



GENERIC HAAS 3 - AXIS VMC

GENERAL INFORMATION

PROJECT NAME:

CUSTOMER NAME:

PROGRAMMER:

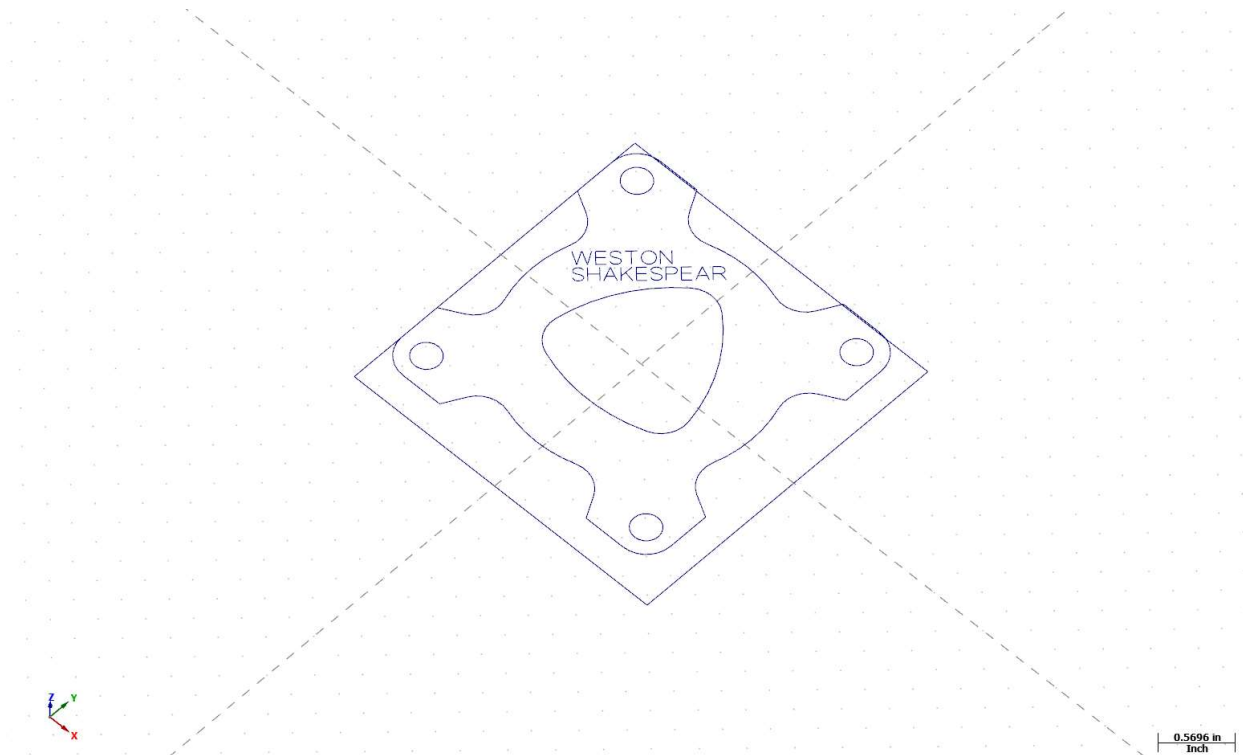
DRAWING:

DATE: Friday, February 3, 2023

TIME: 8:38 PM

REVISION:

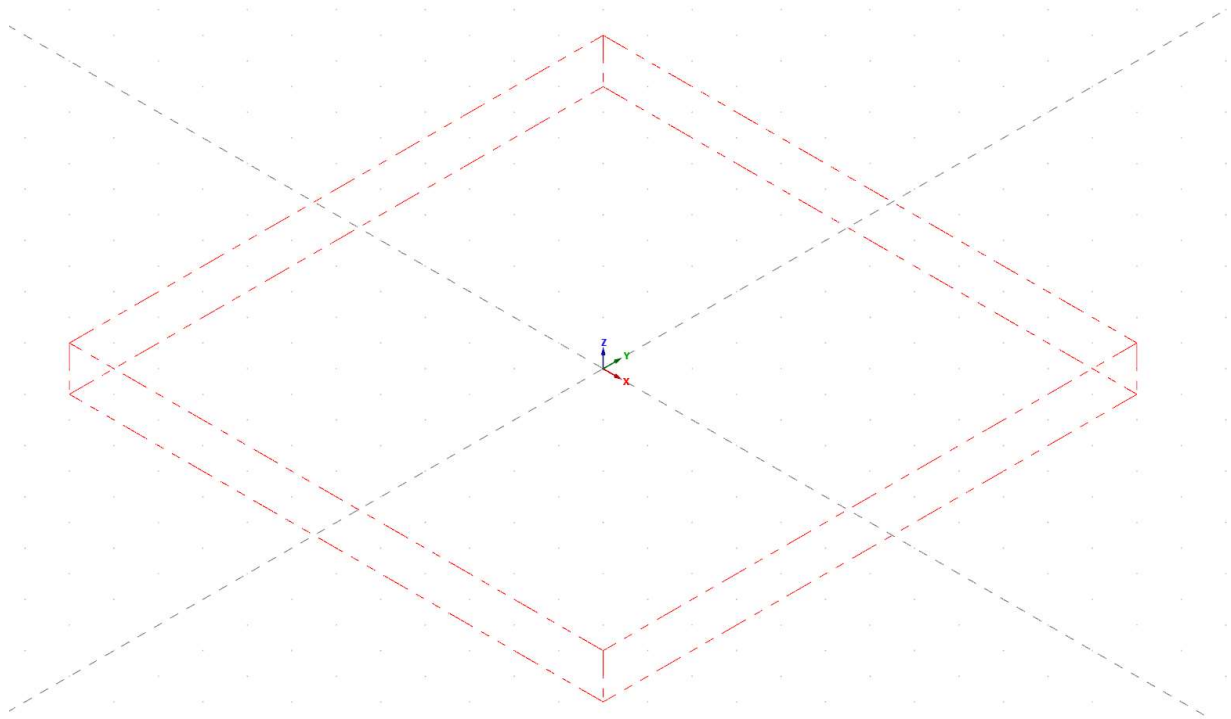
D:\SCHOOL\CNC\LESSON5 SECOND\V2\WSHAKESPEAR MILL LESSON 5B.EMCAM



COMMENTS

[illegible]

STOCK



STOCK:	YES
SHAPE:	Box
SIZE:	3.0, 3.0, 0.25
RADIUS:	NA
LENGTH:	
AXIS:	NA
FILE:	
IDN:	NA

C:\USERS\WES\DOCUMENTS\MY MASTERCAM

CYCLE TIME: 0 HOURS, 3 MINUTES, 18 SECONDS

OPERATION LIST

OPERATION INFO 1 - Contour (2D)

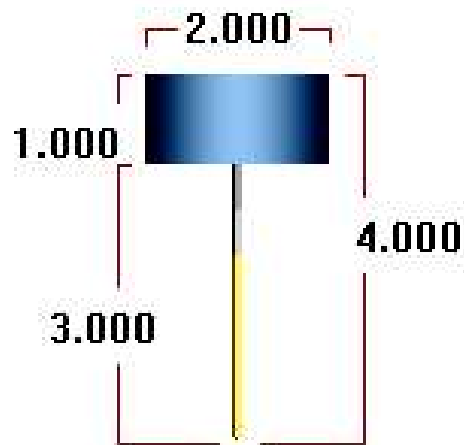
CYCLE TIME: 0 HOURS, 0 MINUTES, 11 SECONDS
COMMENT:

PROGRAM NUMBER: 0
SPINDLE SPEED: 5000 RPM
FEEDRATE: 40.0 inch/min
CLEARANCE PLANE: 2.0
RETRACT PLANE: 0.02
FEED PLANE: 0.02
DEPTH: -0.007
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET:

WESTON
SHAKESPEAR

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: 00:00:11

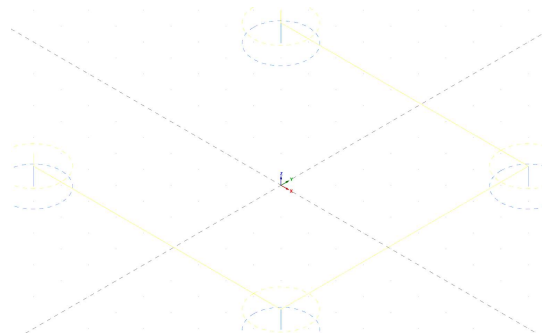


OPERATION INFO

2 - Drill/Counterbore

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

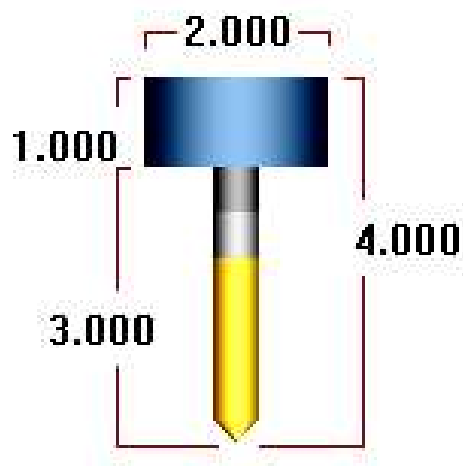
PROGRAM NUMBER: 0
SPINDLE SPEED: 5000 RPM
FEEDRATE: 40.0 inch/min
CLEARANCE PLANE: 0.25
RETRACT PLANE: 0.15
FEED PLANE: 0.15
DEPTH: -0.01
STOCK TO LEAVE: 0.0
COMP TO TIP: NO
WORK OFFSET:



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

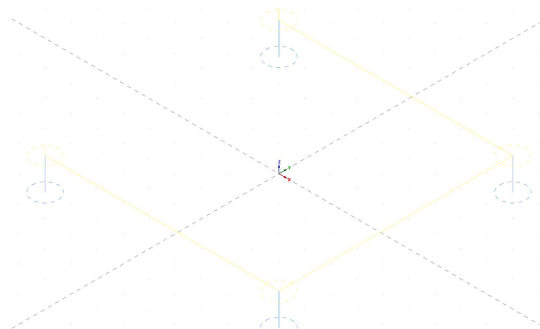


OPERATION INFO

3 - Peck Drill

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

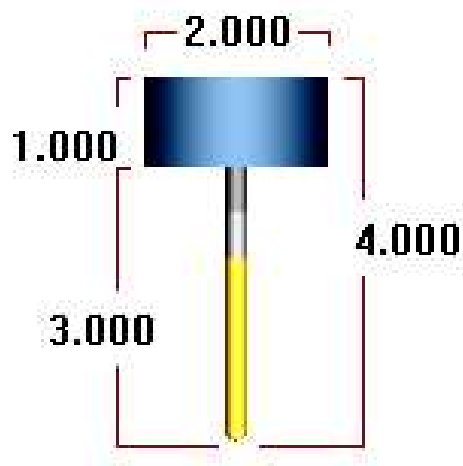
PROGRAM NUMBER: 0
SPINDLE SPEED: 5000 RPM
FEEDRATE: 20.0 inch/min
CLEARANCE PLANE: 0.25
RETRACT PLANE: 0.15
FEED PLANE: 0.15
DEPTH: -0.155
STOCK TO LEAVE: 0.0
COMP TO TIP: NO
WORK OFFSET:



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: 00:00:05

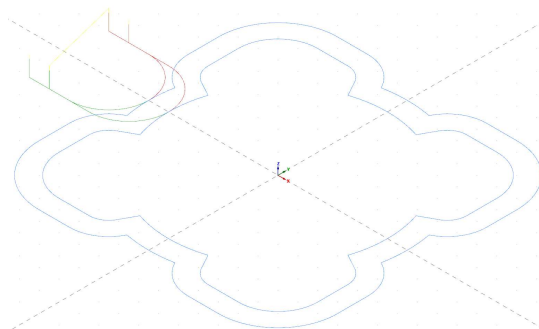


OPERATION INFO

4 - Contour (2D)

CYCLE TIME: 0 HOURS, 0 MINUTES, 57 SECONDS
COMMENT:

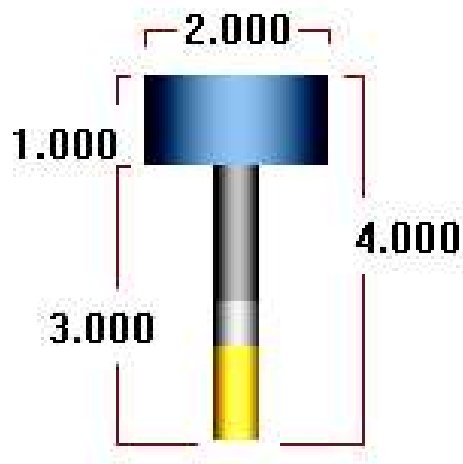
PROGRAM NUMBER: 0
SPINDLE SPEED: 5000 RPM
FEEDRATE: 40.0 inch/min
CLEARANCE PLANE: 2.0
RETRACT PLANE: 0.25
FEED PLANE: 0.2
DEPTH: 0.0
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET:



TOOL INFO

1/2 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: 00:00:57

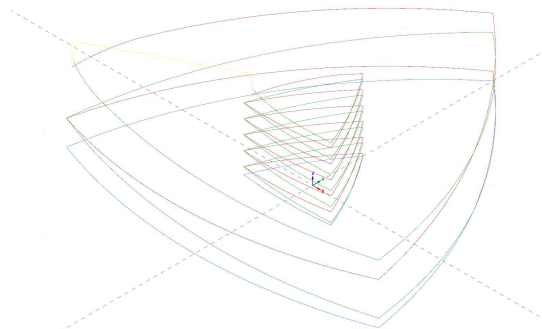


OPERATION INFO

5 - Contour (2D)

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

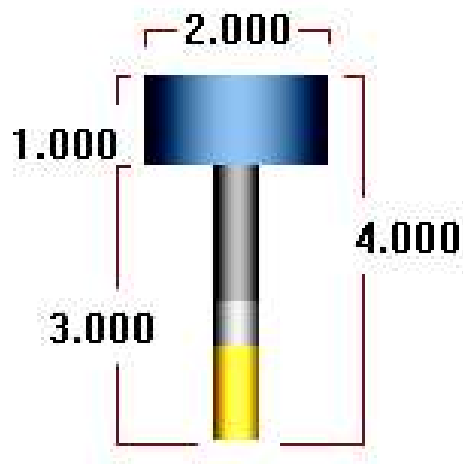
PROGRAM NUMBER: 0
SPINDLE SPEED: 5000 RPM
FEEDRATE: 40.0 inch/min
CLEARANCE PLANE: 2.0
RETRACT PLANE: 0.25
FEED PLANE: 0.2
DEPTH: 0.0
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET:



TOOL INFO

1/2 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: 00:00:29

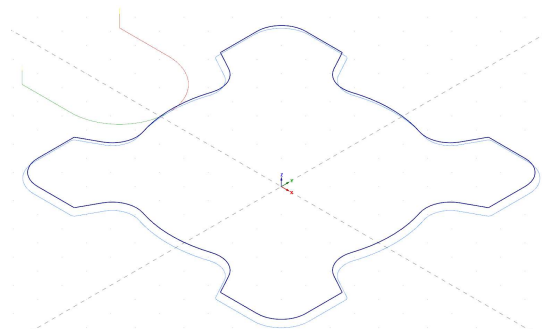


OPERATION INFO

6 - Contour (2D chamfer)

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

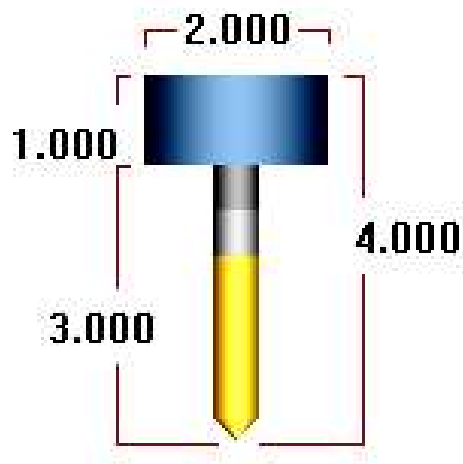
PROGRAM NUMBER: 0
SPINDLE SPEED: 5000 RPM
FEEDRATE: 40.0 inch/min
CLEARANCE PLANE: 2.0
RETRACT PLANE: 0.25
FEED PLANE: 0.2
DEPTH: 0.125
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET:



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: 00:00:24

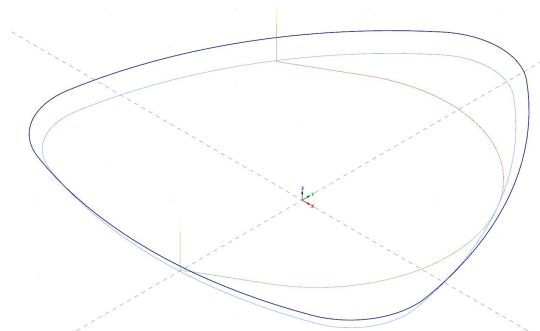


OPERATION INFO

7 - Contour (2D chamfer)

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

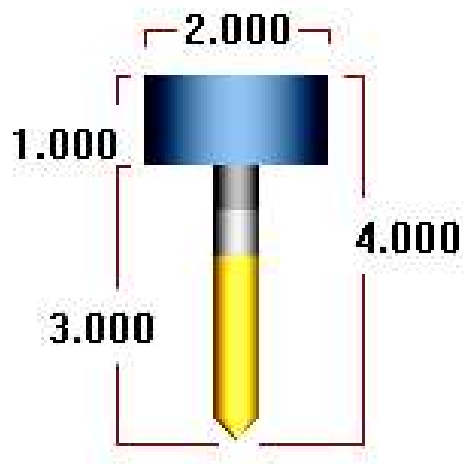
PROGRAM NUMBER: 0
SPINDLE SPEED: 4966 RPM
FEEDRATE: 39.728 inch/min
CLEARANCE PLANE: 2.0
RETRACT PLANE: 0.25
FEED PLANE: 0.2
DEPTH: 0.125
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET:



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: 00:00:11

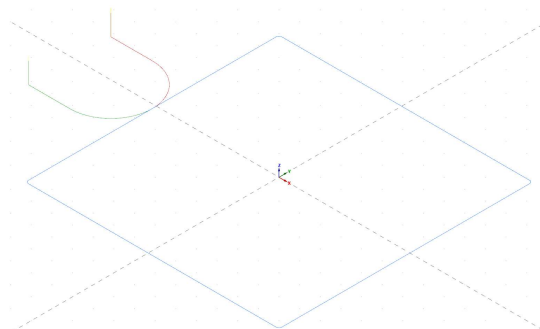


OPERATION INFO

8 - Contour (2D chamfer)

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

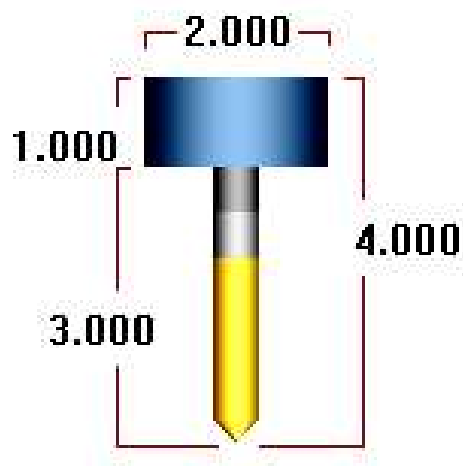
PROGRAM NUMBER: 0
SPINDLE SPEED: 5000 RPM
FEEDRATE: 40.0 inch/min
CLEARANCE PLANE: 2.0
RETRACT PLANE: 0.25
FEED PLANE: 0.2
DEPTH: 0.0
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET:



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: 00:00:26

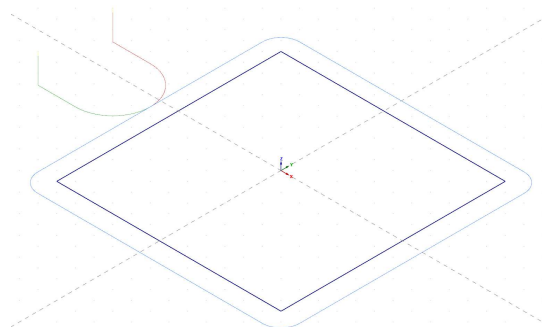


OPERATION INFO

9 - Contour (2D)

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

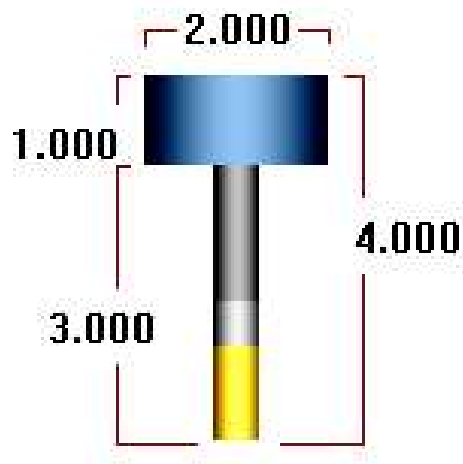
PROGRAM NUMBER: 0
SPINDLE SPEED: 5000 RPM
FEEDRATE: 40.0 inch/min
CLEARANCE PLANE: 2.0
RETRACT PLANE: 0.25
FEED PLANE: 0.2
DEPTH: -0.125
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET:



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: 00:00:30

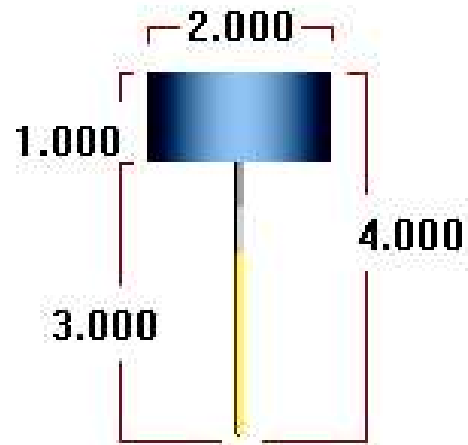


TOOL LIST

Sorted: NO

TOOL INFO**1/8 SPOTDRILL**

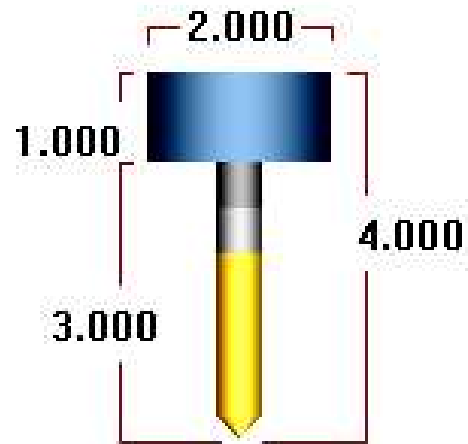
TYPE: Spot drill
NUMBER: 1
DIAMETER: 0.125
CORNER RADIUS: 0.0
LENGTH OFFSET: 1
DIAMETER OFFSET: 1
MATERIAL: HSS
NUMBER OF FLUTES: 2
FPT: 0.0002 SFM: 69.9935
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:00:11



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

TOOL INFO**1/2 SPOTDRILL**

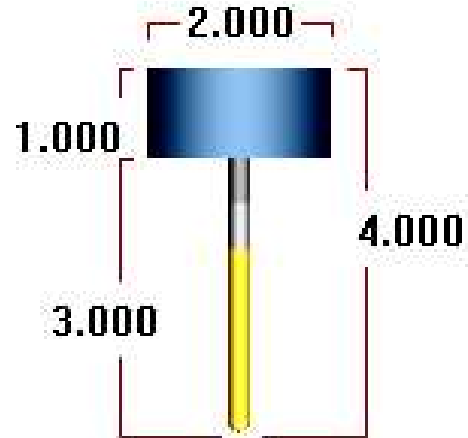
TYPE: Spot drill
NUMBER: 2
DIAMETER: 0.5
CORNER RADIUS: 0.0
LENGTH OFFSET: 2
DIAMETER OFFSET: 2
MATERIAL: HSS
NUMBER OF FLUTES: 2
FPT: 0.001 SFM: 69.8953
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:01:03



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

TOOL INFO**1/4 DRILL**

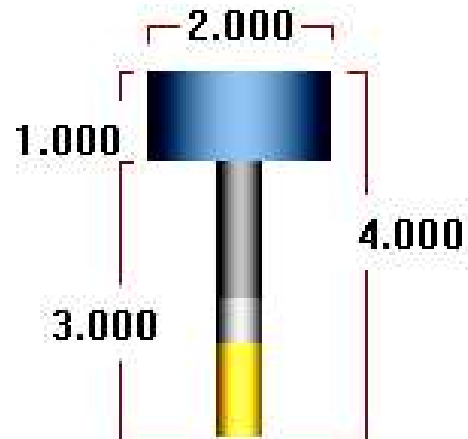
TYPE: Drill
NUMBER: 3
DIAMETER: 0.25
CORNER RADIUS: 0.0
LENGTH OFFSET: 3
DIAMETER OFFSET: 3
MATERIAL: HSS
NUMBER OF FLUTES: 2
FPT: 0.002 SFM: 69.9607
MFG CODE:
ASSEMBLY:
HOLDER: Default Holder
TIME: 00:00:05



USED BY OPERATION: # 3 3 - Peck Drill

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: 00:01:57



USED BY OPERATION: # 4 4 - Contour (2D)
USED BY OPERATION: # 5 5 - Contour (2D)
USED BY OPERATION: # 9 9 - 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 - Peck Drill
USED BY OPERATION:	# 4	4 - Contour (2D)
USED BY OPERATION:	# 5	5 - Contour (2D)
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)