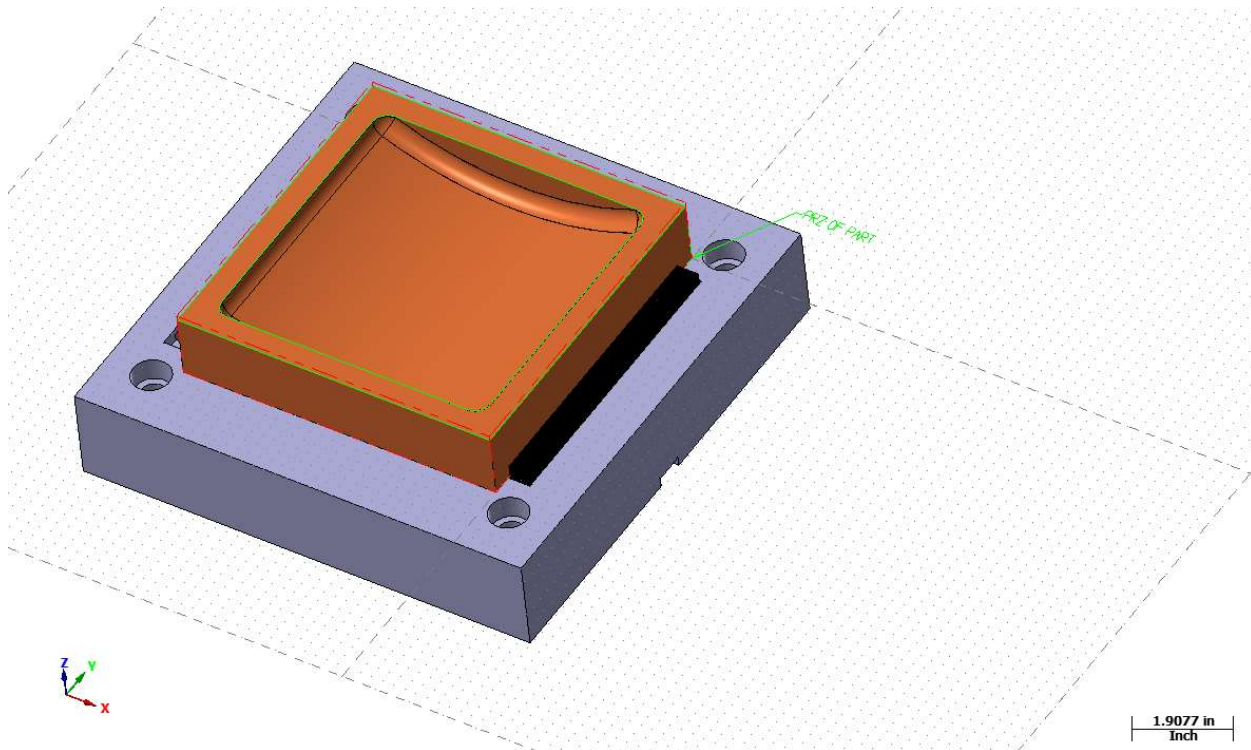


### 3 - AXIS VMC

#### GENERAL INFORMATION

CLASS	PMT 280
PROJECT NAME	280-1
PROGRAMMER:	Devin Watson
DRAWING:	PMT 380-1
DATE:	2/25/2016

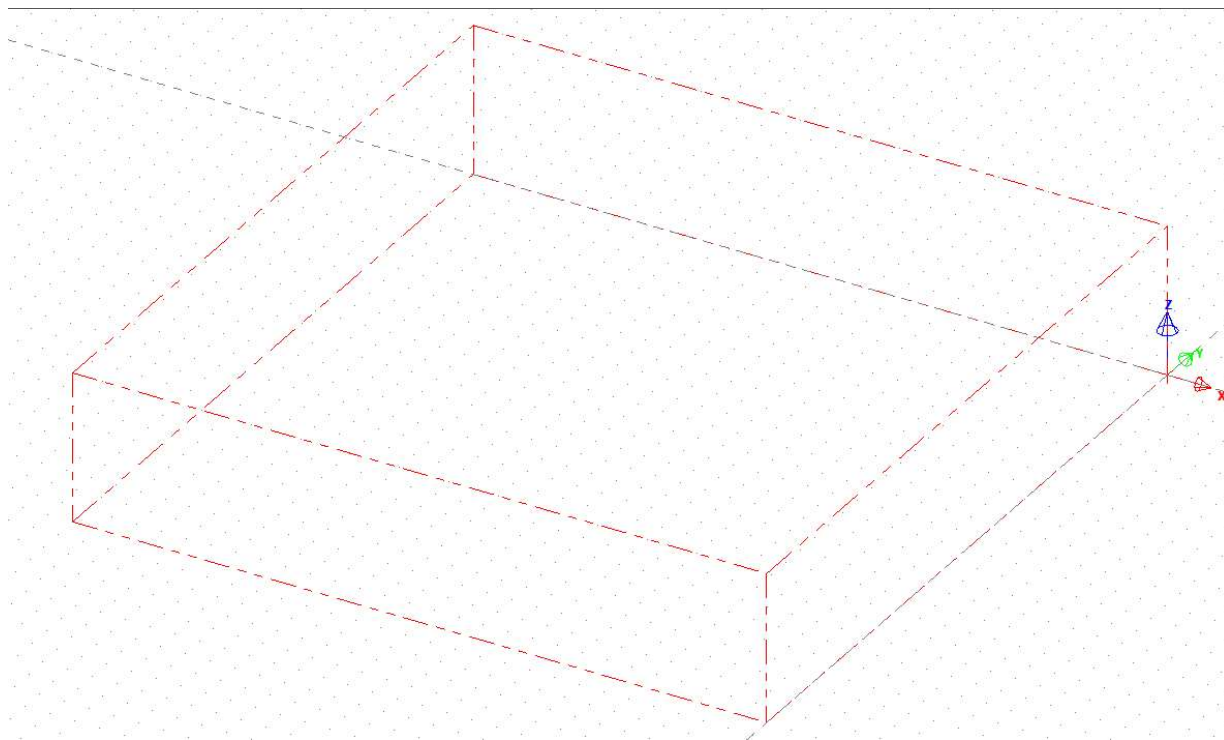
REVISION:



#### COMMENTS




DUE #1303832



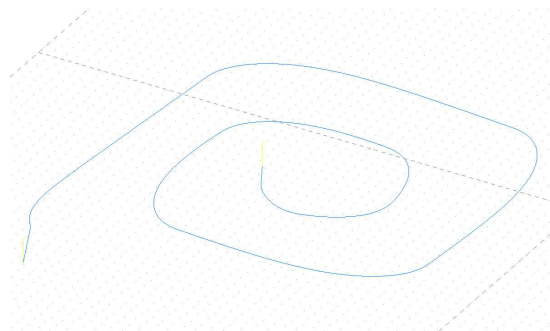
<b>STOCK:</b>	YES
SHAPE:	Box
SIZE:	7.0, 7.0, 1.5
RADIUS:	NA
LENGTH:	NA
AXIS:	NA
FILE:	NA
IDN:	NA

CYCLE TIME: 0 HOURS, 43 MINUTES, 52 SECONDS

OPERATION LIST

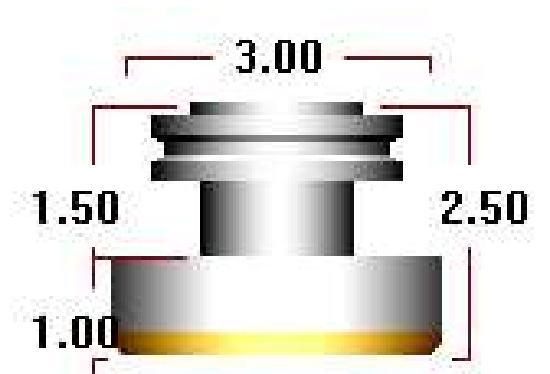
OPERATION INFO	Facing
CYCLE TIME:	0 HOURS, 0 MINUTES, 25 SECONDS
COMMENT:	Face top of part to clean

PROGRAM NUMBER:	3302
SPINDLE SPEED:	2000 RPM
FEEDRATE:	100.0 inch/min
CLEARANCE PLANE:	2.0
RETRACT PLANE:	0.25
FEED PLANE:	0.2
DEPTH:	1.4
STOCK TO LEAVE:	0.0
COMP TO TIP:	YES
WORK OFFSET:	0



TOOL INFO 3" FACE MILL

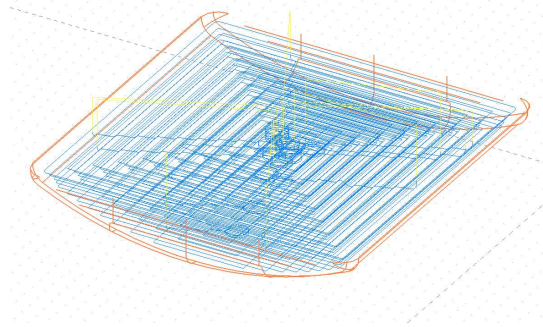
TYPE:	Face mill
NUMBER:	5
DIAMETER:	3.0
CORNER RADIUS:	0.0
LENGTH OFFSET:	5
DIAMETER OFFSET:	5
MATERIAL:	Carbide
NUMBER OF FLUTES:	6
FPT: 0.0083	SFM: 1570.6806
MFG CODE:	
ASSEMBLY:	3" FACE MILL
HOLDER:	CAT 40 - FACE NA
TIME:	00:00:25



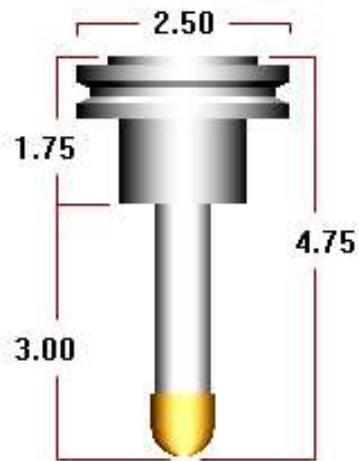
**OPERATION INFO****Surface High Speed (Area clearance)**

CYCLE TIME: 0 HOURS, 12 MINUTES, 8 SECONDS  
COMMENT:

PROGRAM NUMBER: 3302  
SPINDLE SPEED: 5000 RPM  
FEEDRATE: 100.0 inch/min  
CLEARANCE PLANE: 2.0  
RETRACT PLANE: 0.15  
FEED PLANE: 0.025  
DEPTH: NA  
STOCK TO LEAVE: 0.015  
COMP TO TIP: YES  
WORK OFFSET: 0

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

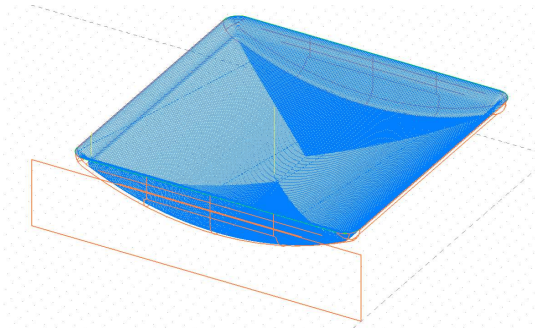
TYPE: Endmill2 Sphere  
NUMBER: 2  
DIAMETER: 0.75  
CORNER RADIUS: 0.375  
LENGTH OFFSET: 3  
DIAMETER OFFSET: 3  
MATERIAL: Carbide  
NUMBER OF FLUTES: 2  
FPT: 0.01 SFM: 981.6754  
MFG CODE: ZBS2048  
ASSEMBLY: 3/4 BALL  
HOLDER: CAT 40 - ID 1 NA  
TIME: 00:12:08



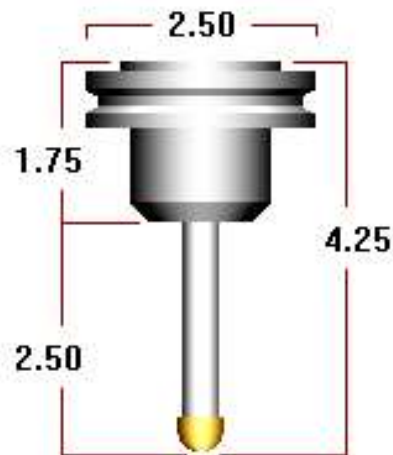
**OPERATION INFO****Surface High Speed (Scallop)**

CYCLE TIME:	0 HOURS, 31 MINUTES, 18 SECONDS
COMMENT:	Finish Cavity

PROGRAM NUMBER:	3302
SPINDLE SPEED:	5000 RPM
FEEDRATE:	100.0 inch/min
CLEARANCE PLANE:	2.0
RETRACT PLANE:	0.15
FEED PLANE:	0.025
DEPTH:	NA
STOCK TO LEAVE:	0.0
COMP TO TIP:	YES
WORK OFFSET:	0

**TOOL INFO****1/2" BALL INSERT TOOL**

TYPE:	Endmill2 Sphere
NUMBER:	7
DIAMETER:	0.5
CORNER RADIUS:	0.25
LENGTH OFFSET:	7
DIAMETER OFFSET:	7
MATERIAL:	Carbide
NUMBER OF FLUTES:	2
FPT: 0.01	SFM: 654.4503
MFG CODE:	
ASSEMBLY:	1/2" BALL
HOLDER:	CAT 40 - ID 0      NA
TIME:	00:31:18

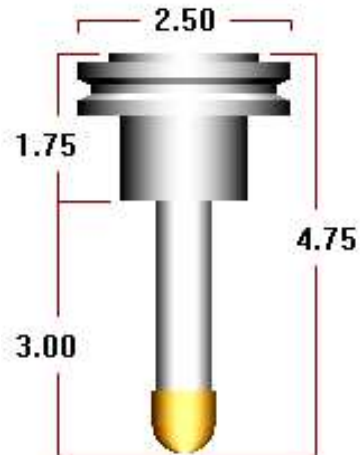


**TOOL LIST**

Sorted: ASC

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

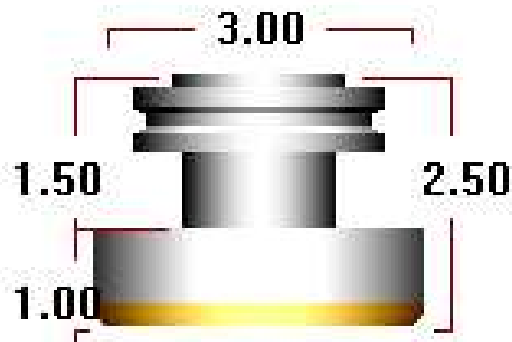
TYPE: Endmill2 Sphere  
NUMBER: 2  
DIAMETER: 0.75  
CORNER RADIUS: 0.375  
LENGTH OFFSET: 3  
DIAMETER OFFSET: 3  
MATERIAL: Carbide  
NUMBER OF FLUTES: 2  
FPT: 0.01 SFM: 981.6754  
MFG CODE: ZBS2048  
ASSEMBLY: 3/4 BALL  
HOLDER: CAT 40 - ID 1 NA  
TIME: 00:12:08



USED BY OPERATION: # 2 Surface High Speed (Area clearance)

**TOOL INFO****3" FACE MILL**

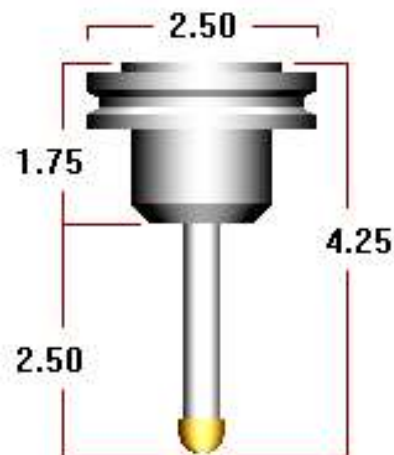
TYPE: Face mill  
NUMBER: 5  
DIAMETER: 3.0  
CORNER RADIUS: 0.0  
LENGTH OFFSET: 5  
DIAMETER OFFSET: 5  
MATERIAL: Carbide  
NUMBER OF FLUTES: 6  
FPT: 0.0083 SFM: 1570.6806  
MFG CODE:  
ASSEMBLY: 3" FACE MILL  
HOLDER: CAT 40 - FACE NA  
TIME: 00:00:25



USED BY OPERATION: # 1 Facing

**TOOL INFO****1/2" BALL INSERT TOOL**

TYPE: Endmill2 Sphere  
NUMBER: 7  
DIAMETER: 0.5  
CORNER RADIUS: 0.25  
LENGTH OFFSET: 7  
DIAMETER OFFSET: 7  
MATERIAL: Carbide  
NUMBER OF FLUTES: 2  
FPT: 0.01 SFM: 654.4503  
MFG CODE:  
ASSEMBLY: 1/2" BALL  
HOLDER: CAT 40 - ID 0 NA  
TIME: 00:31:18



USED BY OPERATION: # 3 Surface High Speed (Scallop)

**WORK OFFSETS**

OFFSET INFO		
NUMBER: 0	PLANE: TOP	ORIGIN: 0.0, 0.0, 0.0
USED BY OPERATION:	# 1	Facing
USED BY OPERATION:	# 2	Surface High Speed (Area clearance)
USED BY OPERATION:	# 3	Surface High Speed (Scallop)