

Supplemental Mill Setup Sheet



GENERAL INFORMATION

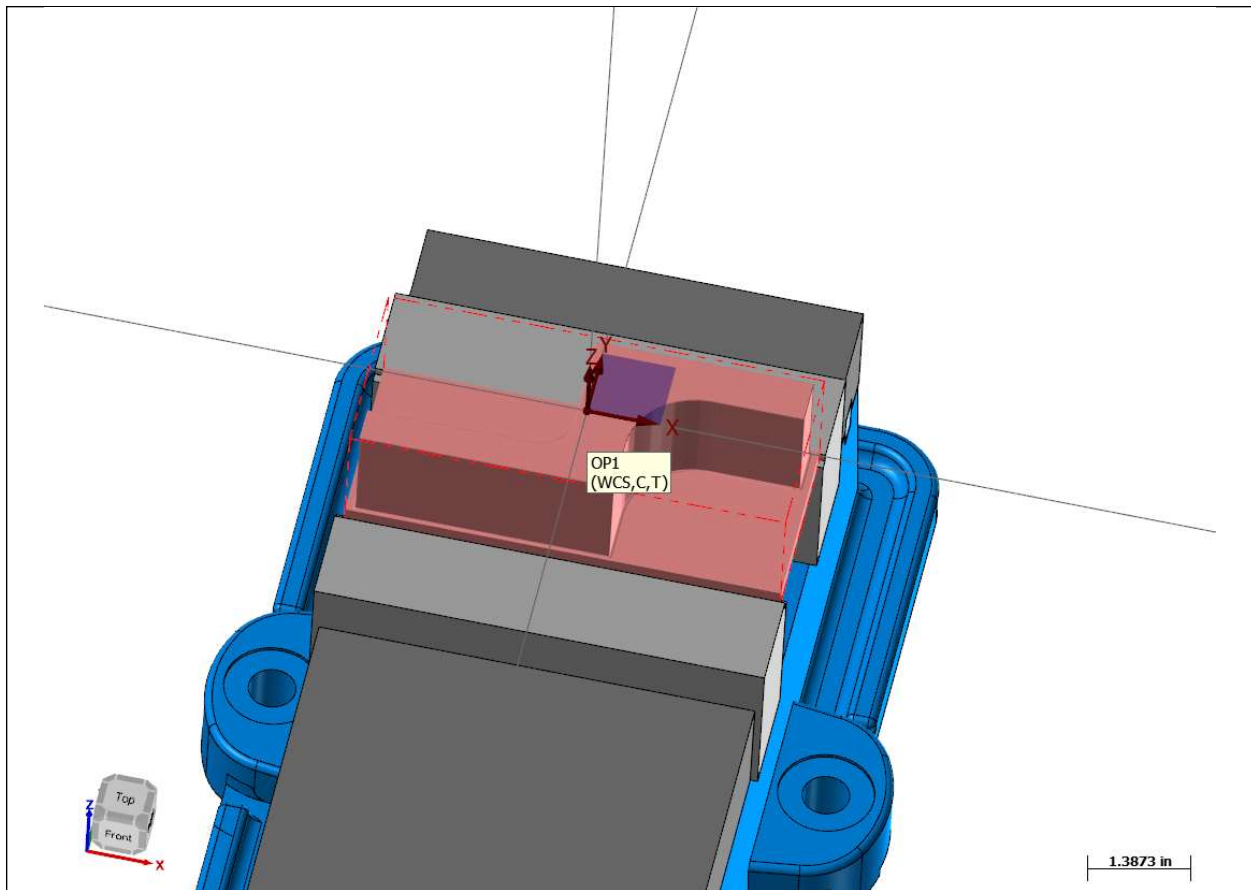
PART NUMBER: CU BRAZE FXTR LARGE
CUSTOMER: LAM-CELEST
PROGRAMMER: Adis
DRAWING: MGK-542-02
DRAWING REV: A
GENERATED: 4/2/2025 12:44 PM

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

POST: HAAS VERTICAL_NEXT_GEN

MCX: \\P1FILES01\CAM\SRCPRG\LAM-CELEST\MGK-542-02-A.MCAM

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



COMMENTS

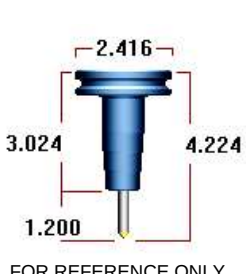
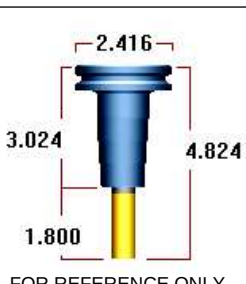
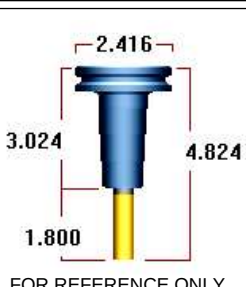
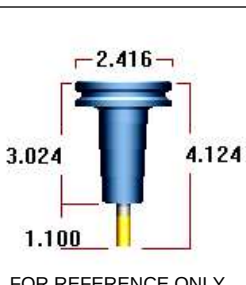
XY: CENTER OF MATERIAL
Z: TOP OF MATERIAL MINUS 0.01
(MILL PERIMETER,)
VERIFY MATERIAL IS 1.8 THICK
HOLD .200 - .250 DEEP IN HARD JAWS

MGK-542-03-A-OP1-NCI

EST. TIME: 00:40:26

ID	T#	OPERATION DESCRIPTION	D	H	RPM	FEED	CLNT	CYCLE
2	9	ROUGH EXCESS MATERIAL LEFT	9	9	2750	17.0	Flood	00:08:16
3	9	ROUGH EXCESS MATERIAL RIGHT	9	9	2750	17.0	Flood	00:10:54
4	9	ROUGH PERIMETER	9	9	2750	17.0	Flood	00:10:25
5	9	ROUGH FACE TOP	9	9	2750	17.0	Flood	00:01:44
6	10	FINISH PERIMETER	10	10	2350	12.0	Flood	00:01:38
7	10	FINISH PERIMETER REMOVE TAPER	10	10	2350	12.0	Flood	00:01:37
8	12	FINISH FACE TOP	12	12	4750	12.0	Flood	00:03:05
9	6	CHAMFER PERIMETER	6	6	4650	6.0	Flood	00:02:44

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