



## GENERAL INFORMATION

REVISION: A



## COMMENTS

[illegible]

C:\USERS\IMG\DOCUMENTS\MY MCAM2019\ROUTER\NC\IT.NCI

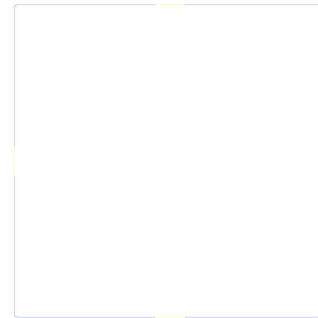
CYCLE TIME: 0 HOURS, 2 MINUTES, 45 SECONDS

### OPERATION LIST

OPERATION INFO 1 - Contour (2D)

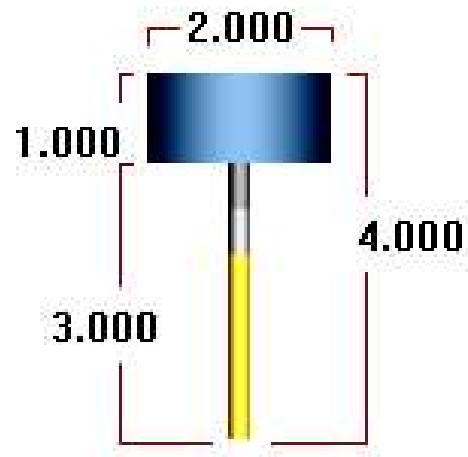
CYCLE TIME: 0 HOURS, 0 MINUTES, 14 SECONDS  
COMMENT:

PROGRAM NUMBER: 0  
SPINDLE SPEED: 18000 RPM  
FEEDRATE: 200.0 inch/min  
CLEARANCE PLANE: 2.0  
RETRACT PLANE: 0.25  
FEED PLANE: 0.1  
DEPTH: 0.0  
STOCK TO LEAVE: 0.0  
COMP TO TIP: NO  
WORK OFFSET: -1



TOOL INFO 1/4 STRAIGHT BIT

TYPE: Straight  
NUMBER: 1  
DIAMETER: 0.25  
CORNER RADIUS: 0.0  
LENGTH OFFSET: 1  
DIAMETER OFFSET: 1  
MATERIAL: HSS  
NUMBER OF FLUTES: 2  
FPT: 0.005 SFM: 1308.9005  
MFG CODE:  
ASSEMBLY:  
HOLDER: Default Holder  
TIME: 00:00:14

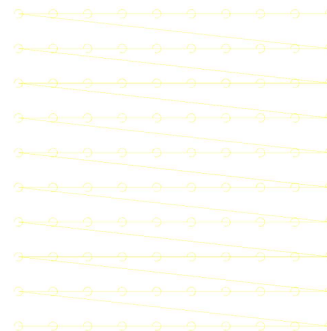


# OPERATION INFO

## 2 - Router Block Drill - Drill/Counterbore

CYCLE TIME: 0 HOURS, 2 MINUTES, 30 SECONDS  
COMMENT:

PROGRAM NUMBER: 0  
SPINDLE SPEED: 1000 RPM  
FEEDRATE: 10.0 inch/min  
CLEARANCE PLANE: 2.0  
RETRACT PLANE: 10.0  
FEED PLANE: 0.25  
DEPTH: 0.0  
STOCK TO LEAVE: 0.0  
COMP TO TIP: NO  
WORK OFFSET: -1



# BLOCK INFO

## #2 - BLOCK DRILL -

OFFSET: 0.0, 0.0, 0.0  
COMMENT:  
TIME: 00:02:30



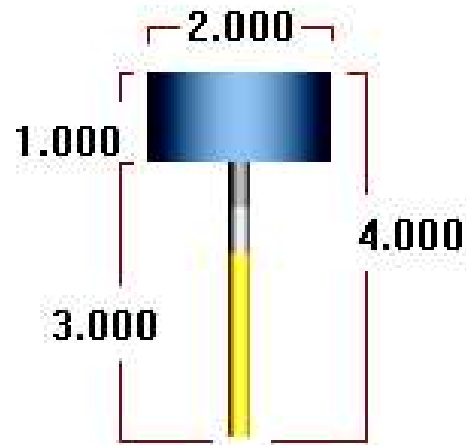
#2 - 0.2500 DRILL - STANDARD DRILL	OFFSET: 0.0, 0.0, 0.0	AGG: NO
#2 - 0.2500 DRILL - STANDARD DRILL	OFFSET: 1.2598, 0.0, 0.0	AGG: NO
#2 - 0.2500 DRILL - STANDARD DRILL	OFFSET: 2.5196, 0.0, 0.0	AGG: NO
#2 - 0.2500 DRILL - STANDARD DRILL	OFFSET: 3.7794, 0.0, 0.0	AGG: NO
#2 - 0.2500 DRILL - STANDARD DRILL	OFFSET: 5.0392, 0.0, 0.0	AGG: NO
#2 - 0.2500 DRILL - STANDARD DRILL	OFFSET: 0.0, -1.2598, 0.0	AGG: NO
#2 - 0.2500 DRILL - STANDARD DRILL	OFFSET: 0.0, -2.5196, 0.0	AGG: NO
#2 - 0.2500 DRILL - STANDARD DRILL	OFFSET: 0.0, -3.7794, 0.0	AGG: NO
#2 - 0.2500 DRILL - STANDARD DRILL	OFFSET: 0.0, -5.0392, 0.0	AGG: NO

**TOOL LIST**

Sorted: NO

**TOOL INFO****1/4 STRAIGHT BIT**

TYPE: Straight  
NUMBER: 1  
DIAMETER: 0.25  
CORNER RADIUS: 0.0  
LENGTH OFFSET: 1  
DIAMETER OFFSET: 1  
MATERIAL: HSS  
NUMBER OF FLUTES: 2  
FPT: 0.005 SFM: 1308.9005  
MFG CODE:  
ASSEMBLY:  
HOLDER: Default Holder  
TIME: 00:00:14



USED BY OPERATION: # 1 1 - Contour (2D)

**BLOCK INFO****#2 - BLOCK DRILL -**

OFFSET: 0.0, 0.0, 0.0  
COMMENT:  
TIME: 00:02:30



#2 - 0.2500 DRILL - STANDARD DRILL OFFSET: 0.0, 0.0, 0.0 AGG: NO  
#2 - 0.2500 DRILL - STANDARD DRILL OFFSET: 1.2598, 0.0, 0.0 AGG: NO  
#2 - 0.2500 DRILL - STANDARD DRILL OFFSET: 2.5196, 0.0, 0.0 AGG: NO  
#2 - 0.2500 DRILL - STANDARD DRILL OFFSET: 3.7794, 0.0, 0.0 AGG: NO  
#2 - 0.2500 DRILL - STANDARD DRILL OFFSET: 5.0392, 0.0, 0.0 AGG: NO  
#2 - 0.2500 DRILL - STANDARD DRILL OFFSET: 0.0, -1.2598, 0.0 AGG: NO  
#2 - 0.2500 DRILL - STANDARD DRILL OFFSET: 0.0, -2.5196, 0.0 AGG: NO  
#2 - 0.2500 DRILL - STANDARD DRILL OFFSET: 0.0, -3.7794, 0.0 AGG: NO  
#2 - 0.2500 DRILL - STANDARD DRILL OFFSET: 0.0, -5.0392, 0.0 AGG: NO

USED BY OPERATION: # 2 2 - Router Block Drill - Drill/Counterbore

**WORK OFFSETS****OFFSET INFO**

NUMBER: -1 PLANE: ORIGIN: 0.0, 0.0, 0.0

USED BY OPERATION: # 1 1 - Contour (2D)

USED BY OPERATION: # 2 2 - Router Block Drill - Drill/Counterbore