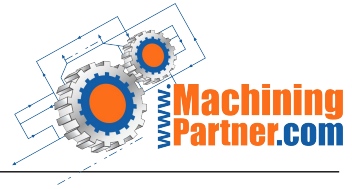


Supplemental Mill Setup Sheet



GENERAL INFORMATION

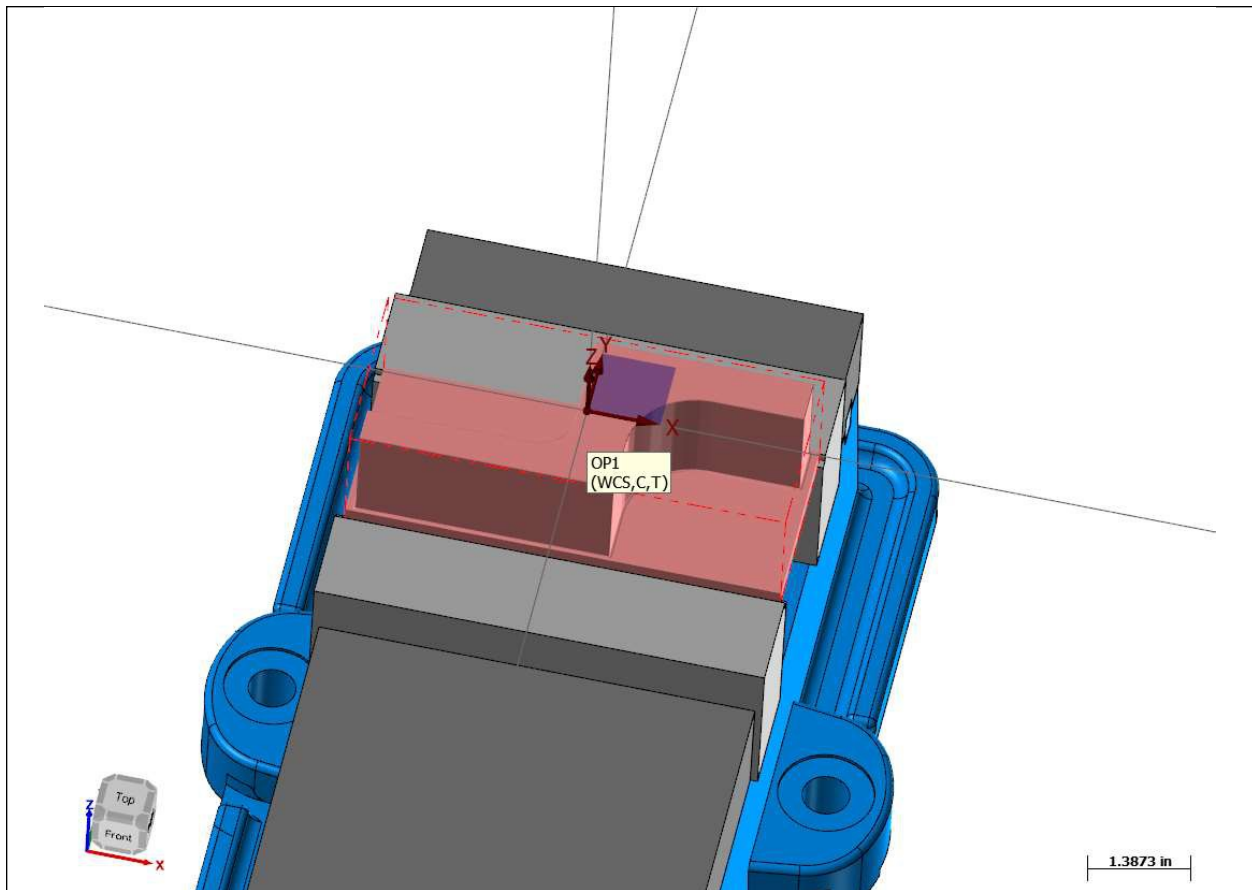
PART NUMBER: CU BRAZE FXTR LARGE
CUSTOMER: LAM-CELEST
PROGRAMMER: Adis
DRAWING: MGK-542-02
DRAWING REV: A
GENERATED: 4/2/2025 12:44 PM

OPERATION: 1
TOTAL OPS: 3
PROGRAM #: 39031
PROVEN: YES

POST: HAAS VERTICAL_NEXT_GEN

MCX: \\P1\FILES01\CAM\SRCPRG\LAM-CELEST\MGK-542-02-A.MCAM

NAME: MGK-542-03-A-OP1.NCI



COMMENTS

XY: CENTER OF MATERIAL
Z: TOP OF MATERIAL MINUS 0.01
(MILL PERIMETER,)
VERIFY MATERIAL IS 1.8 THICK
HOLD .200 - .250 DEEP IN HARD JAWS

MGK-542-02-A-OP1

TOTAL CYCLE TIME:	0 HOURS, 40 MINUTES, 26 SECONDS
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OPERATION LIST

ID#	TOOL #	DESCRIPTION OF TOOL:							#9 - 0.6250 Bull endmill - 5/8 5FL CHPBRKR TPLUS 1.625LOC		
2	9	DESCRIPTION OF TOOLPATH:							ROUGH EXCESS MATERIAL LEFT		
CYCLE	FEEDRATE	SPINDLE	DEPTH	RETRACT	STOCK LEFT	WALLS/FLOOR	TIP COMP	PROVEN			
00:08:16	17.0 inch/min	2750 RPM	-1.52	0.5		0.0 0.03	YES	PROBLEM			
MACHINIST FEEDBACK											

ID#	TOOL #	DESCRIPTION OF TOOL:	#9 - 0.6250 Bull endmill - 5/8 5FL CHPBRKR TPLUS 1.625LOC						
3	9	DESCRIPTION OF TOOLPATH:	ROUGH EXCESS MATERIAL RIGHT						
CYCLE	FEEDRATE	SPINDLE	DEPTH	RETRACT	STOCK LEFT	WALLS/FLOOR	TIP COMP	PROVEN	☐
00:10:54	17.0 inch/min	2750 RPM	-1.52	0.5	0.0	0.03	YES	PROBLEM	☐
MACHINIST FEEDBACK									

ID#	TOOL #	DESCRIPTION OF TOOL:							#9 - 0.6250 Bull endmill - 5/8 5FL CHPBRKR TPLUS 1.625LOC	
4	9	DESCRIPTION OF TOOLPATH:							ROUGH PERIMETER	
CYCLE	FEEDRATE	SPINDLE	DEPTH	RETRACT	STOCK LEFT	WALLS/FLOOR	TIP COMP	PROVEN	☐	
00:10:25	17.0 inch/min	2750 RPM	-1.52	0.2	0.0	0.01	YES	PROBLEM		
MACHINIST FEEDBACK										

ID#	TOOL #	DESCRIPTION OF TOOL:							#9 - 0.6250 Bull endmill - 5/8 5FL CHPBRKR TPLUS 1.625LOC		
5	9	DESCRIPTION OF TOOLPATH:							ROUGH FACE TOP		
CYCLE	FEEDRATE	SPINDLE	DEPTH	RETRACT	STOCK LEFT	WALLS/FLOOR	TIP COMP	PROVEN	☐		
00:01:44	17.0 inch/min	2750 RPM	0.0	1.0	0.0	0.005	YES	PROBLEM	☐		
MACHINIST FEEDBACK											

ID#	TOOL #	DESCRIPTION OF TOOL:							#10 - 0.5000 Flat endmill - 1/2 6FL FINISHER TPLUS 1.625LOC
6	10	DESCRIPTION OF TOOLPATH:							FINISH PERIMETER
CYCLE	FEEDRATE	SPINDLE	DEPTH	RETRACT	STOCK LEFT	WALLS/FLOOR	TIP COMP	PROVEN	☐
00:01:38	12.0 inch/min	2350 RPM	-1.51	0.2		0.0	YES	PROBLEM	☐
MACHINIST FEEDBACK									

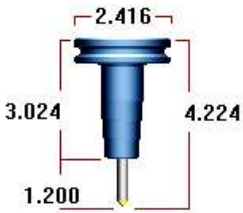
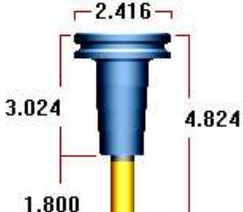
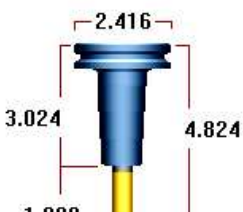
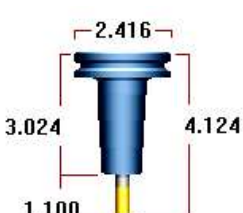
ID#	TOOL #	DESCRIPTION OF TOOL:		#10 - 0.5000 Flat endmill - 1/2 6FL FINISHER TPLUS 1.625LOC					
7	10	DESCRIPTION OF TOOLPATH:		FINISH PERIMETER REMOVE TAPER					
CYCLE	FEEDRATE	SPINDLE	DEPTH	RETRACT	STOCK LEFT	WALLS/FLOOR	TIP COMP	PROVEN	☐
00:01:37	12.0 inch/min	2350 RPM	-1.51	0.2		0.0	YES	PROBLEM	☐
MACHINIST FEEDBACK									

ID#	TOOL #	DESCRIPTION OF TOOL:		#12 - 0.3750 Flat endmill - 3/8 5FL FINISHER TPLUS .750 LOC					
8	12	DESCRIPTION OF TOOLPATH:		FINISH FACE TOP					
CYCLE	FEEDRATE	SPINDLE	DEPTH	RETRACT	STOCK LEFT	WALLS/FLOOR	TIP COMP	PROVEN	☐
00:03:05	12.0 inch/min	4750 RPM	0.0	1.0		0.0	YES	PROBLEM	☐
MACHINIST FEEDBACK									

ID#	TOOL #	DESCRIPTION OF TOOL:		#6 - 0.2500 Chamfer mill - 1/4 X 90 DEG. CHAMFERMILL 4FL COATED				
9	6	DESCRIPTION OF TOOLPATH:		CHAMFER PERIMETER				
CYCLE	FEEDRATE	SPINDLE	DEPTH	RETRACT	STOCK LEFT	WALLS/FLOOR	TIP COMP	PROVEN
00:02:44	6.0 inch/min	4650 RPM	0.0	0.2		0.0	YES	PROBLEM
MACHINIST FEEDBACK								

TOOL LIST-REFERENCE ONLY

SORTED: ASCENDING

 FOR REFERENCE ONLY	MFG NAME: DESTINY MFG CODE: AS21690 OR SIMILAR HLDR (REF): 40-840-1/4z-4 TOOL #: 6 LENGTH #: 6 DIAMETER #: 6	DIAMETER: 0.25 CORNER RADIUS: 0.0 TIP ANGLE: NA FLUTE LENGTH: 0.125 STICKOUT: 1.2 # OF FLUTES: 4
	#6 - 0.2500 Chamfer mill - 1/4 X 90 DEG. CHAMFERMILL 4FL COATED	
 FOR REFERENCE ONLY	MFG NAME: HELICAL MFG CODE: 83118 HLDR (REF): 40-840-5/8z-4 TOOL #: 9 LENGTH #: 9 DIAMETER #: 9	DIAMETER: 0.625 CORNER RADIUS: 0.03 TIP ANGLE: NA FLUTE LENGTH: 1.625 STICKOUT: 1.8 # OF FLUTES: 5
	#9 - 0.6250 Bull endmill - 5/8 5FL CHPBRKR TPLUS 1.625LOC	
 FOR REFERENCE ONLY	MFG NAME: HELICAL MFG CODE: 59911 HLDR (REF): 40-840-1/2z-4 TOOL #: 10 LENGTH #: 10 DIAMETER #: 10	DIAMETER: 0.5 CORNER RADIUS: 0.0 TIP ANGLE: NA FLUTE LENGTH: 1.625 STICKOUT: 1.8 # OF FLUTES: 6
	#10 - 0.5000 Flat endmill - 1/2 6FL FINISHER TPLUS 1.625LOC	
 FOR REFERENCE ONLY	MFG NAME: HELICAL MFG CODE: 82529 HLDR (REF): 40-840-3/8z TOOL #: 12 LENGTH #: 12 DIAMETER #: 12	DIAMETER: 0.375 CORNER RADIUS: 0.0 TIP ANGLE: NA FLUTE LENGTH: 0.75 STICKOUT: 1.1 # OF FLUTES: 5
	#12 - 0.3750 Flat endmill - 3/8 5FL FINISHER TPLUS .750 LOC	