



## GENERAL INFORMATION

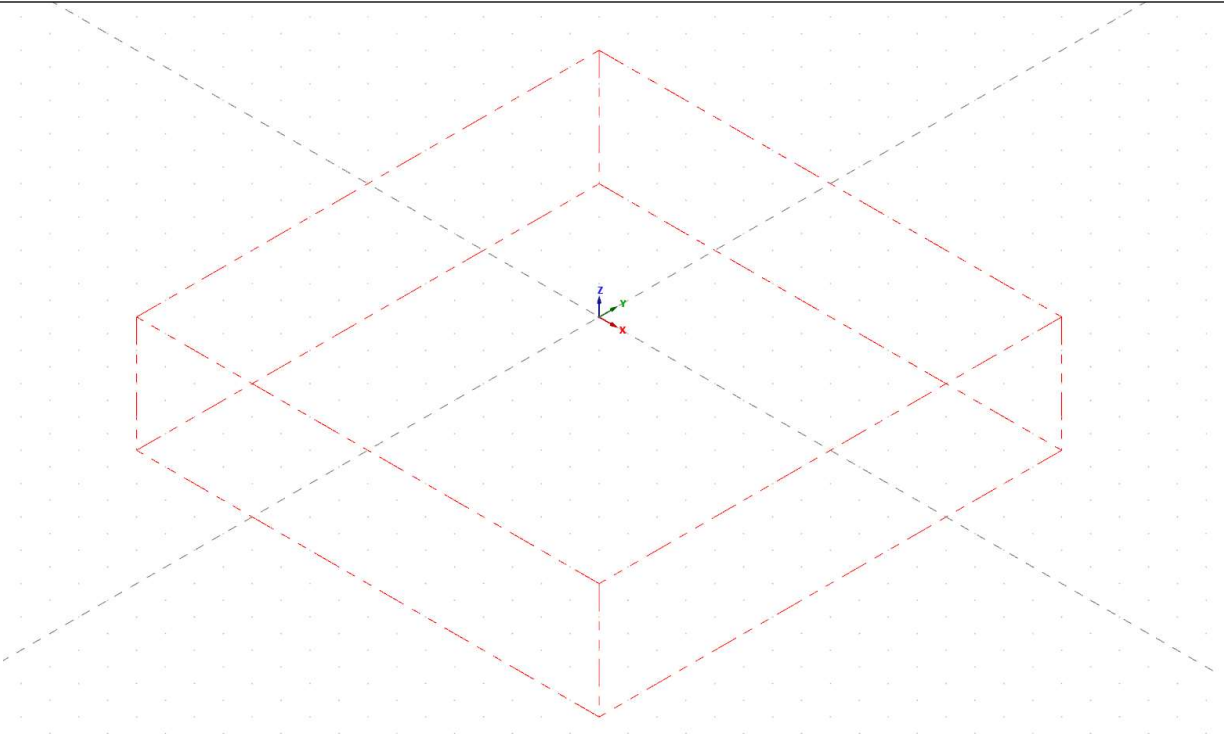
REVISION:

## COMMENTS

[illegible]

*STOCK*

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|               |               |
|---------------|---------------|
| <b>STOCK:</b> | YES           |
| SHAPE:        | Box           |
| SIZE:         | 4.0, 4.0, 1.0 |
| RADIUS:       | NA            |
| LENGTH:       |               |
| AXIS:         | NA            |
| FILE:         |               |
| IDN:          | NA            |

## C:\USERS\WES\DOCUMENTS\MY MASTERCAM

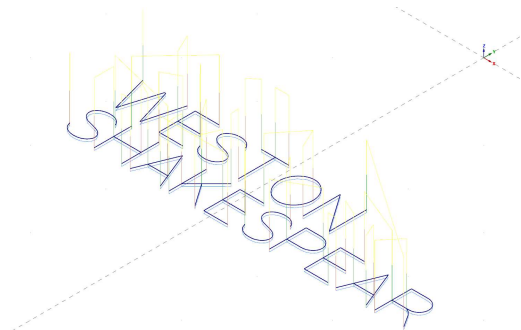
CYCLE TIME: 0 HOURS, 3 MINUTES, 38 SECONDS

### OPERATION LIST

#### OPERATION INFO 1 - Contour (2D)

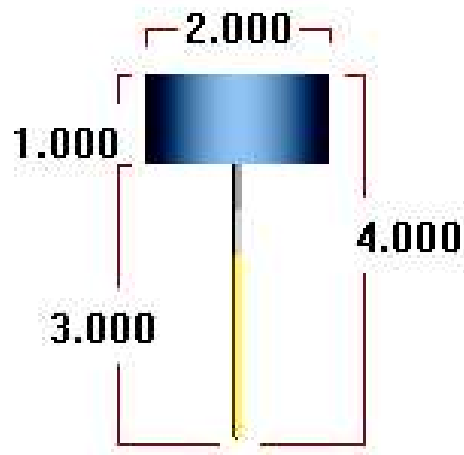
CYCLE TIME: 0 HOURS, 1 MINUTES, 1 SECONDS  
COMMENT:

PROGRAM NUMBER: 0  
SPINDLE SPEED: 5000 RPM  
FEEDRATE: 40.0 inch/min  
CLEARANCE PLANE: 2.0  
RETRACT PLANE: 0.2  
FEED PLANE: 0.1  
DEPTH: -0.008  
STOCK TO LEAVE: 0.0  
COMP TO TIP: YES  
WORK OFFSET:



#### TOOL INFO 1/8 SPOTDRILL

TYPE: Spot drill  
NUMBER: 1  
DIAMETER: 0.125  
CORNER RADIUS: 0.0  
LENGTH OFFSET: 1  
DIAMETER OFFSET: 1  
MATERIAL: HSS  
NUMBER OF FLUTES: 2  
FPT: 0.0002 SFM: 69.9935  
MFG CODE:  
ASSEMBLY:  
HOLDER: Default Holder  
TIME: 00:01:01

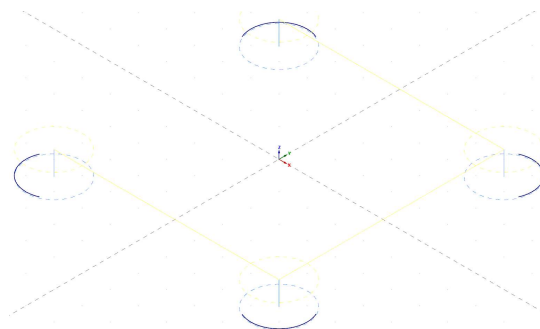


# *OPERATION INFO*

## **2 - Drill/Counterbore**

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

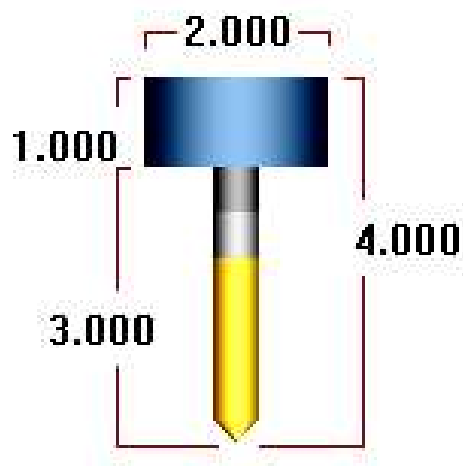
PROGRAM NUMBER: 0  
SPINDLE SPEED: 5000 RPM  
FEEDRATE: 40.0 inch/min  
CLEARANCE PLANE: 5.0  
RETRACT PLANE: 0.2  
FEED PLANE: 0.2  
DEPTH: -0.135  
STOCK TO LEAVE: 0.0  
COMP TO TIP: NO  
WORK OFFSET:



# *TOOL INFO*

## **1/2 SPOTDRILL**

TYPE: Spot drill  
NUMBER: 2  
DIAMETER: 0.5  
CORNER RADIUS: 0.0  
LENGTH OFFSET: 2  
DIAMETER OFFSET: 2  
MATERIAL: HSS  
NUMBER OF FLUTES: 2  
FPT: 0.001 SFM: 69.8953  
MFG CODE:  
ASSEMBLY:  
HOLDER: Default Holder  
TIME: 00:00:01

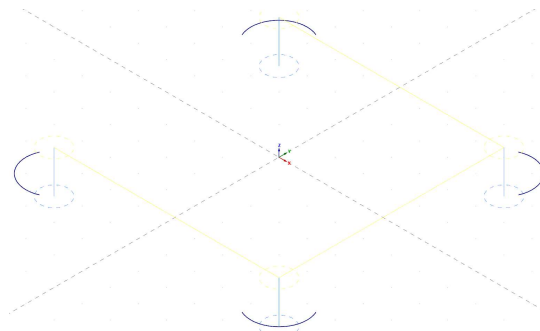


# *OPERATION INFO*

## **3 - Drill/Counterbore**

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

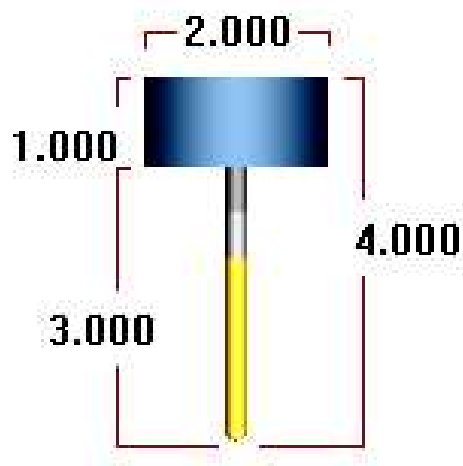
PROGRAM NUMBER: 0  
SPINDLE SPEED: 5000 RPM  
FEEDRATE: 40.0 inch/min  
CLEARANCE PLANE: 5.0  
RETRACT PLANE: 0.2  
FEED PLANE: 0.2  
DEPTH: -0.3  
STOCK TO LEAVE: 0.0  
COMP TO TIP: NO  
WORK OFFSET:



# *TOOL INFO*

## **1/4 DRILL**

TYPE: Drill  
NUMBER: 3  
DIAMETER: 0.25  
CORNER RADIUS: 0.0  
LENGTH OFFSET: 3  
DIAMETER OFFSET: 3  
MATERIAL: HSS  
NUMBER OF FLUTES: 2  
FPT: 0.002 SFM: 69.9607  
MFG CODE:  
ASSEMBLY:  
HOLDER: Default Holder  
TIME: 00:00:02

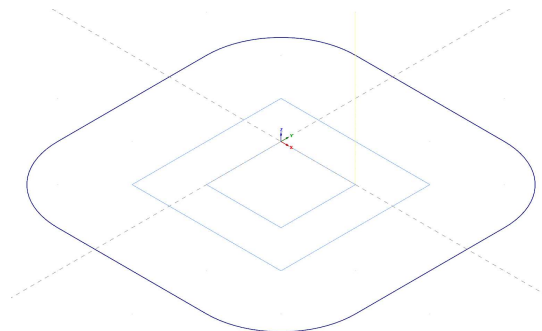


# OPERATION INFO

## 4 - Pocket (Standard)

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

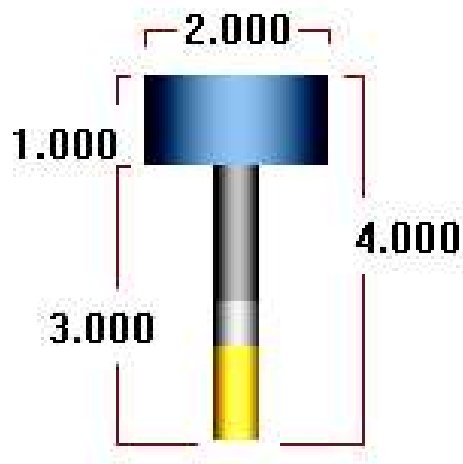
PROGRAM NUMBER: 0  
SPINDLE SPEED: 5000 RPM  
FEEDRATE: 40.0 inch/min  
CLEARANCE PLANE: 2.0  
RETRACT PLANE: 0.25  
FEED PLANE: 0.2  
DEPTH: -0.125  
STOCK TO LEAVE: 0.0  
COMP TO TIP: YES  
WORK OFFSET:



# TOOL INFO

## 1/2 FLAT ENDMILL

TYPE: Flat endmill  
NUMBER: 4  
DIAMETER: 0.5  
CORNER RADIUS: 0.0  
LENGTH OFFSET: 4  
DIAMETER OFFSET: 4  
MATERIAL: HSS  
NUMBER OF FLUTES: 4  
FPT: 0.0015 SFM: 139.9215  
MFG CODE:  
ASSEMBLY:  
HOLDER: Default Holder  
TIME: 00:00:10

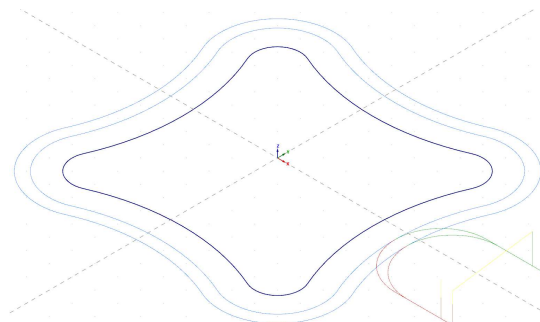


# OPERATION INFO

## 5 - Contour (2D)

CYCLE TIME: 0 HOURS, 0 MINUTES, 52 SECONDS  
COMMENT:

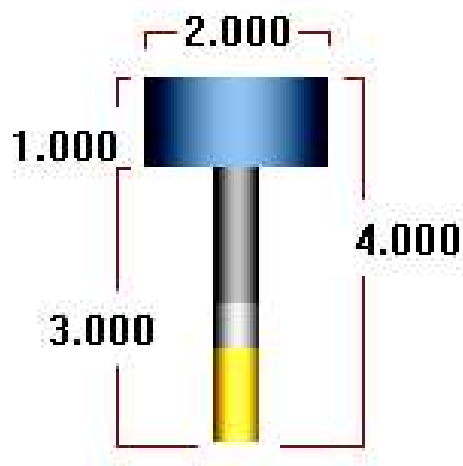
PROGRAM NUMBER: 0  
SPINDLE SPEED: 5000 RPM  
FEEDRATE: 40.0 inch/min  
CLEARANCE PLANE: 2.0  
RETRACT PLANE: 0.25  
FEED PLANE: 0.2  
DEPTH: -0.125  
STOCK TO LEAVE: 0.0  
COMP TO TIP: YES  
WORK OFFSET:



# TOOL INFO

## 1/2 FLAT ENDMILL

TYPE: Flat endmill  
NUMBER: 4  
DIAMETER: 0.5  
CORNER RADIUS: 0.0  
LENGTH OFFSET: 4  
DIAMETER OFFSET: 4  
MATERIAL: HSS  
NUMBER OF FLUTES: 4  
FPT: 0.0015 SFM: 139.9215  
MFG CODE:  
ASSEMBLY:  
HOLDER: Default Holder  
TIME: 00:00:52

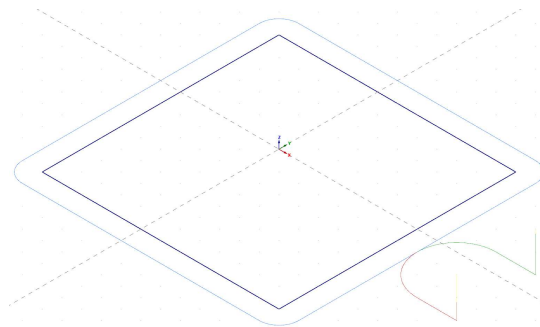


# OPERATION INFO

## 6 - Contour (2D)

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

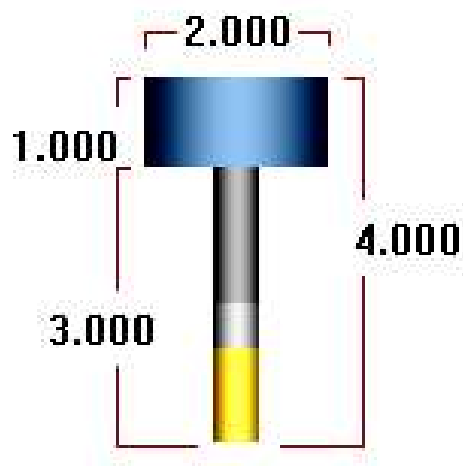
PROGRAM NUMBER: 0  
SPINDLE SPEED: 5000 RPM  
FEEDRATE: 40.0 inch/min  
CLEARANCE PLANE: 2.0  
RETRACT PLANE: 0.25  
FEED PLANE: 0.2  
DEPTH: -0.25  
STOCK TO LEAVE: 0.0  
COMP TO TIP: YES  
WORK OFFSET:



# TOOL INFO

## 1/2 FLAT ENDMILL

TYPE: Flat endmill  
NUMBER: 4  
DIAMETER: 0.5  
CORNER RADIUS: 0.0  
LENGTH OFFSET: 4  
DIAMETER OFFSET: 4  
MATERIAL: HSS  
NUMBER OF FLUTES: 4  
FPT: 0.0015 SFM: 139.9215  
MFG CODE:  
ASSEMBLY:  
HOLDER: Default Holder  
TIME: 00:00:30



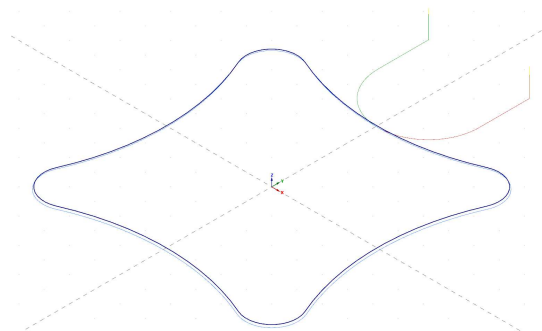


OPERATION INFO

7 - Contour (2D chamfer)

CYCLE TIME: 0 HOURS, 0 MINUTES, 22 SECONDS  
COMMENT:

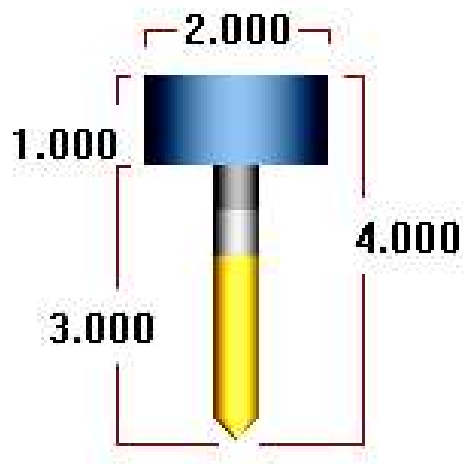
PROGRAM NUMBER: 0  
SPINDLE SPEED: 5000 RPM  
FEEDRATE: 40.0 inch/min  
CLEARANCE PLANE: 2.0  
RETRACT PLANE: 0.25  
FEED PLANE: 0.2  
DEPTH: 0.0  
STOCK TO LEAVE: 0.0  
COMP TO TIP: YES  
WORK OFFSET:



TOOL INFO

1/2 SPOTDRILL

TYPE: Spot drill  
NUMBER: 2  
DIAMETER: 0.5  
CORNER RADIUS: 0.0  
LENGTH OFFSET: 2  
DIAMETER OFFSET: 2  
MATERIAL: HSS  
NUMBER OF FLUTES: 2  
FPT: 0.001 SFM: 69.8953  
MFG CODE:  
ASSEMBLY:  
HOLDER: Default Holder  
TIME: 00:00:22

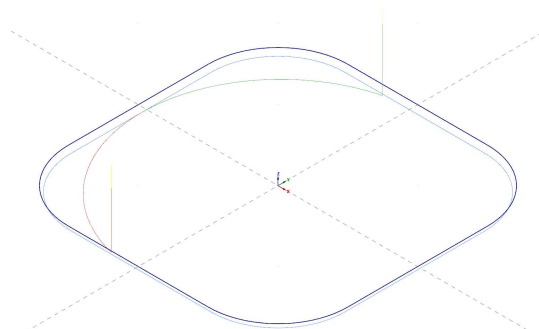


# *OPERATION INFO*

## *8 - Contour (2D chamfer)*

CYCLE TIME: 0 HOURS, 0 MINUTES, 11 SECONDS  
COMMENT:

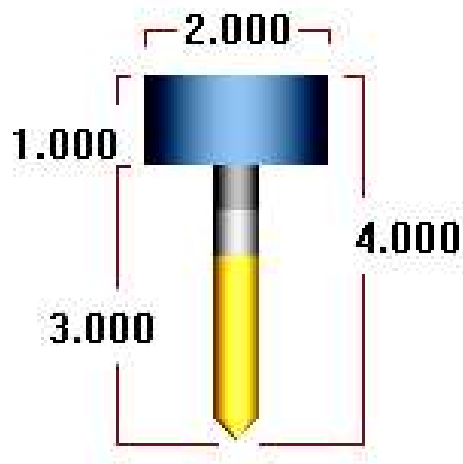
PROGRAM NUMBER: 0  
SPINDLE SPEED: 5000 RPM  
FEEDRATE: 40.0 inch/min  
CLEARANCE PLANE: 2.0  
RETRACT PLANE: 0.25  
FEED PLANE: 0.2  
DEPTH: 0.0  
STOCK TO LEAVE: 0.0  
COMP TO TIP: YES  
WORK OFFSET:



# *TOOL INFO*

## *1/2 SPOTDRILL*

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

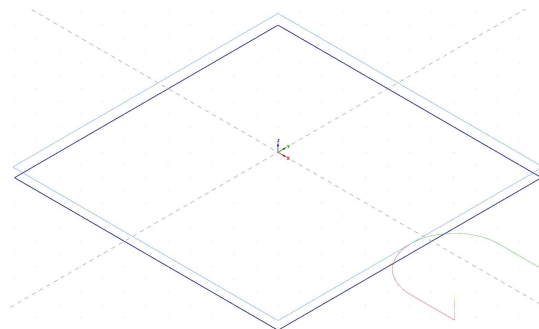


# OPERATION INFO

## 9 - Contour (2D chamfer)

CYCLE TIME: 0 HOURS, 0 MINUTES, 25 SECONDS  
COMMENT:

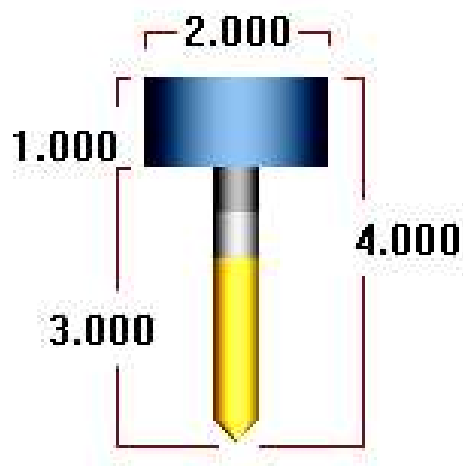
PROGRAM NUMBER: 0  
SPINDLE SPEED: 5000 RPM  
FEEDRATE: 40.0 inch/min  
CLEARANCE PLANE: 2.0  
RETRACT PLANE: 0.25  
FEED PLANE: 0.2  
DEPTH: -0.125  
STOCK TO LEAVE: 0.0  
COMP TO TIP: YES  
WORK OFFSET:



# TOOL INFO

## 1/2 SPOTDRILL

TYPE: Spot drill  
NUMBER: 2  
DIAMETER: 0.5  
CORNER RADIUS: 0.0  
LENGTH OFFSET: 2  
DIAMETER OFFSET: 2  
MATERIAL: HSS  
NUMBER OF FLUTES: 2  
FPT: 0.001 SFM: 69.8953  
MFG CODE:  
ASSEMBLY:  
HOLDER: Default Holder  
TIME: 00:00:25

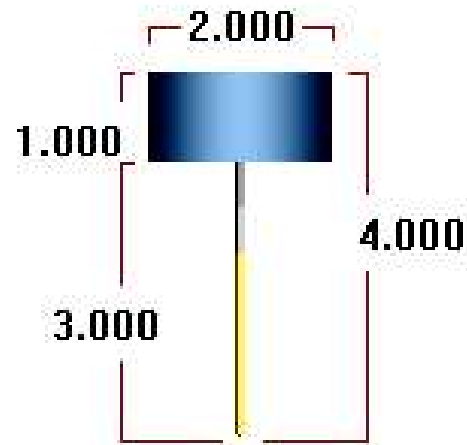


**TOOL LIST**

Sorted: NO

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

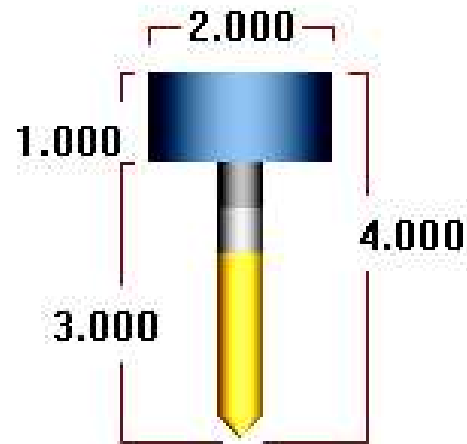
TYPE: Spot drill  
NUMBER: 1  
DIAMETER: 0.125  
CORNER RADIUS: 0.0  
LENGTH OFFSET: 1  
DIAMETER OFFSET: 1  
MATERIAL: HSS  
NUMBER OF FLUTES: 2  
FPT: 0.0002 SFM: 69.9935  
MFG CODE:  
ASSEMBLY:  
HOLDER: Default Holder  
TIME: 00:01:01



USED BY OPERATION: # 1 1 - Contour (2D)

**TOOL INFO****1/2 SPOTDRILL**

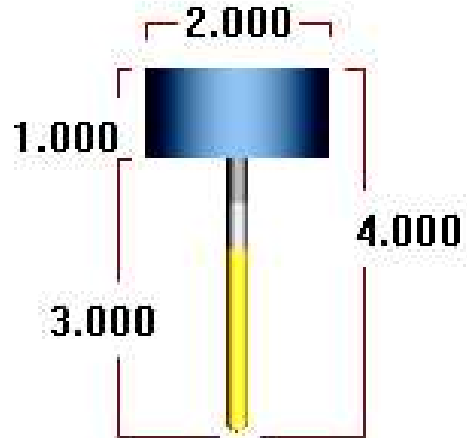
TYPE: Spot drill  
NUMBER: 2  
DIAMETER: 0.5  
CORNER RADIUS: 0.0  
LENGTH OFFSET: 2  
DIAMETER OFFSET: 2  
MATERIAL: HSS  
NUMBER OF FLUTES: 2  
FPT: 0.001 SFM: 69.8953  
MFG CODE:  
ASSEMBLY:  
HOLDER: Default Holder  
TIME: 00:01:01



USED BY OPERATION: # 2 2 - Drill/Counterbore  
USED BY OPERATION: # 7 7 - Contour (2D chamfer)  
USED BY OPERATION: # 8 8 - Contour (2D chamfer)  
USED BY OPERATION: # 9 9 - Contour (2D chamfer)

**TOOL INFO****1/4 DRILL**

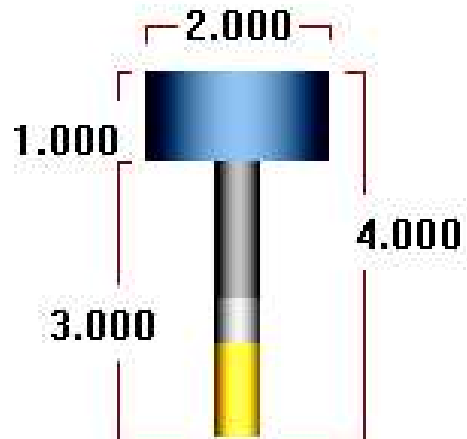
|                   |                |
|-------------------|----------------|
| TYPE:             | Drill          |
| NUMBER:           | 3              |
| DIAMETER:         | 0.25           |
| CORNER RADIUS:    | 0.0            |
| LENGTH OFFSET:    | 3              |
| DIAMETER OFFSET:  | 3              |
| MATERIAL:         | HSS            |
| NUMBER OF FLUTES: | 2              |
| FPT: 0.002        | SFM: 69.9607   |
| MFG CODE:         |                |
| ASSEMBLY:         |                |
| HOLDER:           | Default Holder |
| TIME:             | 00:00:02       |



USED BY OPERATION: # 3 3 - Drill/Counterbore

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

|                   |                |
|-------------------|----------------|
| TYPE:             | Flat endmill   |
| NUMBER:           | 4              |
| DIAMETER:         | 0.5            |
| CORNER RADIUS:    | 0.0            |
| LENGTH OFFSET:    | 4              |
| DIAMETER OFFSET:  | 4              |
| MATERIAL:         | HSS            |
| NUMBER OF FLUTES: | 4              |
| FPT: 0.0015       | SFM: 139.9215  |
| MFG CODE:         |                |
| ASSEMBLY:         |                |
| HOLDER:           | Default Holder |
| TIME:             | 00:01:33       |



USED BY OPERATION: # 4 4 - Pocket (Standard)  
USED BY OPERATION: # 5 5 - Contour (2D)  
USED BY OPERATION: # 6 6 - Contour (2D)

## ***WORK OFFSETS***

### *OFFSET INFO*

|                    |            |                          |
|--------------------|------------|--------------------------|
| NUMBER:            | PLANE: Top | ORIGIN: 0.0, 0.0, 0.0    |
| USED BY OPERATION: | # 1        | 1 - Contour (2D)         |
| USED BY OPERATION: | # 2        | 2 - Drill/Counterbore    |
| USED BY OPERATION: | # 3        | 3 - Drill/Counterbore    |
| USED BY OPERATION: | # 4        | 4 - Pocket (Standard)    |
| USED BY OPERATION: | # 5        | 5 - Contour (2D)         |
| USED BY OPERATION: | # 6        | 6 - Contour (2D)         |
| USED BY OPERATION: | # 7        | 7 - Contour (2D chamfer) |
| USED BY OPERATION: | # 8        | 8 - Contour (2D chamfer) |
| USED BY OPERATION: | # 9        | 9 - Contour (2D chamfer) |