



OPERATIONS SETUP SHEET

BLOCK-OPR-1

PART NAME: 226C238-D

CUSTOMER NAME: WHIZZ SYSTEMS

PROJECT : BLOCK-OPR-1

PROGRAMMER: HARIEASH

Monday, February 20, 2023

11:52 PM

OPERATION LIST

OPERATION NAME	TOOL	SPINDLE SPEED	FEEDRATE	MIN X	MIN Y	MIN Z	MAX X	MAX Y	MAX Z	RUN TIME	COMMENT
9 - Pocket (Standard)	2	5730 RPM	43.548 inch/min	2.2745	8.3437	0.0	15.0105	19.5288	1.0	00:06:24	1/2 ENDMILL X 000 DEEP - FACING
10 - Contour (2D)	2	5730 RPM	43.8918 inch/min	2.2175	8.0317	-1.186	15.0675	19.8408	1.0	00:11:26	1/2 ENDMILL X 1186 DEEP - FACING
11 - Contour (2D)	2	5730 RPM	43.8918 inch/min	5.505	9.8483	-1.186	14.755	13.0758	1.0	00:20:13	1/2 ENDMILL X 1186 DEEP - PLUNGE
12 - Contour (2D)	4	6730 RPM	33.0 inch/min	5.505	10. 1232	-1.186	14.755	10.1234	1.0	00:04:29	1/4 ENDMILL X 1186 DEEP
13 - Contour (2D)	2	5730 RPM	43.8918 inch/min	1.5875	8.2867	-1.186	15.6975	19.5858	1.0	00:32:35	1/2 ENDMILL X 1186 DEEP - SIZING
14 - Contour (2D)	2	5730 RPM	43.8918 inch/min	5.92	8.8358	-1.186	11.2632	13.5467	1.0	00:09:29	1/2 ENDMILL X 1186 DEEP - PLUNGE
15 - Drill/Counterbore	16	5500 RPM	10.0 inch/min	2.78	8.8483	-0.0445	14.51	19.0233	1.0	00:00:11	089 SPOT DRILL
16 - Drill/Counterbore	16	5500 RPM	10.0 inch/min	2.78	8.8492	-0.109	14.505	19.0233	1.0	00:00:05	7/32 SPOT DRILL
17 - Peck Drill	11	5500 RPM	50.0 inch/min	2.78	8.8483	-0.2767	14.51	19.0233	1.0	00:00:13	089 DRILL X 250 DEEP
18 - Peck Drill	18	3000 RPM	30.0 inch/min	2.78	8.8492	-0.4157	14.505	19.0233	1.0	00:00:10	7/32 DRILL X 350 DEEP
19 - Pocket (Standard)	4	6730 RPM	33.0 inch/min	5.0476	10. 2169	-0.15	14.0105	18.988	1.0	00:04:30	1/4 ENDMILL X 150 DEEP
20 - Pocket (Standard)	4	6730 RPM	33.0 inch/min	6.4574	10. 1692	-0.2	13.6669	18.9687	1.0	00:03:03	1/4 ENDMILL X 200 DEEP

TOTAL CYCLE 1 HOURS, 32 MINUTES, 54 SECONDS