

Supplemental Mill Setup Sheet



GENERAL INFORMATION

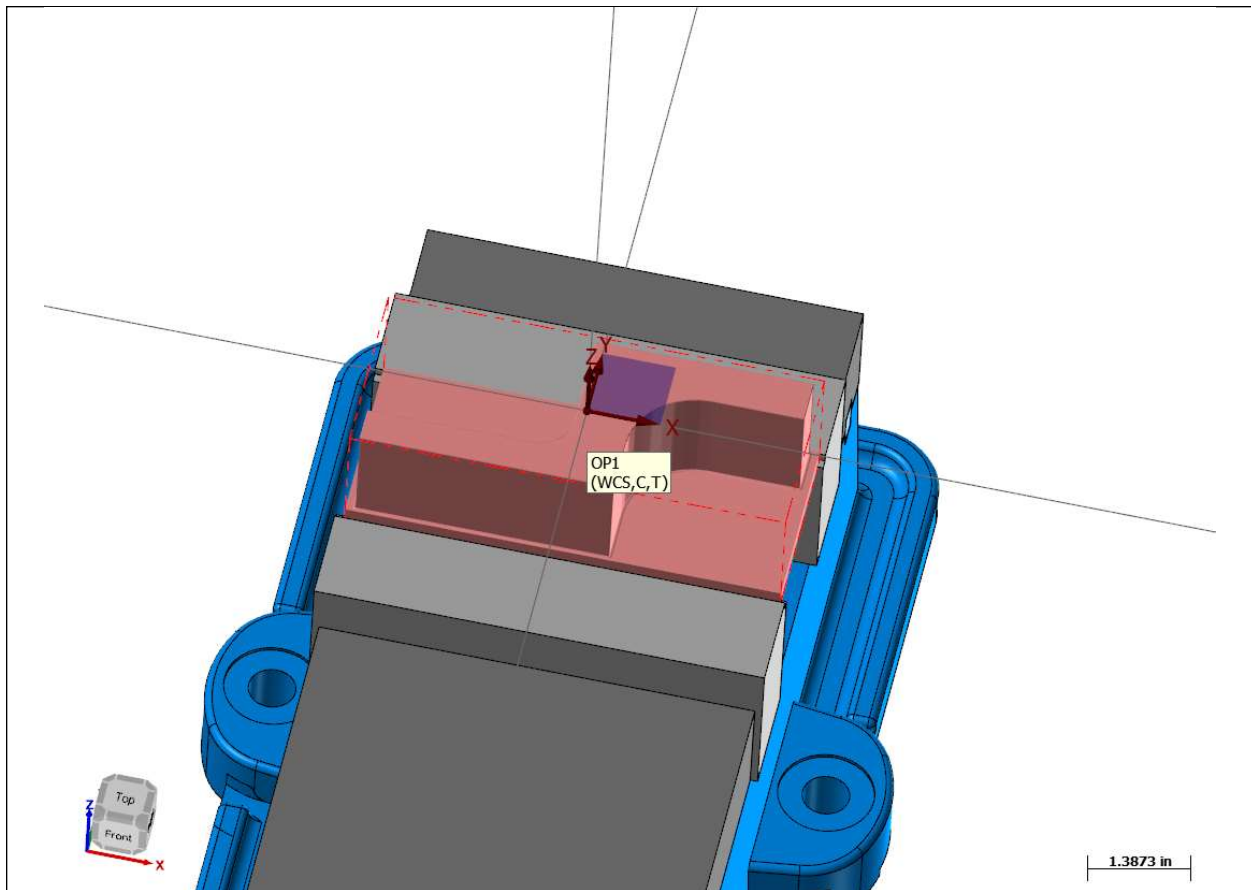
PART NUMBER: CU BRAZE FXTR LARGE
CUSTOMER: FM INDUSTRIES
PROGRAMMER: Adis Pilavdzic Bey
DRAWING: WJ10390-03
DRAWING REV: A
GENERATED: 4/2/2024 12:44 PM

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

POST: HAAS VERTICAL_NEXT_GEN

MCX: \\P1FILES01\CAM\SRCPRG\FM\WJ10390\WJ10390-03\MILL\MCX-SOURCE\WJ10390-03-A.MCAM

NAME: WJ10390-03-A-OP1.NCI



COMMENTS

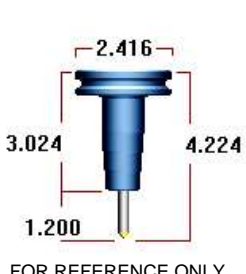
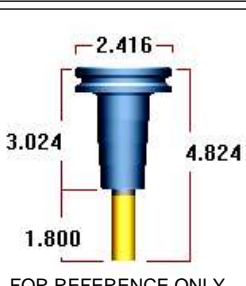
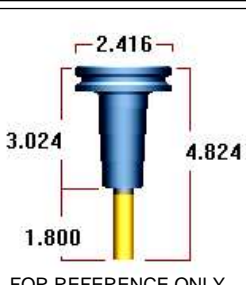
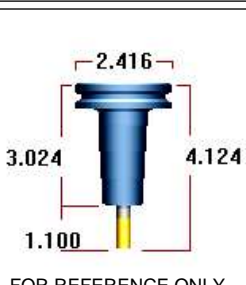
XY: CENTER OF MATERIAL
Z: TOP OF MATERIAL MINUS 0.01
(MILL PERIMETER,)
VERIFY MATERIAL IS 1.8 THICK
HOLD .200 - .250 DEEP IN HARD JAWS

WJ10390-03-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

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