Mazak HMC
Tool Change Log

Dept. D2

OP.10 Asset# 2441 (South) 6594 (North) 10186 (West) (CIRCLE ONE)

A

Rev: 6/16/20

The following is an estimated tool change frequency. Record actual tool change on the chart below. If tooling did not meet matrix, put a check in either of the first two columns (chipped or quality) or describe the failure in the last column so that the cause may be addressed.

Tool No.	Tool Decription	Insert / Insert Holder	Mfg.	Max. Life
1	Flange Face Mill / Scallop	TL-17724-01	ISCAR	120 min.
7	Flange Hole End Mill	31147891	TCI	50 min.
10	Deburr (4) Flange Holes	TL-9831-02 (6H)	ISCAR	300 min.
2	Rough Bore / Flange End Center	CCC-35063	CCC	60 min.
3	Finish Bore	BFHI MB63-63	ISCAR / ITS Bore	70 min.
5	Pilot Diameter / Chamfer	CCC-34676 / TD-17725-01	CCC	70 min.
8	Carrier End Face Mill	CCC-34674	Competitive Carbide Company	100 min.
18	_Mojave_ Carrier End Face Mill	TD-15196-01 (D4)	Ultra Dex	100 min.
9	Carrier Centering Tool	CCC-34675 / TD-17725-03	CCC	100 min.
19	_Mojave_ Carrier Centering Tool	CCC-35780	CCC	100 min.
43	Tube Blow Out	TD-15351-01 (4K)		∞

****TURN IN SHEET AT END OF WORK WEEK**** Monday's Date:_____

Shift	DAY							Tool Pos	Tool Counter (min)	MATRIX? (CIRCLE ONE)	Description of Failure	
	M	T	W	T	F	S	S				Chipped / Broken	Other (write description)
A / B / C										YES / NO		
A / B / C										YES / NO		
A / B / C										YES / NO		
A / B / C										YES / NO		
A / B / C										YES / NO		
A / B / C										YES / NO		
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