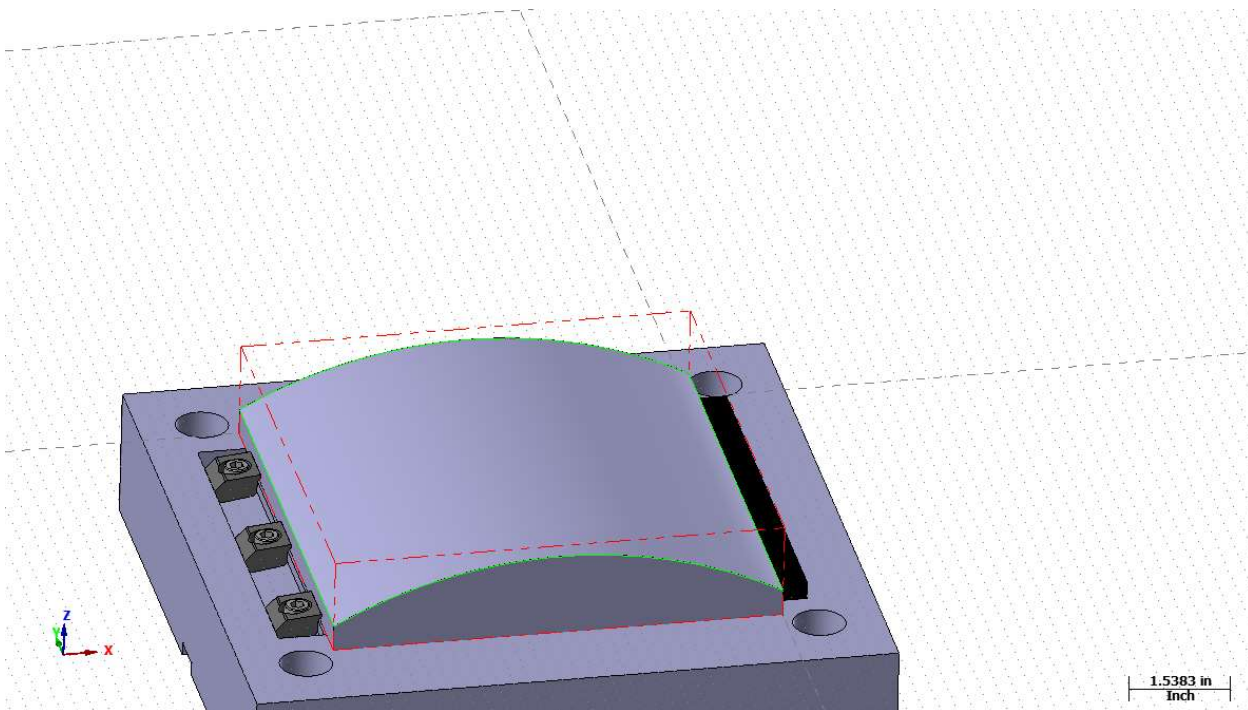


3 - AXIS VMC

GENERAL INFORMATION

| | | |
|--------------|--------------|-------------|
| CLASS | PMT 280 | |
| PROJECT NAME | 330-2 | |
| PROGRAMMER: | Devin Watson | |
| DRAWING: | PMT 330-2 | REVISION: A |
| DATE: | 2/25/2016 | |

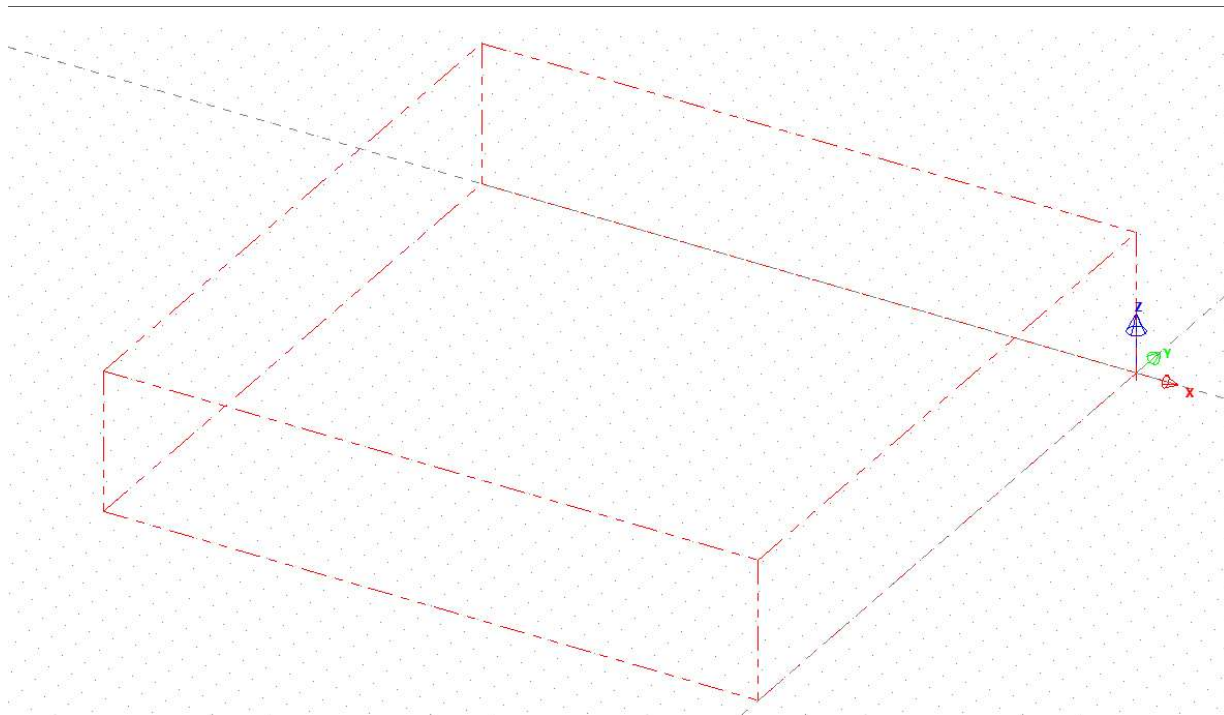


COMMENTS

| |
|--|
| |
| |
| |



DUE #1303832



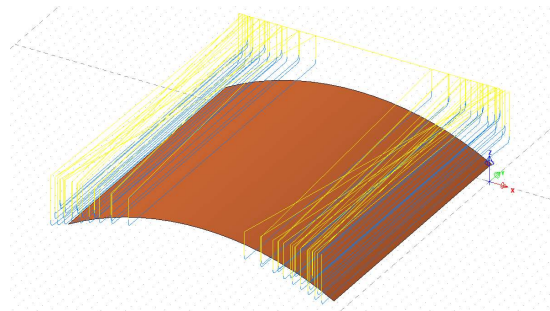
| | |
|---------------|---------------|
| STOCK: | YES |
| SHAPE: | Box |
| SIZE: | 7.0, 7.0, 1.5 |
| RADIUS: | NA |
| LENGTH: | NA |
| AXIS: | NA |
| FILE: | NA |
| IDN: | NA |

CYCLE TIME: 1 HOURS, 3 MINUTES, 58 SECONDS

OPERATION LIST

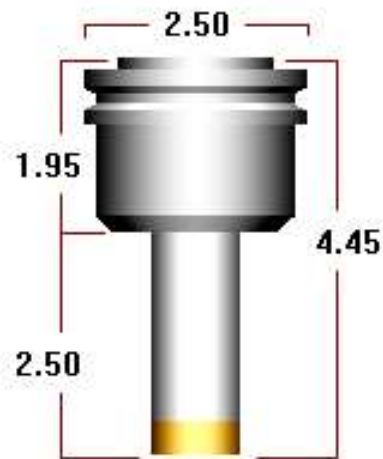
| OPERATION INFO | Surface High Speed (Core roughing) |
|----------------|------------------------------------|
| CYCLE TIME: | 0 HOURS, 7 MINUTES, 6 SECONDS |
| COMMENT: | Rough Top of Part |

| | |
|------------------|---------------|
| PROGRAM NUMBER: | 3302 |
| SPINDLE SPEED: | 3500 RPM |
| FEEDRATE: | 72.0 inch/min |
| CLEARANCE PLANE: | 2.0 |
| RETRACT PLANE: | 0.15 |
| FEED PLANE: | 0.025 |
| DEPTH: | NA |
| STOCK TO LEAVE: | 0.02 |
| COMP TO TIP: | YES |
| WORK OFFSET: | 0 |



| TOOL INFO | 1" Insertable Endmill |
|-----------|-----------------------|
|-----------|-----------------------|

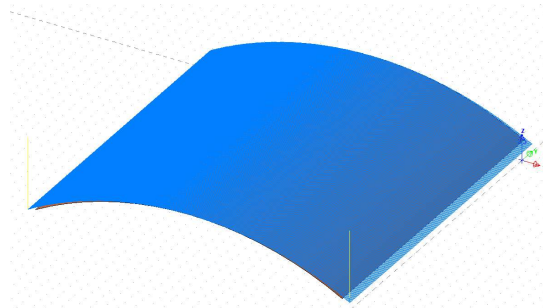
| | |
|-------------------|--------------------|
| TYPE: | Endmill1 Flat |
| NUMBER: | 1 |
| DIAMETER: | 1.0 |
| CORNER RADIUS: | 0.0 |
| LENGTH OFFSET: | 1 |
| DIAMETER OFFSET: | 1 |
| MATERIAL: | Carbide |
| NUMBER OF FLUTES: | 3 |
| FPT: 0.0069 | SFM: 916.2304 |
| MFG CODE: | R390 Shoulder Mill |
| ASSEMBLY: | 1" INSERTABLE |
| HOLDER: | CAT 40 - ID 1 NA |
| TIME: | 00:07:06 |



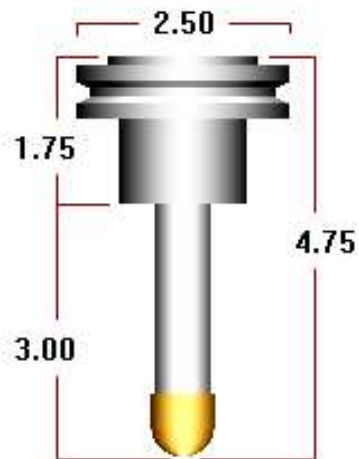
OPERATION INFO**Surface Finish Parallel**

| | |
|-------------|--------------------------------|
| CYCLE TIME: | 0 HOURS, 53 MINUTES, 5 SECONDS |
| COMMENT: | Finish Surface |

| | |
|------------------|----------------|
| PROGRAM NUMBER: | 3302 |
| SPINDLE SPEED: | 5000 RPM |
| FEEDRATE: | 100.0 inch/min |
| CLEARANCE PLANE: | 2.0 |
| RETRACT PLANE: | 0.25 |
| FEED PLANE: | 0.1 |
| DEPTH: | NA |
| STOCK TO LEAVE: | 0.0 |
| COMP TO TIP: | YES |
| WORK OFFSET: | 0 |

**TOOL INFO****3/4 BALL INSERT**

| | |
|-------------------|-----------------------|
| TYPE: | Endmill2 Sphere |
| NUMBER: | 2 |
| DIAMETER: | 0.75 |
| CORNER RADIUS: | 0.375 |
| LENGTH OFFSET: | 2 |
| DIAMETER OFFSET: | 2 |
| MATERIAL: | Carbide |
| NUMBER OF FLUTES: | 2 |
| FPT: 0.01 | SFM: 981.6754 |
| MFG CODE: | ZBS2048 |
| ASSEMBLY: | 3/4 BALL |
| HOLDER: | CAT 40 - ID 1 NA |
| TIME: | 00:53:05 |

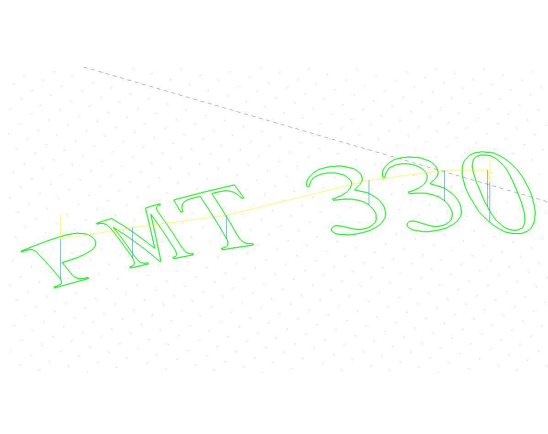


OPERATION INFO

Contour (3D)

| | |
|-------------|--------------------------------|
| CYCLE TIME: | 0 HOURS, 3 MINUTES, 45 SECONDS |
| COMMENT: | Finish Letters on Part |

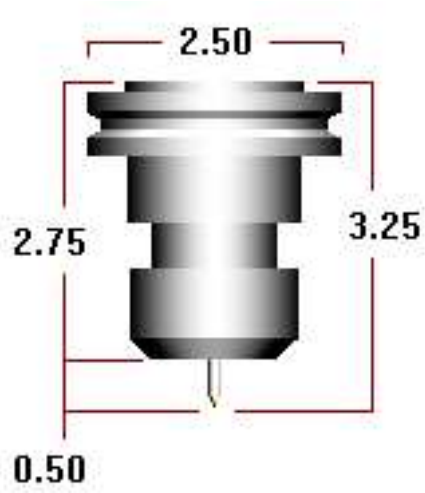
| | |
|------------------|---------------|
| PROGRAM NUMBER: | 3302 |
| SPINDLE SPEED: | 5000 RPM |
| FEEDRATE: | 12.0 inch/min |
| CLEARANCE PLANE: | 2.0 |
| RETRACT PLANE: | 0.25 |
| FEED PLANE: | 0.2 |
| DEPTH: | 0.0 |
| STOCK TO LEAVE: | 0.0 |
| COMP TO TIP: | YES |
| WORK OFFSET: | 0 |



TOOL INFO

#1 CARBIDE CENTER DRILL

| | |
|-------------------|----------------------|
| TYPE: | Center Drill |
| NUMBER: | 3 |
| DIAMETER: | 0.125 |
| CORNER RADIUS: | 0.0 |
| LENGTH OFFSET: | 3 |
| DIAMETER OFFSET: | 3 |
| MATERIAL: | Carbide |
| NUMBER OF FLUTES: | 2 |
| FPT: 0.0012 | SFM: 163.6126 |
| MFG CODE: | |
| ASSEMBLY: | #1 CARBIDE |
| HOLDER: | CAT 40 - ER 25 NA |
| TIME: | 00:03:45 |

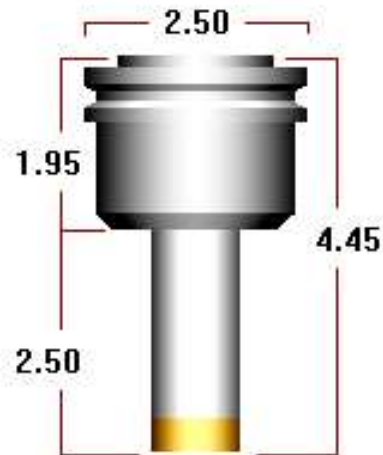


TOOL LIST

Sorted: ASC

TOOL INFO**1" Insertable Endmill**

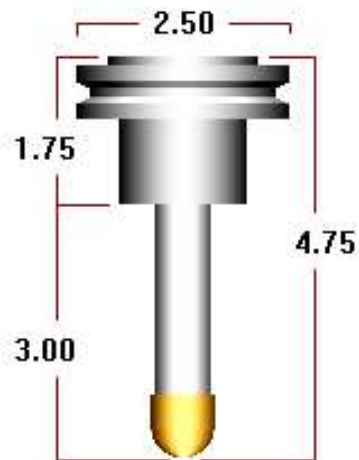
TYPE: Endmill1 Flat
NUMBER: 1
DIAMETER: 1.0
CORNER RADIUS: 0.0
LENGTH OFFSET: 1
DIAMETER OFFSET: 1
MATERIAL: Carbide
NUMBER OF FLUTES: 3
FPT: 0.0069 SFM: 916.2304
MFG CODE: R390 Shoulder Mill
ASSEMBLY: 1" INSERTABLE
HOLDER: CAT 40 - ID 1 NA
TIME: 00:07:06



USED BY OPERATION: # 4 Surface High Speed (Core roughing)

TOOL INFO**3/4 BALL INSERT**

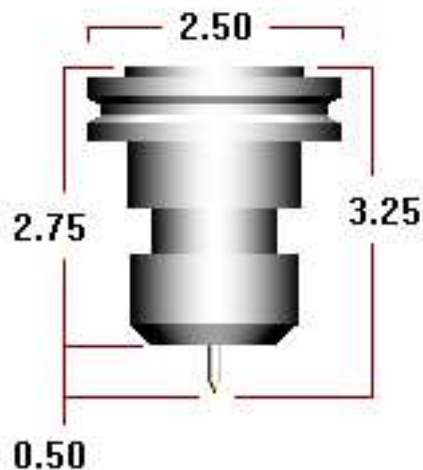
TYPE: Endmill2 Sphere
NUMBER: 2
DIAMETER: 0.75
CORNER RADIUS: 0.375
LENGTH OFFSET: 2
DIAMETER OFFSET: 2
MATERIAL: Carbide
NUMBER OF FLUTES: 2
FPT: 0.01 SFM: 981.6754
MFG CODE: ZBS2048
ASSEMBLY: 3/4 BALL
HOLDER: CAT 40 - ID 1 NA
TIME: 00:53:05



USED BY OPERATION: # 5 Surface Finish Parallel

TOOL INFO**#1 CARBIDE CENTER DRILL**

TYPE: Center Drill
NUMBER: 3
DIAMETER: 0.125
CORNER RADIUS: 0.0
LENGTH OFFSET: 3
DIAMETER OFFSET: 3
MATERIAL: Carbide
NUMBER OF FLUTES: 2
FPT: 0.0012 SFM: 163.6126
MFG CODE:
ASSEMBLY: #1 CARBIDE
HOLDER: CAT 40 - ER 25 NA
TIME: 00:03:45



USED BY OPERATION: # 6 Contour (3D)

WORK OFFSETS

OFFSET INFO

| | | |
|--------------------|------------|------------------------------------|
| NUMBER: 0 | PLANE: TOP | ORIGIN: 0.0, 0.0, 0.0 |
| USED BY OPERATION: | # 4 | Surface High Speed (Core roughing) |
| USED BY OPERATION: | # 5 | Surface Finish Parallel |
| USED BY OPERATION: | # 6 | Contour (3D) |