

5/14/17-5/17/17

# CNC LATHE OPERATION WORK SHEET

DATE 06/04/2015 BY #201

MACHINE NO. #1 - NI-2500 #1

OPERATION NO. 20

SPINDLE #1 G54=FACE OF MATERIAL .015

SPINDLE #2 G55=FACE OF PART +.015 (PART AT 3.00" LONG)

MATERIAL ALUMINUM DIA. 1.500" LENGTH OUT OF SPINDLE 1 3.900" AT START

COLLET PRESSURE SPINDLE #1 = 250LBS SPINDLE #2 = 225LBS

**J. D. OTT COMPANY, INC.**

PART NO. 348T2200-34

PART NAME FITTING

TOOL #	OPERATION SPINDLE #1	INSERT/E.M.	GRADE/EDP#	TNR/E.M. R	MISC INFO/LENGTH OUT OF HOLDER	HOLDER	TNRC	E.M. CRC
1	ROUGH FACE/TURN	VNMG 332	K313	.0312	N/A	DVJNR	N/A	N/A
2	FINISH FACE/TURN	VNMG 331	K313	.0156	N/A	DVJNR	N/A	N/A
12	THREAD	NJF3009R18	K68	.0083	N/A	NSR	N/A	N/A
11	ROUGH BORE	3/8 DRILL	COBALT	135°	STUB DRILL	ER32 COLLET	N/A	N/A
7	ROUGH PORT I.D.	CDHH120605	CG5	.008	EXTEND OUT .500"	.1875 SLEEVE	N/A	N/A
9	FINISH PORT I.D.	SCI-BAR	CARBIDE	.010	EXTEND OUT .500"	.250 SLEEVE	N/A	N/A
4	MILL CUT-OUT	1.00" E.M.	HSS	NONE	EXTEND OUT 2.500"	X ER40 LIVE	N/A	D7=R
3	CENTER DRILL	#4	HSS	60°	FLUTE	ER32 COLLET	N/A	N/A
8	DRILL	"L" (.290 DIA)	COBALT	45°	EXTEND OUT 2.700"	ER32 COLLET	N/A	N/A
3	REAMER	.297 DIA	HSS	45°	EXTEND OUT 3.00"	ER32 COLLET	N/A	N/A
10	STOP				SPRING LOADED			
	CUT-OFF	507-128	C2	.005	N/A	MANCHESTER	N/A	N/A

USE 1.500" COLLET PADS AT G54\*\*\*\*\*USE A 9/16" 16C COLLET AT G55\*\*\*\*\* TOOLS IN JOB BOX ON DRAWER #209

T4 =.1875 DIA. WIDIA CIRCLE CSB1180187255R HSS BORE BAR.\*\*ALL DRILLS/REAMER USE M611 AND MUST BE DIALED IN\*\*

T6 SCI-BAR SHARED WITH PART #344T2200-211 *344T2200-101 5 hole #208 (Store Sci-Bar Back in #208 Solis Box)*

TOOL #	OPERATION SPINDLE #2	INSERT/E.M.	GRADE/EDP#	TNR/E.M. R	MISC INFO/LENGTH OUT OF HOLDER	HOLDER	TNRC	E.M. CRC
1-17	ROUGH FACE	CNMG 432	KW10	.0312	N/A	DCLNR	N/A	N/A
2-18	FINISH FACE	VNMG 331	K313	.0156	N/A	DVJNR	N/A	N/A
3-19								
4-20								
5-21								
6-22								
7-23								
8-24								
9-25								
10-26								
11-27								
12-28								