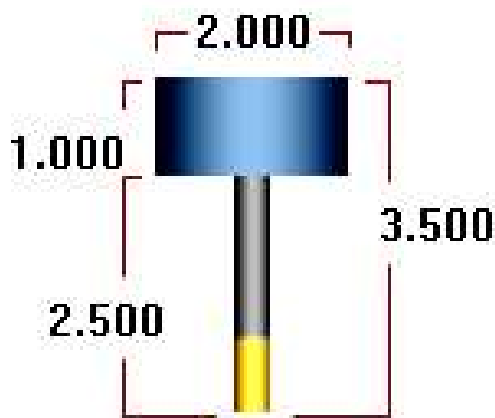
PROGRAM NUMBER: 0
SPINDLE SPEED: 4966 RPM
FEEDRATE: 49.0 inch/min
CLEARANCE PLANE: 0.125
RETRACT PLANE: 0.0625
FEED PLANE: 0.05
DEPTH: 0.0
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET: 0



TOOL INFO

3/8 FLAT ENDMILL

TYPE: Flat endmill
NUMBER: 2
DIAMETER: 0.375
CORNER RADIUS: 0.0
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: 00:01:24

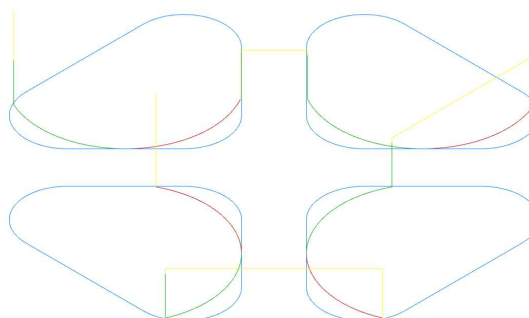


OPERATION INFO

6 - Contour (2D chamfer)

CYCLE TIME: 0 HOURS, 0 MINUTES, 55 SECONDS
COMMENT:

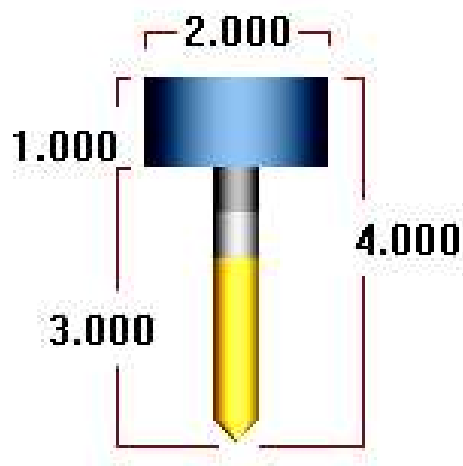
PROGRAM NUMBER: 0
SPINDLE SPEED: 4966 RPM
FEEDRATE: 20.0 inch/min
CLEARANCE PLANE: 0.125
RETRACT PLANE: 0.25
FEED PLANE: 0.2
DEPTH: 0.0
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET: 0



TOOL INFO

1/2 SPOTDRILL

TYPE: Spot drill
NUMBER: 3
DIAMETER: 0.5
CORNER RADIUS: 0.0
LENGTH OFFSET: 3
DIAMETER OFFSET: 3
MATERIAL: HSS
NUMBER OF FLUTES: 2
FPT: 0.001 SFM: 69.8953
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:00:55

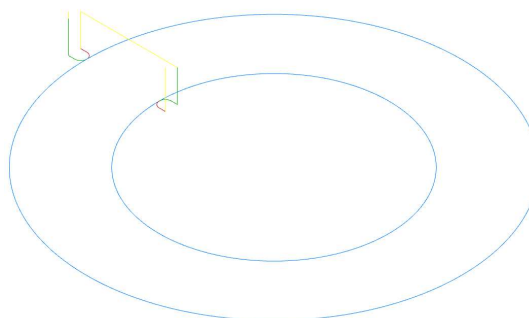


OPERATION INFO

7 - Contour (2D chamfer)

CYCLE TIME: 0 HOURS, 0 MINUTES, 50 SECONDS
COMMENT:

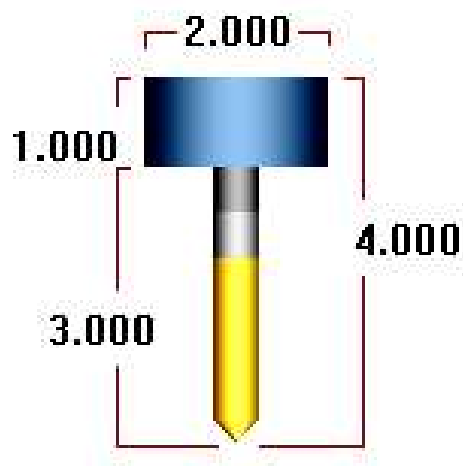
PROGRAM NUMBER: 0
SPINDLE SPEED: 4966 RPM
FEEDRATE: 20.0 inch/min
CLEARANCE PLANE: 0.125
RETRACT PLANE: 0.25
FEED PLANE: 0.2
DEPTH: 0.0
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET: 0



TOOL INFO

1/2 SPOTDRILL

TYPE: Spot drill
NUMBER: 3
DIAMETER: 0.5
CORNER RADIUS: 0.0
LENGTH OFFSET: 3
DIAMETER OFFSET: 3
MATERIAL: HSS
NUMBER OF FLUTES: 2
FPT: 0.001 SFM: 69.8953
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:00:50

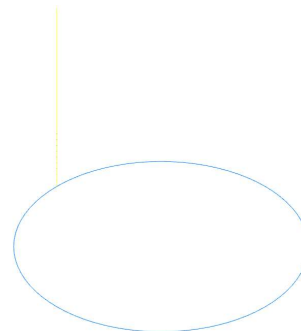


OPERATION INFO

8 - Contour (2D chamfer)

CYCLE TIME: 0 HOURS, 0 MINUTES, 10 SECONDS
COMMENT:

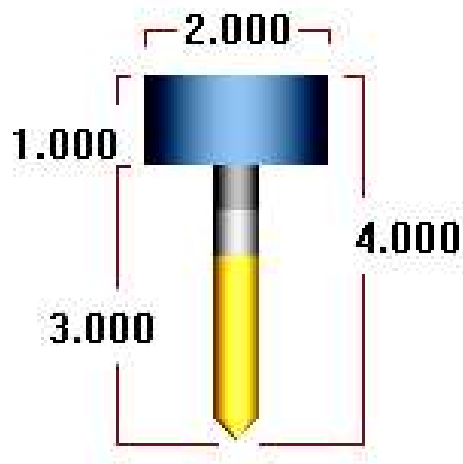
PROGRAM NUMBER: 0
SPINDLE SPEED: 4966 RPM
FEEDRATE: 20.0 inch/min
CLEARANCE PLANE: 0.125
RETRACT PLANE: 0.25
FEED PLANE: 0.2
DEPTH: 0.0
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET: 0



TOOL INFO

1/2 SPOTDRILL

TYPE: Spot drill
NUMBER: 3
DIAMETER: 0.5
CORNER RADIUS: 0.0
LENGTH OFFSET: 3
DIAMETER OFFSET: 3
MATERIAL: HSS
NUMBER OF FLUTES: 2
FPT: 0.001 SFM: 69.8953
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:00:10

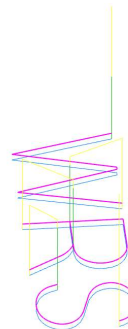


OPERATION INFO

9 - Contour (2D)

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

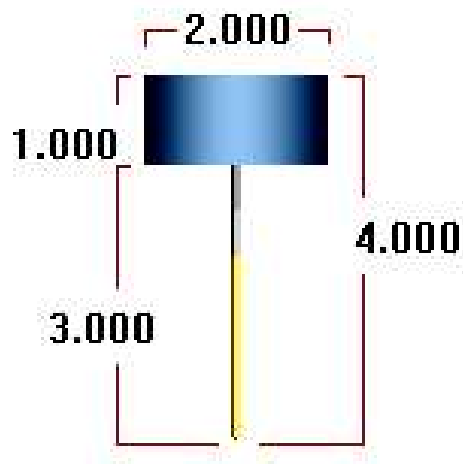
PROGRAM NUMBER: 0
SPINDLE SPEED: 4966 RPM
FEEDRATE: 49.0 inch/min
CLEARANCE PLANE: 0.125
RETRACT PLANE: 0.25
FEED PLANE: 0.2
DEPTH: -0.02
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET: 0



TOOL INFO

1/8 SPOTDRILL

TYPE: Spot drill
NUMBER: 4
DIAMETER: 0.125
CORNER RADIUS: 0.0
LENGTH OFFSET: 4
DIAMETER OFFSET: 4
MATERIAL: HSS
NUMBER OF FLUTES: 2
FPT: 0.0002 SFM: 69.9935
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:00:05

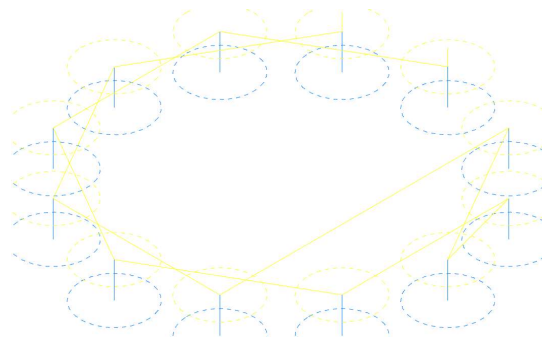


OPERATION INFO

10 - Drill/Counterbore

CYCLE TIME: 0 HOURS, 0 MINUTES, 10 SECONDS
COMMENT:

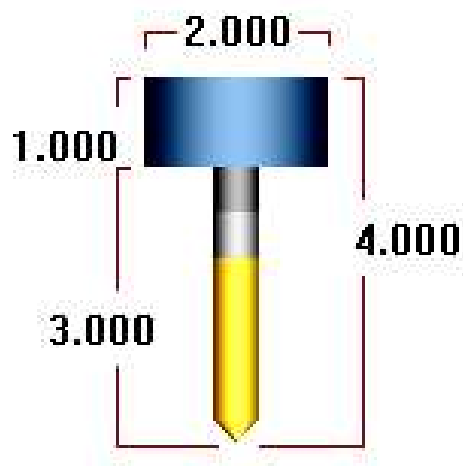
PROGRAM NUMBER: 0
SPINDLE SPEED: 9932 RPM
FEEDRATE: 19.0712 inch/min
CLEARANCE PLANE: 0.125
RETRACT PLANE: 0.125
FEED PLANE: 0.125
DEPTH: -0.14
STOCK TO LEAVE: 0.0
COMP TO TIP: NO
WORK OFFSET: 0



TOOL INFO

1/2 SPOTDRILL

TYPE: Spot drill
NUMBER: 3
DIAMETER: 0.5
CORNER RADIUS: 0.0
LENGTH OFFSET: 3
DIAMETER OFFSET: 3
MATERIAL: HSS
NUMBER OF FLUTES: 2
FPT: 0.001 SFM: 69.8953
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:00:10

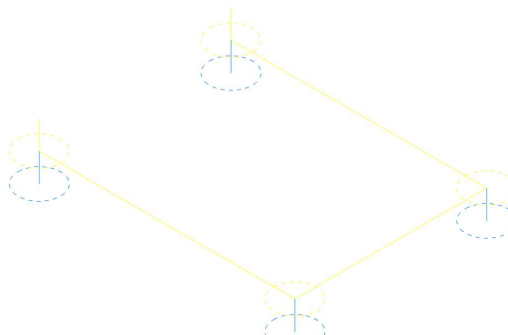


OPERATION INFO

11 - Drill/Counterbore

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

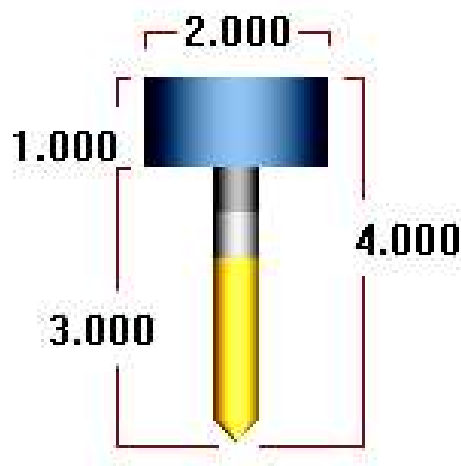
PROGRAM NUMBER: 0
SPINDLE SPEED: 9932 RPM
FEEDRATE: 19.0712 inch/min
CLEARANCE PLANE: 0.125
RETRACT PLANE: 0.125
FEED PLANE: 0.125
DEPTH: -0.208
STOCK TO LEAVE: 0.0
COMP TO TIP: NO
WORK OFFSET: 0



TOOL INFO

1/2 SPOTDRILL

TYPE: Spot drill
NUMBER: 3
DIAMETER: 0.5
CORNER RADIUS: 0.0
LENGTH OFFSET: 3
DIAMETER OFFSET: 3
MATERIAL: HSS
NUMBER OF FLUTES: 2
FPT: 0.001 SFM: 69.8953
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:00:04

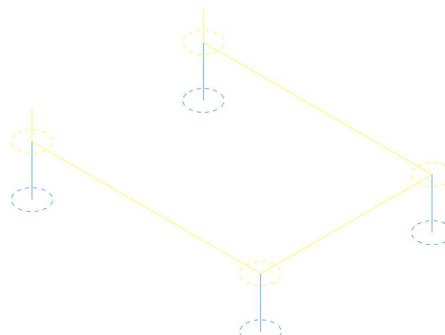


OPERATION INFO

12 - Peck Drill

CYCLE TIME: 0 HOURS, 0 MINUTES, 24 SECONDS
COMMENT:

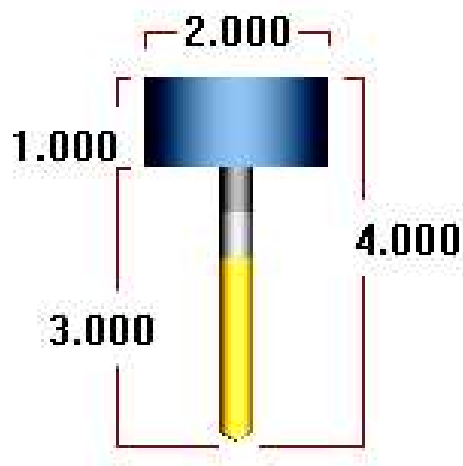
PROGRAM NUMBER: 0
SPINDLE SPEED: 3216 RPM
FEEDRATE: 10.0 inch/min
CLEARANCE PLANE: 0.125
RETRACT PLANE: 0.0625
FEED PLANE: 0.0625
DEPTH: -0.0965
STOCK TO LEAVE: 0.0
COMP TO TIP: NO
WORK OFFSET: 0



TOOL INFO

LTR. W DRILL

TYPE: Drill
NUMBER: 5
DIAMETER: 0.386
CORNER RADIUS: 0.0
LENGTH OFFSET: 5
DIAMETER OFFSET: 5
MATERIAL: HSS
NUMBER OF FLUTES: 2
FPT: 0.003 SFM: 69.9246
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:00:24

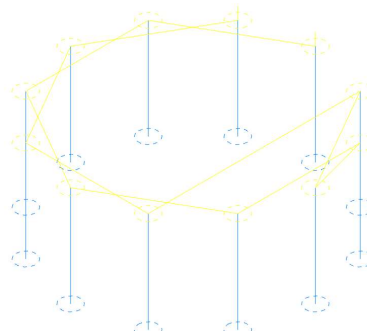


OPERATION INFO

13 - Peck Drill

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

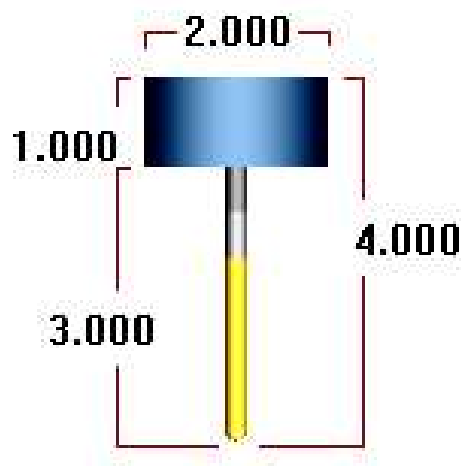
PROGRAM NUMBER: 0
SPINDLE SPEED: 600 RPM
FEEDRATE: 30.0 inch/min
CLEARANCE PLANE: 0.125
RETRACT PLANE: 0.125
FEED PLANE: 0.125
DEPTH: -0.201
STOCK TO LEAVE: 0.0
COMP TO TIP: NO
WORK OFFSET: 0



TOOL INFO

NO. 7 DRILL

TYPE: Drill
NUMBER: 6
DIAMETER: 0.201
CORNER RADIUS: 0.0
LENGTH OFFSET: 6
DIAMETER OFFSET: 6
MATERIAL: HSS
NUMBER OF FLUTES: 2
FPT: 0.0048 SFM: 399.9479
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:01:00

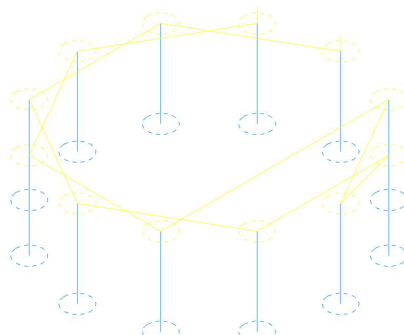


OPERATION INFO

14 - Tap

CYCLE TIME: 0 HOURS, 0 MINUTES, 39 SECONDS
COMMENT:

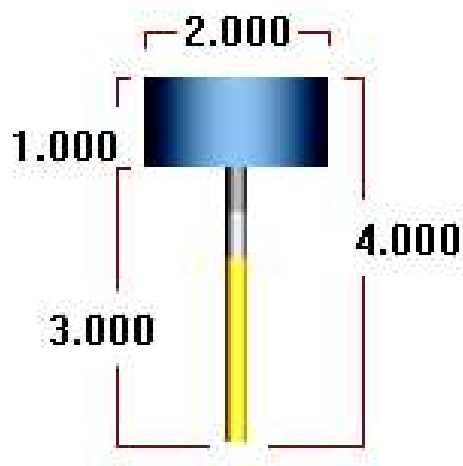
PROGRAM NUMBER: 0
SPINDLE SPEED: 600 RPM
FEEDRATE: 30.0 inch/min
CLEARANCE PLANE: 0.125
RETRACT PLANE: 0.125
FEED PLANE: 0.125
DEPTH: 0.0
STOCK TO LEAVE: 0.0
COMP TO TIP: NO
WORK OFFSET: 0



TOOL INFO

1/4-20 TAPRH

TYPE: Right-hand tap
NUMBER: 7
DIAMETER: 0.25
CORNER RADIUS: 0.0
LENGTH OFFSET: 7
DIAMETER OFFSET: 7
MATERIAL: Carbide
NUMBER OF FLUTES: 1
FPT: 0.05 SFM: 17.4738
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:00:39

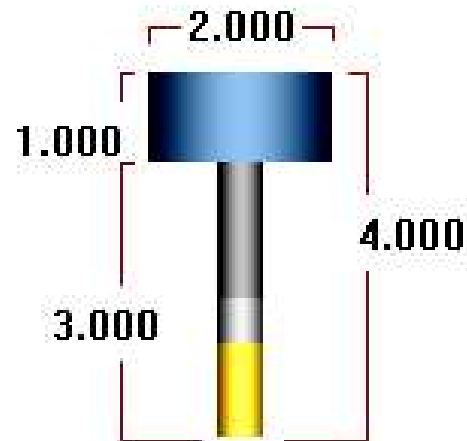


TOOL LIST

Sorted: NO

TOOL INFO**1/2 FLAT ENDMILL**

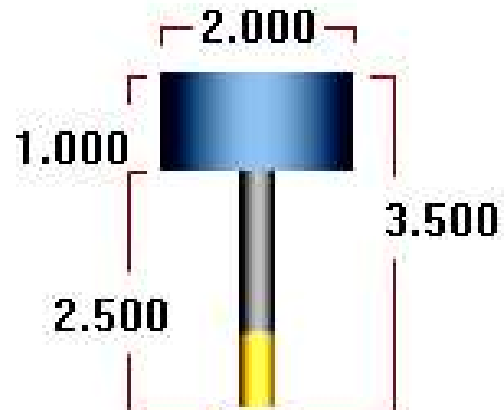
TYPE: Flat endmill
NUMBER: 1
DIAMETER: 0.5
CORNER RADIUS: 0.0
LENGTH OFFSET: 1
DIAMETER OFFSET: 1
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.0015 SFM: 139.9215
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:05:57



USED BY OPERATION: # 1 1 - Facing
USED BY OPERATION: # 2 2 - 2D High Speed (2D Dynamic Mill)
USED BY OPERATION: # 3 3 - 2D High Speed (2D Dynamic Rest Mill)

TOOL INFO**3/8 FLAT ENDMILL**

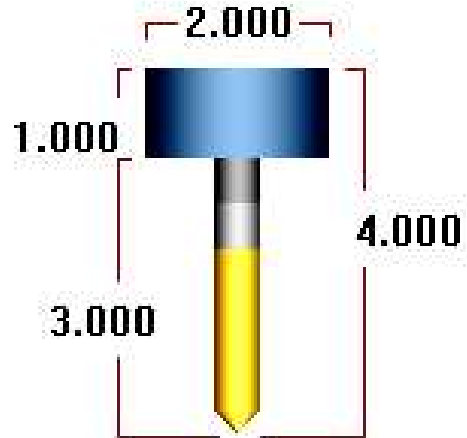
TYPE: Flat endmill
NUMBER: 2
DIAMETER: 0.375
CORNER RADIUS: 0.0
LENGTH OFFSET: 2
DIAMETER OFFSET: 2
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.0011 SFM: 139.9869
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:07:15



USED BY OPERATION: # 4 4 - 2D High Speed (2D Dynamic Rest Mill)
USED BY OPERATION: # 5 5 - 2D High Speed (2D Dynamic Rest Mill)

TOOL INFO**1/2 SPOTDRILL**

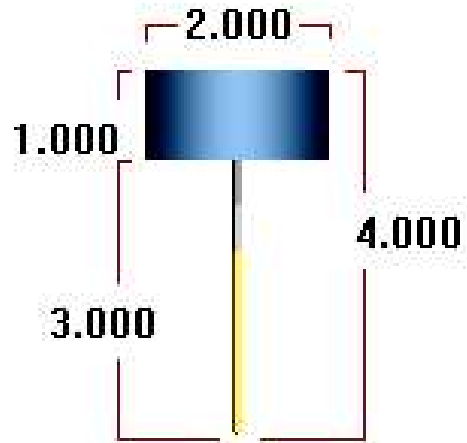
TYPE: Spot drill
NUMBER: 3
DIAMETER: 0.5
CORNER RADIUS: 0.0
LENGTH OFFSET: 3
DIAMETER OFFSET: 3
MATERIAL: HSS
NUMBER OF FLUTES: 2
FPT: 0.001 SFM: 69.8953
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:02:11



USED BY OPERATION: # 6 6 - Contour (2D chamfer)
USED BY OPERATION: # 7 7 - Contour (2D chamfer)
USED BY OPERATION: # 8 8 - Contour (2D chamfer)
USED BY OPERATION: # 10 10 - Drill/Counterbore
USED BY OPERATION: # 11 11 - Drill/Counterbore

TOOL INFO**1/8 SPOTDRILL**

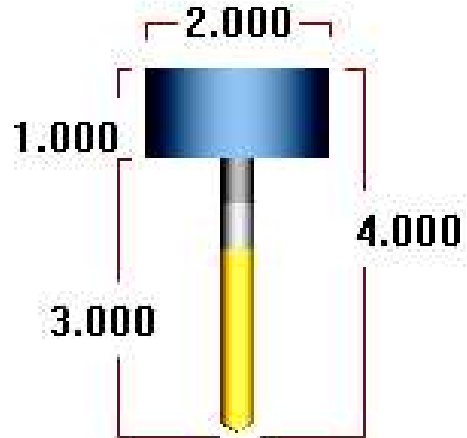
TYPE: Spot drill
NUMBER: 4
DIAMETER: 0.125
CORNER RADIUS: 0.0
LENGTH OFFSET: 4
DIAMETER OFFSET: 4
MATERIAL: HSS
NUMBER OF FLUTES: 2
FPT: 0.0002 SFM: 69.9935
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:00:05



USED BY OPERATION: # 9 9 - Contour (2D)

TOOL INFO**LTR. W DRILL**

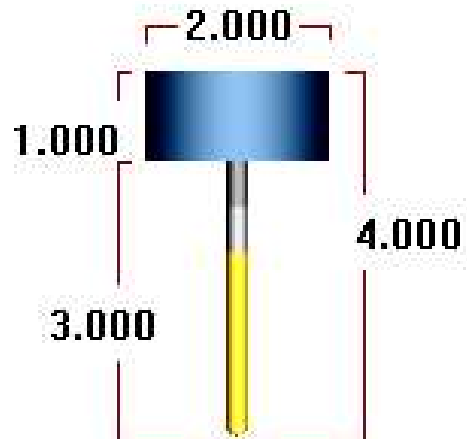
TYPE:	Drill
NUMBER:	5
DIAMETER:	0.386
CORNER RADIUS:	0.0
LENGTH OFFSET:	5
DIAMETER OFFSET:	5
MATERIAL:	HSS
NUMBER OF FLUTES:	2
FPT: 0.003	SFM: 69.9246
MFG CODE:	
ASSEMBLY:	
HOLDER:	Default Holder
TIME:	00:00:24



USED BY OPERATION: # 12 12 - Peck Drill

TOOL INFO**NO. 7 DRILL**

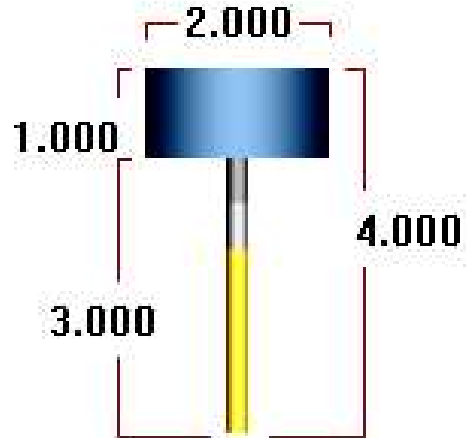
TYPE:	Drill
NUMBER:	6
DIAMETER:	0.201
CORNER RADIUS:	0.0
LENGTH OFFSET:	6
DIAMETER OFFSET:	6
MATERIAL:	HSS
NUMBER OF FLUTES:	2
FPT: 0.0048	SFM: 399.9479
MFG CODE:	
ASSEMBLY:	
HOLDER:	Default Holder
TIME:	00:01:00



USED BY OPERATION: # 13 13 - Peck Drill

TOOL INFO**1/4-20 TAPRH**

TYPE:	Right-hand tap
NUMBER:	7
DIAMETER:	0.25
CORNER RADIUS:	0.0
LENGTH OFFSET:	7
DIAMETER OFFSET:	7
MATERIAL:	Carbide
NUMBER OF FLUTES:	1
FPT: 0.05	SFM: 17.4738
MFG CODE:	
ASSEMBLY:	
HOLDER:	Default Holder
TIME:	00:00:39



USED BY OPERATION: # 14 14 - Tap

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:	# 2	2 - 2D High Speed (2D Dynamic Mill)
USED BY OPERATION:	# 3	3 - 2D High Speed (2D Dynamic Rest Mill)
USED BY OPERATION:	# 4	4 - 2D High Speed (2D Dynamic Rest Mill)
USED BY OPERATION:	# 5	5 - 2D High Speed (2D Dynamic Rest Mill)
USED BY OPERATION:	# 6	6 - Contour (2D chamfer)
USED BY OPERATION:	# 7	7 - Contour (2D chamfer)
USED BY OPERATION:	# 8	8 - Contour (2D chamfer)
USED BY OPERATION:	# 9	9 - Contour (2D)
USED BY OPERATION:	# 10	10 - Drill/Counterbore
USED BY OPERATION:	# 11	11 - Drill/Counterbore
USED BY OPERATION:	# 12	12 - Peck Drill
USED BY OPERATION:	# 13	13 - Peck Drill
USED BY OPERATION:	# 14	14 - Tap