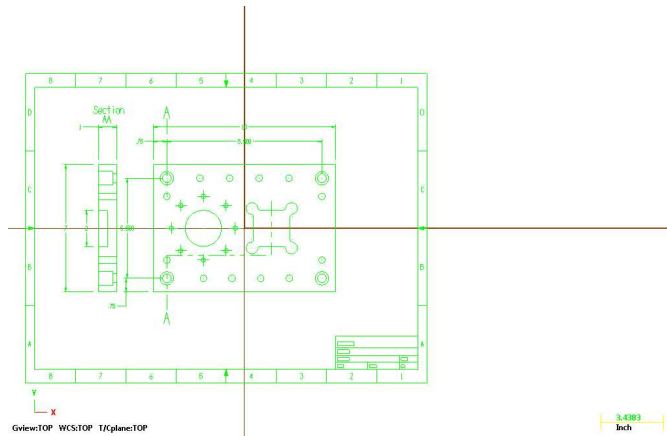
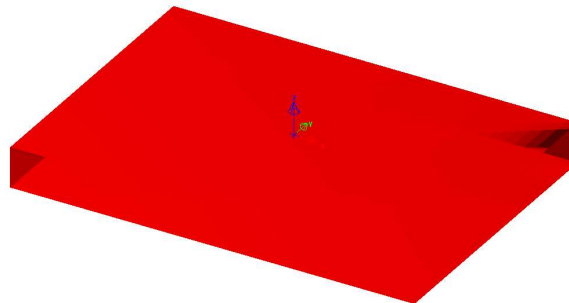


Generic Mill

PROJECT NAME: Test	DRAWING: 1234	REV: A
CUSTOMER NAME: Shopware	DATE: Friday, October 29, 2010	
PROGRAMMER: Dave	TIME: 11:35 AM	
2D_DWG_TP.MCX-5		



STOCK INFO



STOCK:	YES	SHAPE:	Box
SIZE (X, Y, Z)	10.0, 7.0, 1.0	RADIUS:	NA
LENGTH:	NA	AXIS:	NA

NOTES

TEST

PART CYCLE TIME

CYCLE TIME: 0 HOURS, 29 MINUTES, 19 SECONDS

OPERATION LIST**Drill/Counterbore** CYCLE TIME: 00:01:55 MIN Z: -0.155 FPT: 0.001 SFM: 69.8953

COMMENT: Spot .25 Dia Holes

#2 - 0.5000 SPOT DRILL - 1/2 SPOTDRILL LEN OFFSET: 0 DIA OFFSET: 0

Contour (2D) CYCLE TIME: 00:12:22 MIN Z: 0.0 FPT: 0.0023 SFM: 139.9869

COMMENT: _

#7 - 0.7500 ENDMILL1 FLAT - 3/4 FLAT ENDMILL LEN OFFSET: 241 DIA OFFSET: 241

Peck Drill CYCLE TIME: 00:00:07 MIN Z: -0.75 FPT: 0.0048 SFM: 399.9479

COMMENT: _

#3 - 0.2010 DRILL - NO. 7 DRILL LEN OFFSET: 0 DIA OFFSET: 0

Tap CYCLE TIME: 00:00:10 MIN Z: -0.75 FPT: 0.05 SFM: 69.9607

COMMENT: _

#1 - 0.2500 X 20.00 TAP RH - 1/4-20 TAPRH LEN OFFSET: 0 DIA OFFSET: 0

Drill/Counterbore CYCLE TIME: 00:03:36 MIN Z: -0.2175 FPT: 0.0015 SFM: 69.8953

COMMENT: _

#5 - 0.7500 SPOT DRILL - 3/4 SPOTDRILL LEN OFFSET: 0 DIA OFFSET: 0

Peck Drill CYCLE TIME: 00:03:05 MIN Z: -0.9545 FPT: 0.0027 SFM: 69.9644

COMMENT: _

#6 - 0.3480 DRILL - LTR. S DRILL LEN OFFSET: 0 DIA OFFSET: 0

Bore #1 (feed-out) CYCLE TIME: 00:01:40 MIN Z: -0.75 FPT: 0.0044 SFM: 69.9935

COMMENT: _

#4 - 0.3750 REAMER - 3/8 REAMER LEN OFFSET: 0 DIA OFFSET: 0

Pocket (Standard) CYCLE TIME: 00:02:43 MIN Z: -0.5 FPT: 0.0023 SFM: 139.9869

COMMENT: _

#7 - 0.7500 ENDMILL1 FLAT - 3/4 FLAT ENDMILL LEN OFFSET: 241 DIA OFFSET: 241

Pocket (Remachining) CYCLE TIME: 00:03:36 MIN Z: -0.5 FPT: 0.0008 SFM: 139.9869

COMMENT: _

#8 - 0.2500 ENDMILL1 FLAT - 1/4 FLAT ENDMILL

LEN OFFSET: 235 DIA OFFSET: 235

TOOL LIST

TYPE: Spot Drill 1/2 SPOTDRILL	NUMBER: 2 OVERALL LEN: 3.0	DIAMETER: 0.5 FLUTES: 2	TIME: 00:01:55 MATERIAL HSS
TYPE: Endmill1 Flat 3/4 FLAT ENDMILL	NUMBER: 7 OVERALL LEN: 3.75	DIAMETER: 0.75 FLUTES: 4	TIME: 00:15:05 MATERIAL User Def 2
TYPE: Drill NO. 7 DRILL	NUMBER: 3 OVERALL LEN: 3.0	DIAMETER: 0.201 FLUTES: 2	TIME: 00:00:07 MATERIAL Carbide
TYPE: Tap RH 1/4-20 TAPRH	NUMBER: 1 OVERALL LEN: 3.0	DIAMETER: 0.25 FLUTES: 1	TIME: 00:00:10 MATERIAL Ti Coated
TYPE: Spot Drill 3/4 SPOTDRILL	NUMBER: 5 OVERALL LEN: 3.0	DIAMETER: 0.75 FLUTES: 2	TIME: 00:03:36 MATERIAL Ceramic
TYPE: Drill LTR. S DRILL	NUMBER: 6 OVERALL LEN: 3.0	DIAMETER: 0.348 FLUTES: 2	TIME: 00:03:05 MATERIAL HSS
TYPE: Reamer 3/8 REAMER	NUMBER: 4 OVERALL LEN: 3.0	DIAMETER: 0.375 FLUTES: 2	TIME: 00:01:40 MATERIAL HSS
TYPE: Endmill1 Flat 1/4 FLAT ENDMILL	NUMBER: 8 OVERALL LEN: 2.5	DIAMETER: 0.25 FLUTES: 4	TIME: 00:03:36 MATERIAL User Def 1