



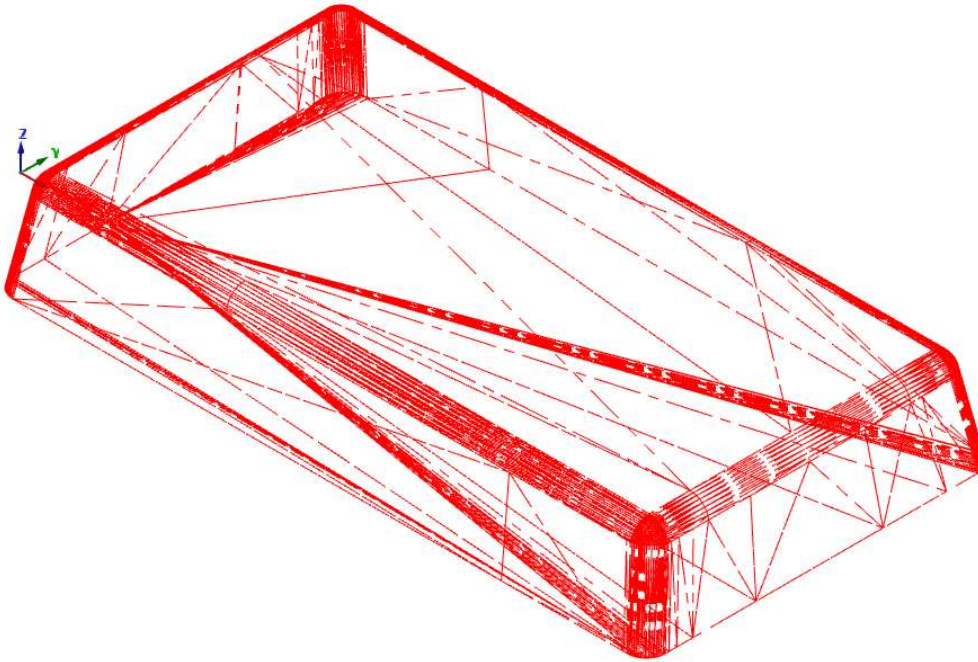
GENERAL INFORMATION

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

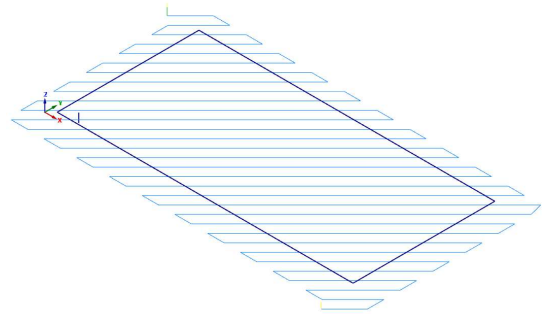
CYCLE TIME: 0 HOURS, 33 MINUTES, 58 SECONDS

OPERATION LIST

OPERATION INFO 1 - Facing

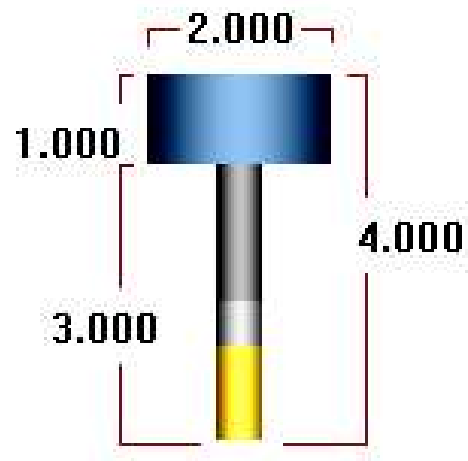
CYCLE TIME: 0 HOURS, 2 MINUTES, 6 SECONDS
COMMENT:

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

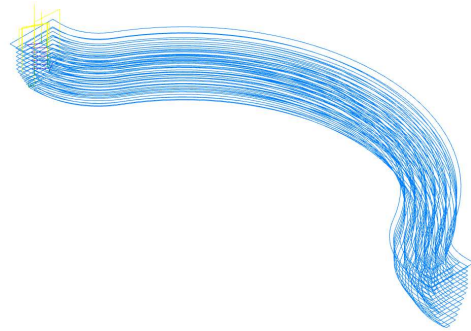
TYPE: Flat endmill
NUMBER: 1
DIAMETER: 0.5
CORNER RADIUS: 0.0
LENGTH OFFSET: 1
DIAMETER OFFSET: 1
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.0025 SFM: 650.0
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:02:06



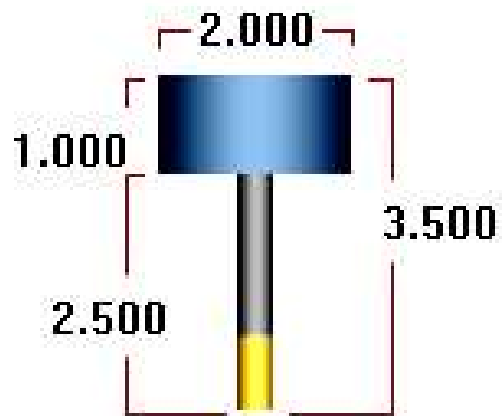
OPERATION INFO**2 - Surface Rough Pocket**

CYCLE TIME: 0 HOURS, 8 MINUTES, 10 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 0.015
COMP TO TIP: YES
WORK OFFSET: 0

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

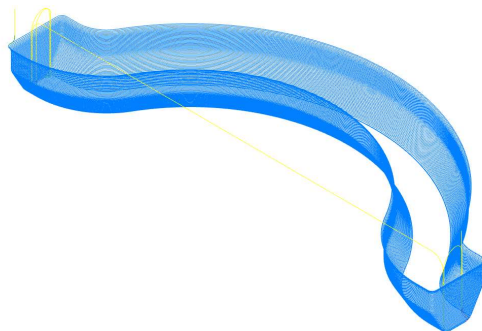
TYPE: Bull endmill
NUMBER: 2
DIAMETER: 0.375
CORNER RADIUS: 0.0625
LENGTH OFFSET: 2
DIAMETER OFFSET: 2
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.0015 SFM: 139.9869
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:08:10



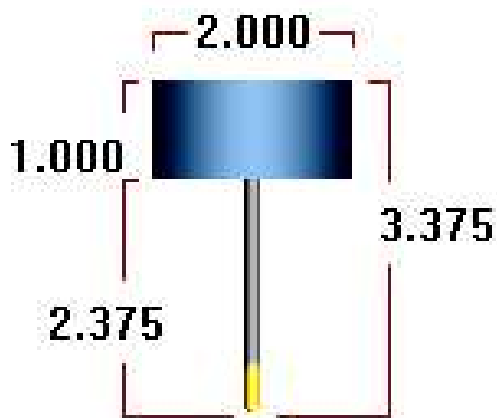
OPERATION INFO**3 - 3D High Speed (Waterline)**

CYCLE TIME: 0 HOURS, 17 MINUTES, 7 SECONDS
COMMENT:

PROGRAM NUMBER: 0
SPINDLE SPEED: 7000 RPM
FEEDRATE: 50.0 inch/min
CLEARANCE PLANE: 0.25
RETRACT PLANE: 0.125
FEED PLANE: 0.025
DEPTH: NA
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET: 0

**TOOL INFO****3/16 BALL ENDMILL**

TYPE: Ball endmill
NUMBER: 3
DIAMETER: 0.1875
CORNER RADIUS: 0.0938
LENGTH OFFSET: 3
DIAMETER OFFSET: 3
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.0005 SFM: 139.9869
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:17:07

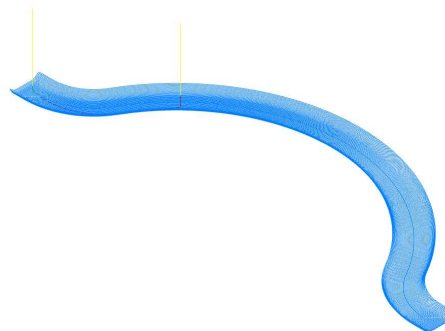


OPERATION INFO

4 - 3D High Speed (Scallop)

CYCLE TIME: 0 HOURS, 6 MINUTES, 25 SECONDS
COMMENT:

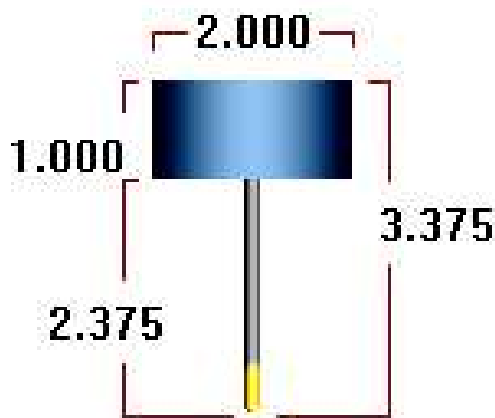
PROGRAM NUMBER: 0
SPINDLE SPEED: 7000 RPM
FEEDRATE: 50.0 inch/min
CLEARANCE PLANE: 0.25
RETRACT PLANE: 0.125
FEED PLANE: 0.025
DEPTH: NA
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET: 0



TOOL INFO

3/16 BALL ENDMILL

TYPE: Ball endmill
NUMBER: 3
DIAMETER: 0.1875
CORNER RADIUS: 0.0938
LENGTH OFFSET: 3
DIAMETER OFFSET: 3
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.0005 SFM: 139.9869
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:06:25



OPERATION INFO

5 - Contour (2D)

CYCLE TIME: 0 HOURS, 0 MINUTES, 8 SECONDS
COMMENT:

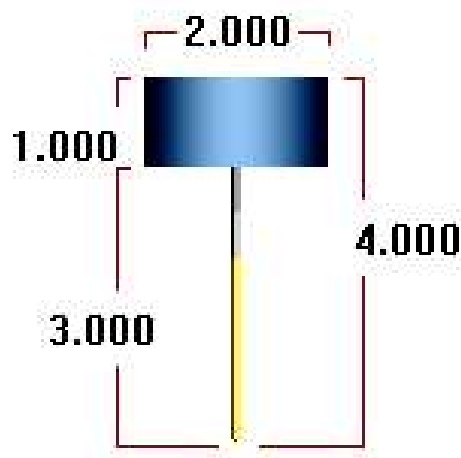
PROGRAM NUMBER: 0
SPINDLE SPEED: 10000 RPM
FEEDRATE: 35.0 inch/min
CLEARANCE PLANE: 2.0
RETRACT PLANE: 0.25
FEED PLANE: 0.2
DEPTH: -0.02
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET: 0



TOOL INFO

1/8 SPOTDRILL

TYPE: Spot drill
NUMBER: 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: 00:00:08

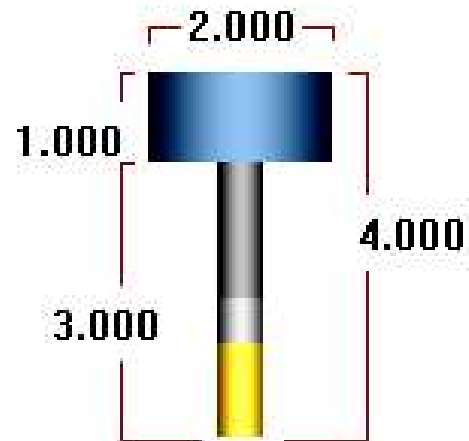


TOOL LIST

Sorted: NO

TOOL INFO**1/2 FLAT ENDMILL**

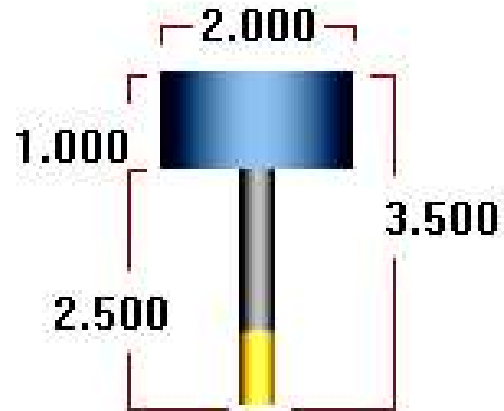
TYPE: Flat endmill
NUMBER: 1
DIAMETER: 0.5
CORNER RADIUS: 0.0
LENGTH OFFSET: 1
DIAMETER OFFSET: 1
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.0025 SFM: 650.0
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:02:06



USED BY OPERATION: # 1 1 - Facing

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

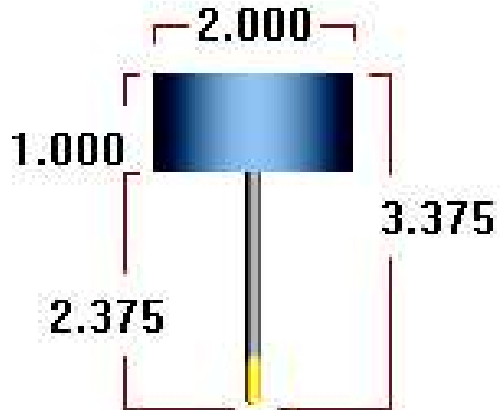
TYPE: Bull endmill
NUMBER: 2
DIAMETER: 0.375
CORNER RADIUS: 0.0625
LENGTH OFFSET: 2
DIAMETER OFFSET: 2
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.0015 SFM: 139.9869
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:08:10



USED BY OPERATION: # 2 2 - Surface Rough Pocket

TOOL INFO**3/16 BALL ENDMILL**

TYPE: Ball endmill
NUMBER: 3
DIAMETER: 0.1875
CORNER RADIUS: 0.0938
LENGTH OFFSET: 3
DIAMETER OFFSET: 3
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.0005 SFM: 139.9869
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:23:33

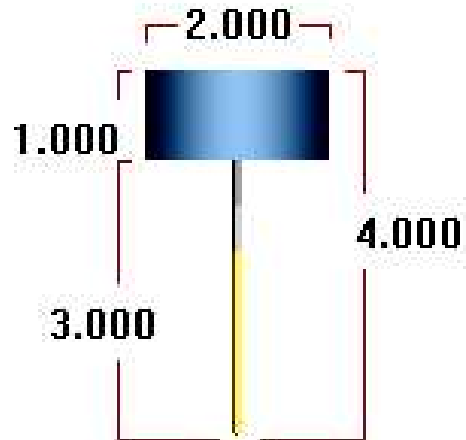


USED BY OPERATION: # 3 3 - 3D High Speed (Waterline)

USED BY OPERATION: # 4 4 - 3D High Speed (Scallop)

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: 00:00:08



USED BY OPERATION: # 5 5 - Contour (2D)

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 - Surface Rough Pocket
USED BY OPERATION: # 3 3 - 3D High Speed (Waterline)
USED BY OPERATION: # 4 4 - 3D High Speed (Scallop)
USED BY OPERATION: # 5 5 - Contour (2D)