



GENERAL INFORMATION

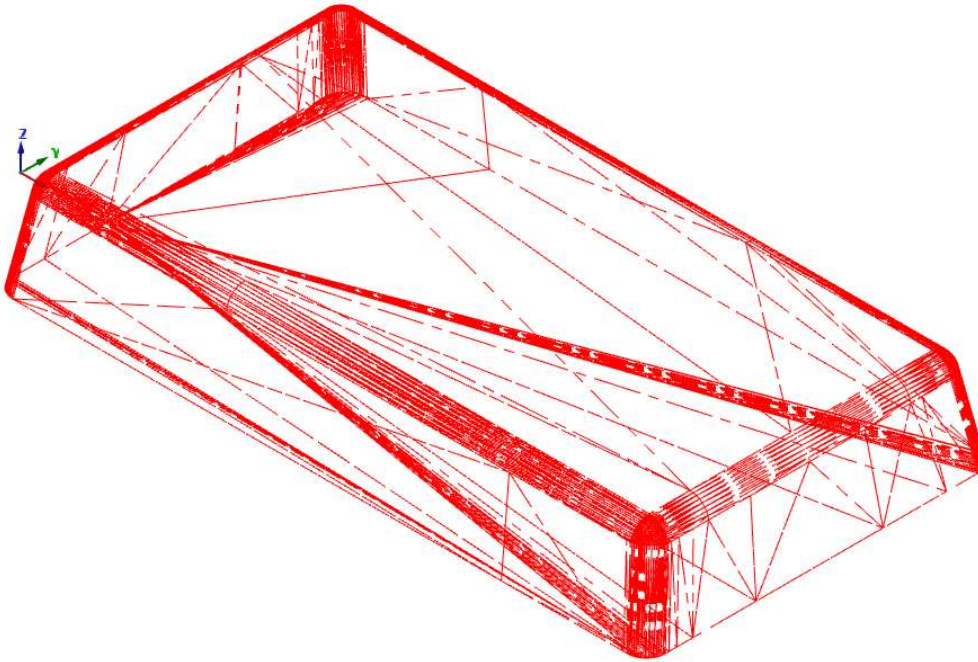
REVISION:



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\IMY

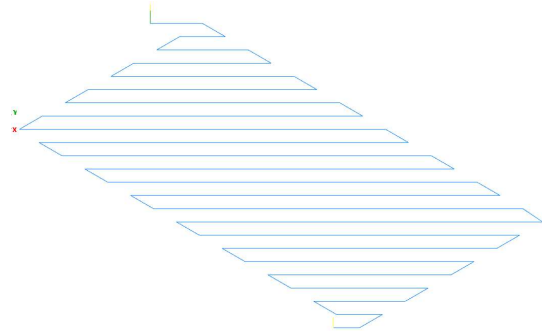
CYCLE TIME: 0 HOURS, 14 MINUTES, 30 SECONDS

OPERATION LIST

OPERATION INFO 1 - Facing

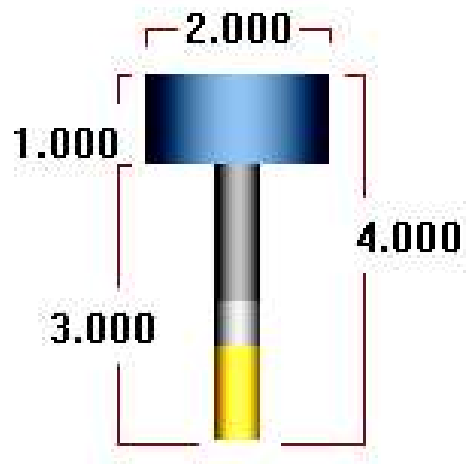
CYCLE TIME: 0 HOURS, 1 MINUTES, 13 SECONDS
COMMENT:

PROGRAM NUMBER: 0
SPINDLE SPEED: 4966 RPM
FEEDRATE: 50.0 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: 00:01:13

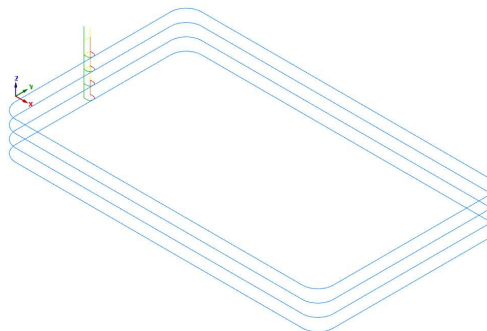


OPERATION INFO

2 - Contour (2D)

CYCLE TIME: 0 HOURS, 1 MINUTES, 29 SECONDS
COMMENT:

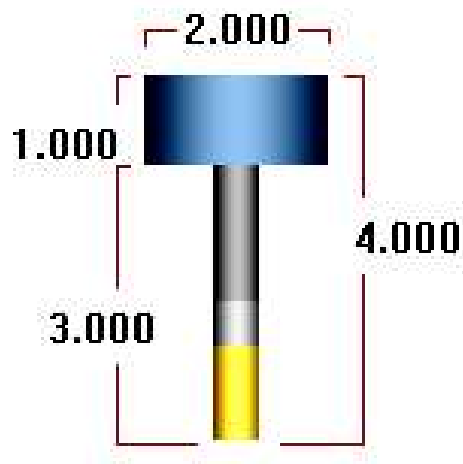
PROGRAM NUMBER: 0
SPINDLE SPEED: 4966 RPM
FEEDRATE: 45.0 inch/min
CLEARANCE PLANE: 2.0
RETRACT PLANE: 0.125
FEED PLANE: 0.2
DEPTH: -0.8
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET: 0



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: 00:01:29

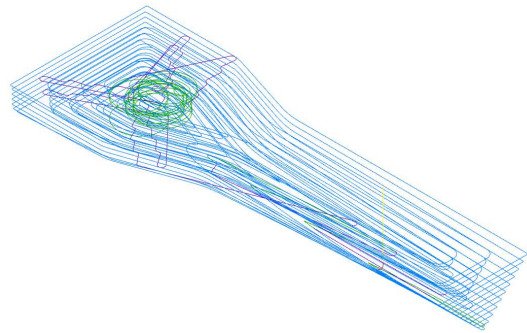


OPERATION INFO

3 - 3D High Speed (Area roughing)

CYCLE TIME: 0 HOURS, 6 MINUTES, 31 SECONDS
COMMENT:

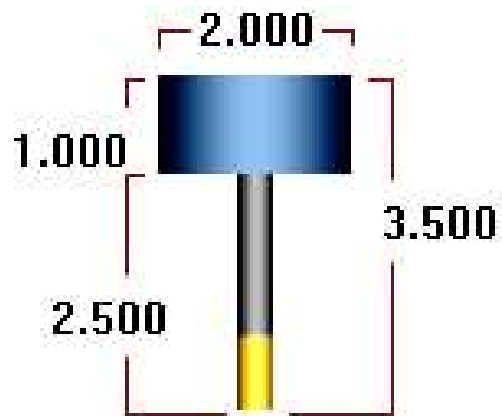
PROGRAM NUMBER: 0
SPINDLE SPEED: 6621 RPM
FEEDRATE: 50.0 inch/min
CLEARANCE PLANE: 0.25
RETRACT PLANE: 0.15
FEED PLANE: 0.025
DEPTH: NA
STOCK TO LEAVE: 0.05
COMP TO TIP: YES
WORK OFFSET: 0



TOOL INFO

3/8 BULL ENDMILL 0.0625 RAD

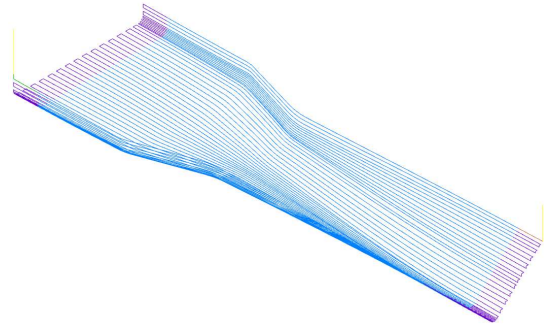
TYPE: Bull endmill
NUMBER: 2
DIAMETER: 0.375
CORNER RADIUS: 0.0625
LENGTH OFFSET: 2
DIAMETER OFFSET: 2
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.0015 SFM: 139.9869
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:06:31



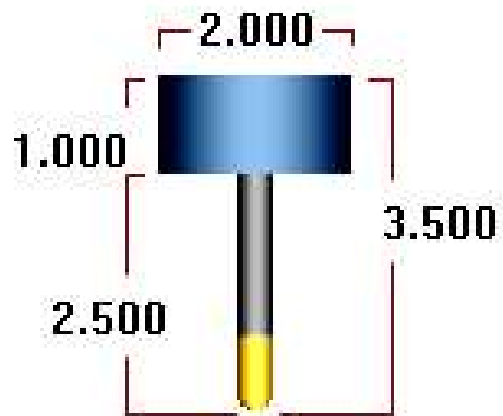
OPERATION INFO**4 - Surface Finish Flowline**

CYCLE TIME: 0 HOURS, 5 MINUTES, 6 SECONDS
COMMENT:

PROGRAM NUMBER: 0
SPINDLE SPEED: 6621 RPM
FEEDRATE: 55.0 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: 3
DIAMETER: 0.375
CORNER RADIUS: 0.1875
LENGTH OFFSET: 3
DIAMETER OFFSET: 3
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.0011 SFM: 139.9869
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:05:06

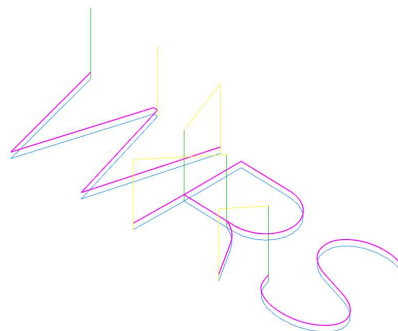


OPERATION INFO

5 - Contour (3D)

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

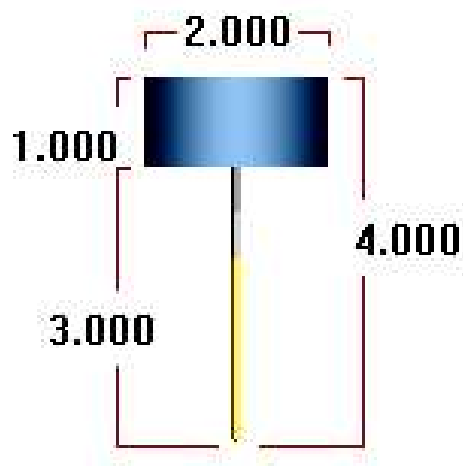
PROGRAM NUMBER: 0
SPINDLE SPEED: 7500 RPM
FEEDRATE: 30.0 inch/min
CLEARANCE PLANE: 2.0
RETRACT PLANE: 0.125
FEED PLANE: 0.2
DEPTH: -0.02
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET: 0



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: 0.0024 SFM: 162.5
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:00:10

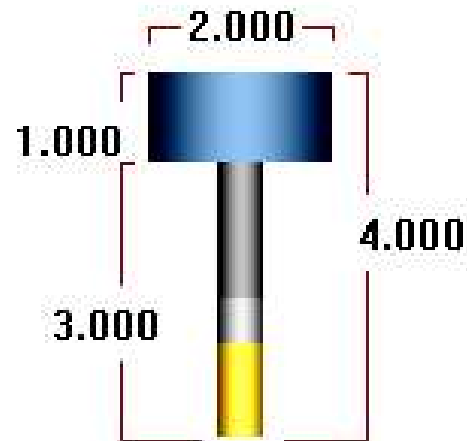


TOOL LIST

Sorted: NO

TOOL INFO**1/2 FLAT ENDMILL**

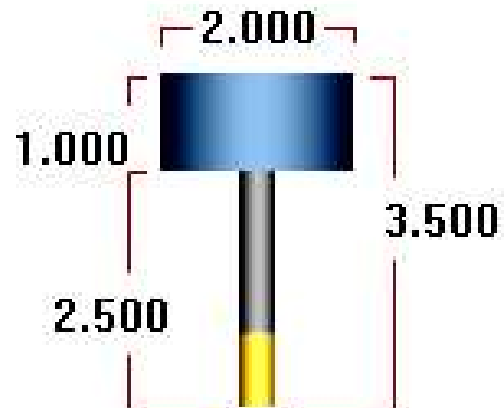
TYPE: Flat endmill
NUMBER: 1
DIAMETER: 0.5
CORNER RADIUS: 0.0
LENGTH OFFSET: 1
DIAMETER OFFSET: 1
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.0025 SFM: 650.0
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:02:42



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

TOOL INFO**3/8 BULL ENDMILL 0.0625 RAD**

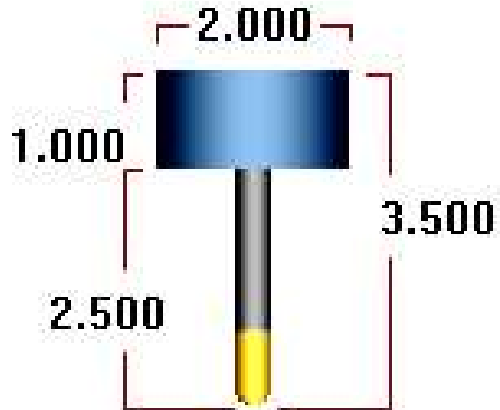
TYPE: Bull endmill
NUMBER: 2
DIAMETER: 0.375
CORNER RADIUS: 0.0625
LENGTH OFFSET: 2
DIAMETER OFFSET: 2
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.0015 SFM: 139.9869
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:06:31



USED BY OPERATION: # 3 3 - 3D High Speed (Area roughing)

TOOL INFO**3/8 BALL ENDMILL**

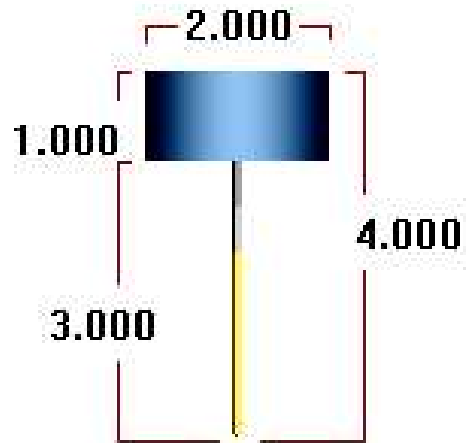
TYPE:	Ball endmill
NUMBER:	3
DIAMETER:	0.375
CORNER RADIUS:	0.1875
LENGTH OFFSET:	3
DIAMETER OFFSET:	3
MATERIAL:	HSS
NUMBER OF FLUTES:	4
FPT: 0.0011	SFM: 139.9869
MFG CODE:	
ASSEMBLY:	
HOLDER:	Default Holder
TIME:	00:05:06



USED BY OPERATION:	# 4	4 - Surface Finish Flowline
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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: 0.0024	SFM: 162.5
MFG CODE:	
ASSEMBLY:	
HOLDER:	Default Holder
TIME:	00:00:10



USED BY OPERATION:	# 5	5 - Contour (3D)
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WORK OFFSETS**OFFSET INFO**

NUMBER: 0	PLANE: Top	ORIGIN: 0.0, 0.0, 0.0
USED BY OPERATION:	# 1	1 - Facing
USED BY OPERATION:	# 2	2 - Contour (2D)
USED BY OPERATION:	# 3	3 - 3D High Speed (Area roughing)
USED BY OPERATION:	# 4	4 - Surface Finish Flowline
USED BY OPERATION:	# 5	5 - Contour (3D)