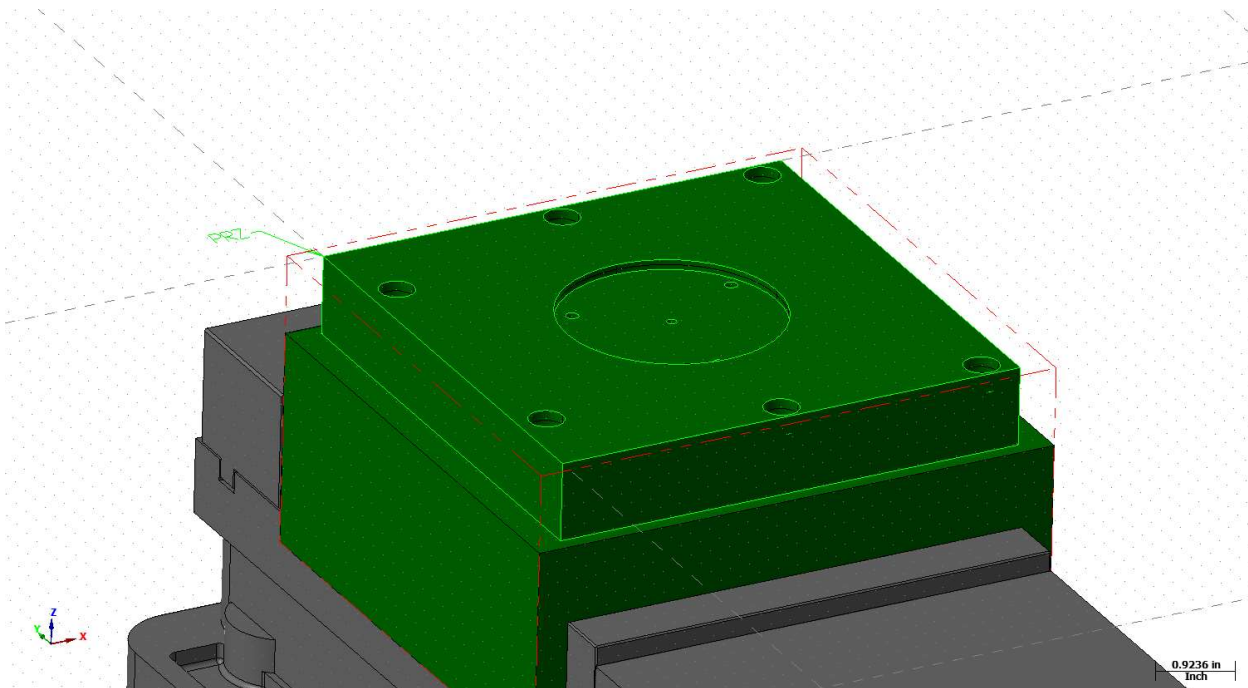


3 - AXIS VMC

GENERAL INFORMATION

| | |
|--------------|-----------|
| CLASS | PMT 280 |
| PROJECT NAME | 280-3 |
| PROGRAMMER: | D. WATSON |
| DRAWING: | 280-4 |
| DATE: | 2/25/2016 |

REVISION:

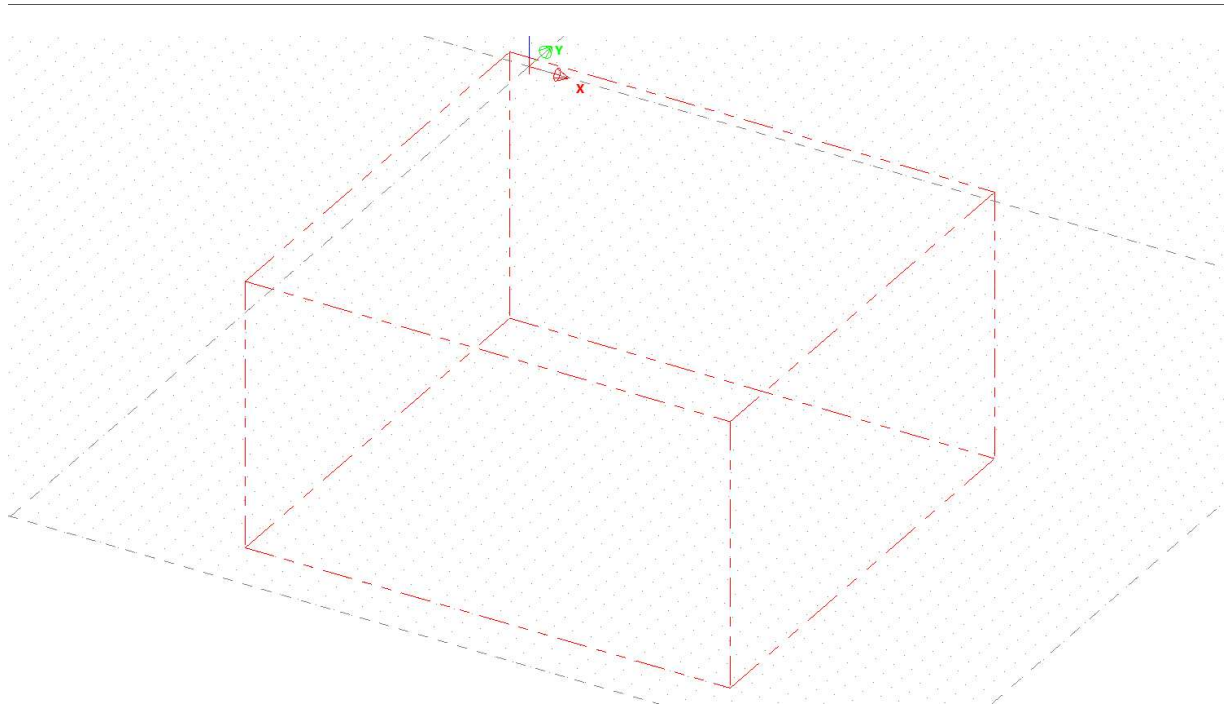


COMMENTS

PRZ- XY IS THE TOP LEFT CORNER
Z TOP OF STOCK



DUE #1303832



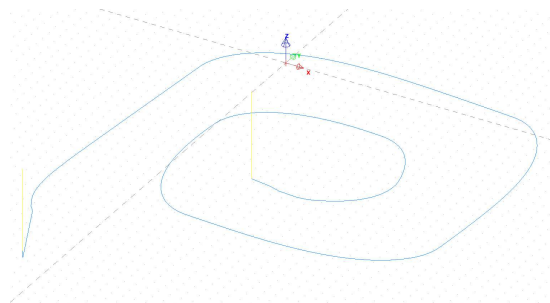
| | |
|---------------|------------------|
| STOCK: | YES |
| SHAPE: | Box |
| SIZE: | 6.75, 6.375, 3.7 |
| RADIUS: | NA |
| LENGTH: | NA |
| AXIS: | NA |
| FILE: | NA |
| IDN: | NA |

CYCLE TIME: 0 HOURS, 6 MINUTES, 45 SECONDS

OPERATION LIST

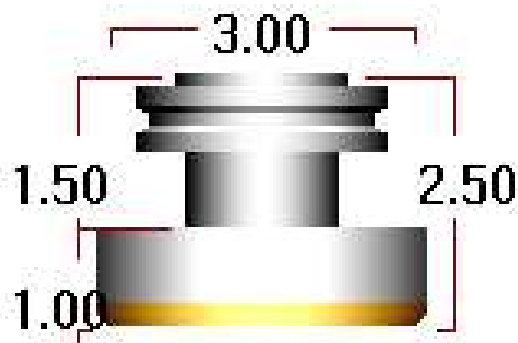
| OPERATION INFO | Facing |
|----------------|--------------------------------|
| CYCLE TIME: | 0 HOURS, 0 MINUTES, 24 SECONDS |
| COMMENT: | FACE TOP OF PART |

| | |
|------------------|----------------|
| PROGRAM NUMBER: | 3303 |
| SPINDLE SPEED: | 2000 RPM |
| FEEDRATE: | 100.0 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: | 0 |



TOOL INFO 3" FACE MILL

| | |
|-------------------|------------------|
| TYPE: | Face mill |
| NUMBER: | 1 |
| DIAMETER: | 3.0 |
| CORNER RADIUS: | 0.0 |
| LENGTH OFFSET: | 1 |
| DIAMETER OFFSET: | 1 |
| MATERIAL: | Carbide |
| NUMBER OF FLUTES: | 6 |
| FPT: 0.0083 | SFM: 1570.6806 |
| MFG CODE: | |
| ASSEMBLY: | 3" FACE MILL |
| HOLDER: | CAT 40 - FACE NA |
| TIME: | 00:00:24 |

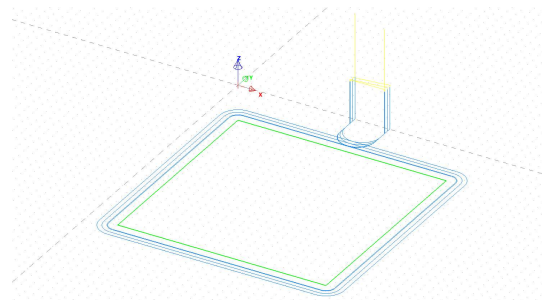


OPERATION INFO

Contour (2D)

| | |
|-------------|--------------------------------|
| CYCLE TIME: | 0 HOURS, 2 MINUTES, 36 SECONDS |
| COMMENT: | Mill Outer Contour |

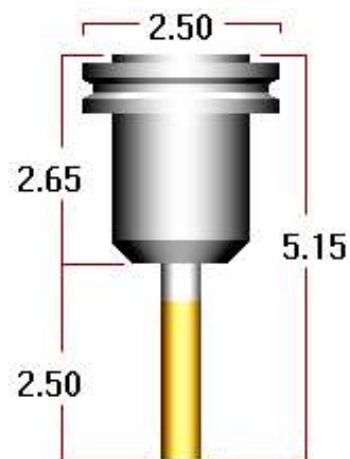
| | |
|------------------|---------------|
| PROGRAM NUMBER: | 3303 |
| SPINDLE SPEED: | 3500 RPM |
| FEEDRATE: | 50.0 inch/min |
| CLEARANCE PLANE: | 2.0 |
| RETRACT PLANE: | 0.25 |
| FEED PLANE: | 0.2 |
| DEPTH: | 0.0 |
| STOCK TO LEAVE: | 0.0 |
| COMP TO TIP: | YES |
| WORK OFFSET: | 0 |



TOOL INFO

1/2" FLAT 2 FLUTE EM

| | |
|-------------------|---------------------|
| TYPE: | Endmill1 Flat |
| NUMBER: | 2 |
| DIAMETER: | 0.5 |
| CORNER RADIUS: | 0.0 |
| LENGTH OFFSET: | 2 |
| DIAMETER OFFSET: | 2 |
| MATERIAL: | Carbide |
| NUMBER OF FLUTES: | 2 |
| FPT: 0.0071 | SFM: 458.1152 |
| MFG CODE: | |
| ASSEMBLY: | 1/2" FLAT 2 |
| HOLDER: | CAT 40 - 1/2 ID, NA |
| TIME: | 00:02:36 |

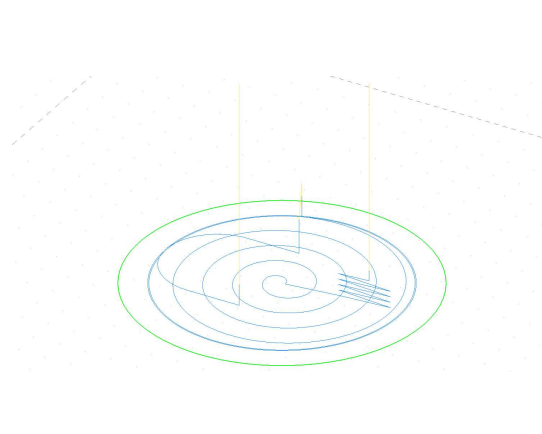


OPERATION INFO

Pocket (Standard)

| | |
|-------------|--------------------------------|
| CYCLE TIME: | 0 HOURS, 0 MINUTES, 51 SECONDS |
| COMMENT: | Mill Pocket |

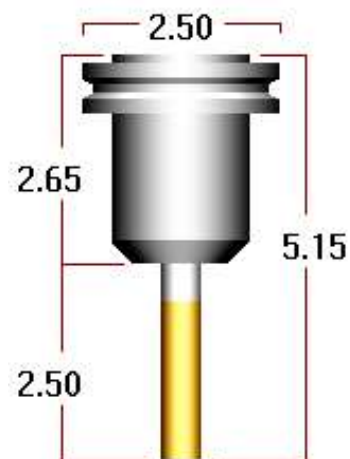
| | |
|------------------|---------------|
| PROGRAM NUMBER: | 3303 |
| SPINDLE SPEED: | 3500 RPM |
| FEEDRATE: | 50.0 inch/min |
| CLEARANCE PLANE: | 2.0 |
| RETRACT PLANE: | 0.25 |
| FEED PLANE: | 0.2 |
| DEPTH: | 0.0 |
| STOCK TO LEAVE: | 0.0 |
| COMP TO TIP: | YES |
| WORK OFFSET: | 0 |



TOOL INFO

1/2" FLAT 2 FLUTE EM

| | |
|-------------------|---------------------|
| TYPE: | Endmill1 Flat |
| NUMBER: | 2 |
| DIAMETER: | 0.5 |
| CORNER RADIUS: | 0.0 |
| LENGTH OFFSET: | 2 |
| DIAMETER OFFSET: | 2 |
| MATERIAL: | Carbide |
| NUMBER OF FLUTES: | 2 |
| FPT: 0.0071 | SFM: 458.1152 |
| MFG CODE: | |
| ASSEMBLY: | 1/2" FLAT 2 |
| HOLDER: | CAT 40 - 1/2 ID, NA |
| TIME: | 00:00:51 |

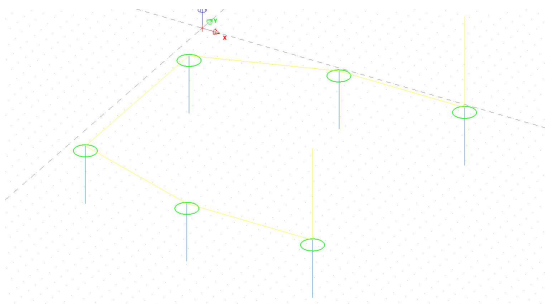


OPERATION INFO

Drill/Counterbore

CYCLE TIME: 0 HOURS, 1 MINUTES, 27 SECONDS
COMMENT: Drill 6 Holes

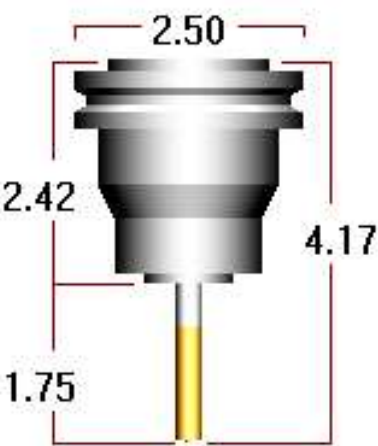
PROGRAM NUMBER: 3303
SPINDLE SPEED: 4000 RPM
FEEDRATE: 5.0 inch/min
CLEARANCE PLANE: 2.0
RETRACT PLANE: 0.0
FEED PLANE: 0.1
DEPTH: -1.1
STOCK TO LEAVE: 0.0
COMP TO TIP: NO
WORK OFFSET: 0



TOOL INFO

.270 Sandvik Carbide Drill

TYPE: Drill
NUMBER: 3
DIAMETER: 0.27
CORNER RADIUS: 0.0
LENGTH OFFSET: 3
DIAMETER OFFSET: 3
MATERIAL: Carbide
NUMBER OF FLUTES: 2
FPT: 0.0006 SFM: 282.7225
MFG CODE: R850-0690-70-A1A
ASSEMBLY: .270 SANDVIK
HOLDER: CAT 40 - NA
TIME: 00:01:27

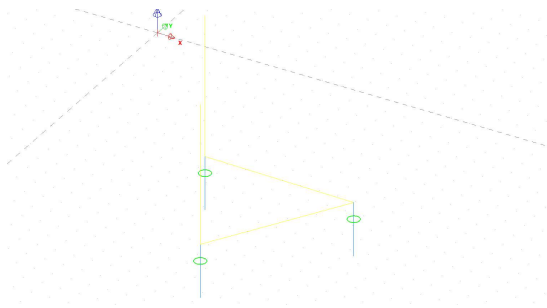


OPERATION INFO

Drill/Counterbore

| | |
|-------------|-------------------------------|
| CYCLE TIME: | 0 HOURS, 1 MINUTES, 5 SECONDS |
| COMMENT: | Drill Three Holes In Pocket |

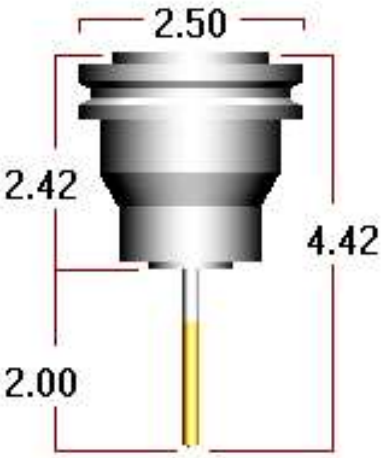
| | |
|------------------|--------------|
| PROGRAM NUMBER: | 3303 |
| SPINDLE SPEED: | 3000 RPM |
| FEEDRATE: | 2.0 inch/min |
| CLEARANCE PLANE: | 2.0 |
| RETRACT PLANE: | 0.0 |
| FEED PLANE: | 0.1 |
| DEPTH: | -0.625 |
| STOCK TO LEAVE: | 0.0 |
| COMP TO TIP: | NO |
| WORK OFFSET: | 0 |



TOOL INFO

.201 CARBIDE TWIST DRILL

| | |
|-------------------|-----------------|
| TYPE: | Drill |
| NUMBER: | 4 |
| DIAMETER: | 0.201 |
| CORNER RADIUS: | 0.0 |
| LENGTH OFFSET: | 4 |
| DIAMETER OFFSET: | 4 |
| MATERIAL: | Carbide |
| NUMBER OF FLUTES: | 2 |
| FPT: 0.0003 | SFM: 157.8534 |
| MFG CODE: | R850-510-70-A1A |
| ASSEMBLY: | .201 CARBIDE |
| HOLDER: | CAT 40 - NA |
| TIME: | 00:01:05 |

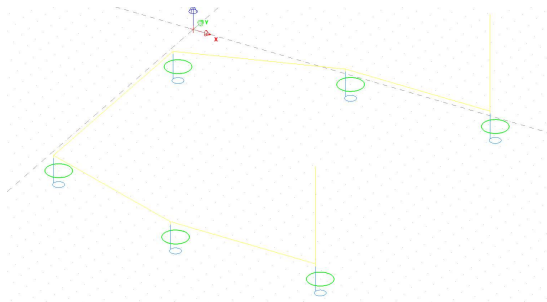


OPERATION INFO

Contour (2D)

| | |
|-------------|--------------------------------|
| CYCLE TIME: | 0 HOURS, 0 MINUTES, 20 SECONDS |
| COMMENT: | Mill 6 C'Bores |

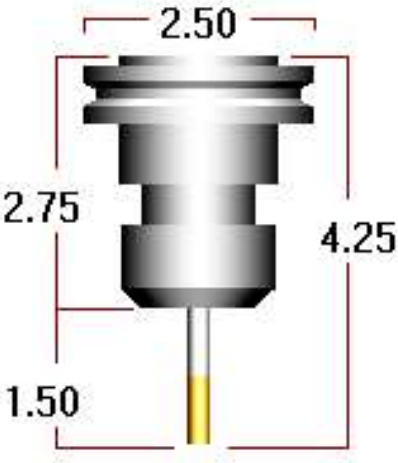
| | |
|------------------|---------------|
| PROGRAM NUMBER: | 3303 |
| SPINDLE SPEED: | 4000 RPM |
| FEEDRATE: | 25.0 inch/min |
| CLEARANCE PLANE: | 2.0 |
| RETRACT PLANE: | 0.25 |
| FEED PLANE: | 0.2 |
| DEPTH: | -0.25 |
| STOCK TO LEAVE: | 0.0 |
| COMP TO TIP: | YES |
| WORK OFFSET: | 0 |



TOOL INFO

1/4" FLAT 2 FLUTE CARBIDE EM

| | |
|-------------------|----------------------|
| TYPE: | Endmill1 Flat |
| NUMBER: | 5 |
| DIAMETER: | 0.25 |
| CORNER RADIUS: | 0.0 |
| LENGTH OFFSET: | 5 |
| DIAMETER OFFSET: | 5 |
| MATERIAL: | Carbide |
| NUMBER OF FLUTES: | 2 |
| FPT: 0.0031 | SFM: 261.7801 |
| MFG CODE: | |
| ASSEMBLY: | 1/4" FLAT 2 |
| HOLDER: | CAT 40 - ER 25 NA |
| TIME: | 00:00:20 |

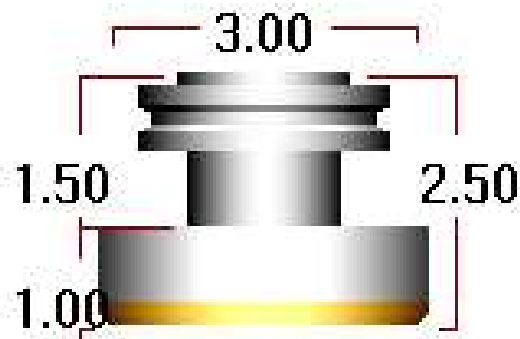


TOOL LIST

Sorted: NO

TOOL INFO**3" FACE MILL**

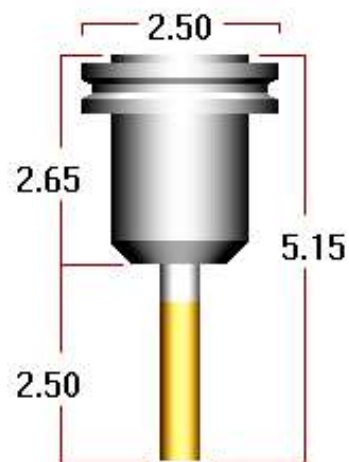
TYPE: Face mill
NUMBER: 1
DIAMETER: 3.0
CORNER RADIUS: 0.0
LENGTH OFFSET: 1
DIAMETER OFFSET: 1
MATERIAL: Carbide
NUMBER OF FLUTES: 6
FPT: 0.0083 SFM: 1570.6806
MFG CODE:
ASSEMBLY: 3" FACE MILL
HOLDER: CAT 40 - FACE NA
TIME: 00:00:24



USED BY OPERATION: # 1 Facing

TOOL INFO**1/2" FLAT 2 FLUTE EM**

TYPE: Endmill1 Flat
NUMBER: 2
DIAMETER: 0.5
CORNER RADIUS: 0.0
LENGTH OFFSET: 2
DIAMETER OFFSET: 2
MATERIAL: Carbide
NUMBER OF FLUTES: 2
FPT: 0.0071 SFM: 458.1152
MFG CODE:
ASSEMBLY: 1/2" FLAT 2
HOLDER: CAT 40 - 1/2 ID, NA
TIME: 00:03:27

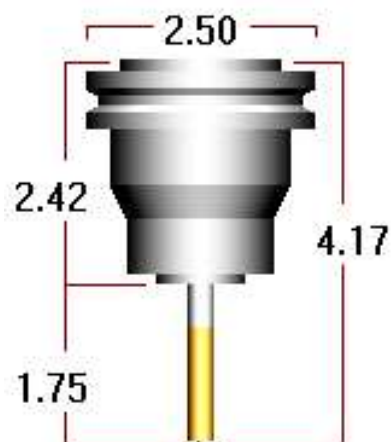


USED BY OPERATION: # 2 Contour (2D)

USED BY OPERATION: # 3 Pocket (Standard)

TOOL INFO**.270 Sandvik Carbide Drill**

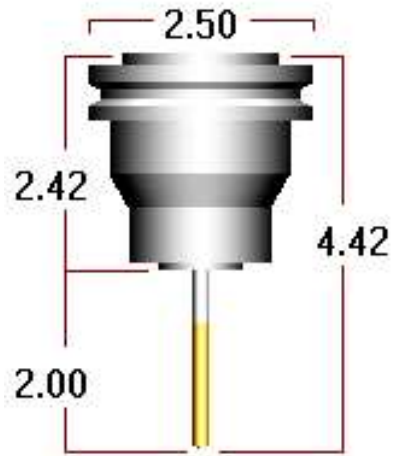
TYPE: Drill
NUMBER: 3
DIAMETER: 0.27
CORNER RADIUS: 0.0
LENGTH OFFSET: 3
DIAMETER OFFSET: 3
MATERIAL: Carbide
NUMBER OF FLUTES: 2
FPT: 0.0006 SFM: 282.7225
MFG CODE: R850-0690-70-A1A
ASSEMBLY: .270 SANDVIK
HOLDER: CAT 40 - NA
TIME: 00:01:27



USED BY OPERATION: # 4 Drill/Counterbore

TOOL INFO**.201 CARBIDE TWIST DRILL**

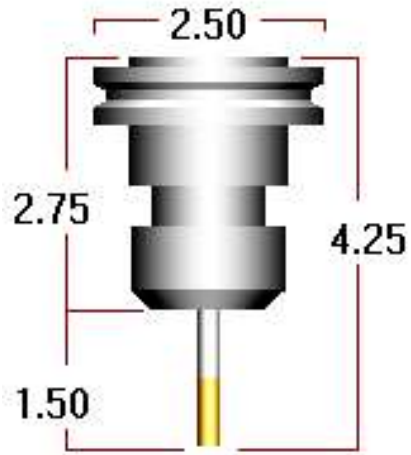
| | |
|-------------------|-----------------|
| TYPE: | Drill |
| NUMBER: | 4 |
| DIAMETER: | 0.201 |
| CORNER RADIUS: | 0.0 |
| LENGTH OFFSET: | 4 |
| DIAMETER OFFSET: | 4 |
| MATERIAL: | Carbide |
| NUMBER OF FLUTES: | 2 |
| FPT: 0.0003 | SFM: 157.8534 |
| MFG CODE: | R850-510-70-A1A |
| ASSEMBLY: | .201 CARBIDE |
| HOLDER: | CAT 40 - NA |
| TIME: | 00:01:05 |



| | | |
|--------------------|-----|-------------------|
| USED BY OPERATION: | # 5 | Drill/Counterbore |
|--------------------|-----|-------------------|

TOOL INFO**1/4" FLAT 2 FLUTE CARBIDE EM**

| | |
|-------------------|-------------------|
| TYPE: | Endmill1 Flat |
| NUMBER: | 5 |
| DIAMETER: | 0.25 |
| CORNER RADIUS: | 0.0 |
| LENGTH OFFSET: | 5 |
| DIAMETER OFFSET: | 5 |
| MATERIAL: | Carbide |
| NUMBER OF FLUTES: | 2 |
| FPT: 0.0031 | SFM: 261.7801 |
| MFG CODE: | |
| ASSEMBLY: | 1/4" FLAT 2 |
| HOLDER: | CAT 40 - ER 25 NA |
| TIME: | 00:00:20 |



| | | |
|--------------------|-----|--------------|
| USED BY OPERATION: | # 6 | Contour (2D) |
|--------------------|-----|--------------|

WORK OFFSETS**OFFSET INFO**

| | | |
|--------------------|------------|-----------------------|
| NUMBER: 0 | PLANE: TOP | ORIGIN: 0.0, 0.0, 0.0 |
| USED BY OPERATION: | # 1 | Facing |
| USED BY OPERATION: | # 2 | Contour (2D) |
| USED BY OPERATION: | # 3 | Pocket (Standard) |
| USED BY OPERATION: | # 4 | Drill/Counterbore |
| USED BY OPERATION: | # 5 | Drill/Counterbore |
| USED BY OPERATION: | # 6 | Contour (2D) |