



# OPERATIONS SETUP SHEET

# BLOCK-OPR-2

PART NAME: 226C238-D

CUSTOMER NAME: WHIZZ SYSTEMS

PROJECT : BLOCK-OPR-2

PROGRAMMER: HARIEASH

Tuesday, February 21, 2023

12:59 AM

**OPERATION LIST**

OPERATION NAME	TOOL	SPINDLE SPEED	FEEDRATE	MIN X	MIN Y	MIN Z	MAX X	MAX Y	MAX Z	RUN TIME	COMMENT
21 - Pocket (Standard)	2	5730 RPM	43.548 inch/min	4.6852	2.0212	0.0	18.9462	11.5776	1.0	00:10:29	1/2 ENDMILL X 000 DEEP - FACING
22 - Contour (2D)	2	5730 RPM	43.8918 inch/min	4.6282	1.7092	-1.71	19.0032	11.8896	1.0	00:06:22	1/2 ENDMILL X 1710 DEEP - FACING
23 - Contour (2D)	2	5730 RPM	43.8918 inch/min	8.005	8.7483	-1.71	18.9407	9.3221	1.0	00:19:27	1/2 ENDMILL X 1710 DEEP - PLUNGE
24 - Contour (2D)	2	5730 RPM	43.8918 inch/min	3.9982	1.9642	-1.71	19.6332	8.559	1.0	00:16:45	1/2 ENDMILL X 1710 DEEP - SIZING
25 - Drill/Counterbore	6	5500 RPM	10.0 inch/min	7.9607	2.3767	-0.0313	15.6707	3.7267	1.0	00:00:04	1/16 SPOT DRILL
26 - Drill/Counterbore	16	5500 RPM	10.0 inch/min	5.0807	2.3767	-0.06	18.5507	3.7267	1.0	00:00:07	120 SPOT DRILL
27 - Peck Drill	20	5500 RPM	50.0 inch/min	7.9607	2.3767	-0.2688	15.6707	3.7267	1.0	00:00:05	1/16 DRILL X 250 DEEP
28 - Peck Drill	18	5500 RPM	50.0 inch/min	5.0807	2.3767	-0.3861	18.5507	3.7267	1.0	00:00:10	120 DRILL X 350 DEEP
29 - Pocket (Standard)	2	5730 RPM	43.548 inch/min	4.5852	7.9682	-0.222	19.0462	8.3718	1.0	00:08:05	1/2 ENDMILL X 222 DEEP
30 - Pocket (Standard)	17	8149 RPM	23.3061 inch/min	4.9477	6.5059	-0.1	18.6917	7.5191	1.0	00:00:43	3/16 ENDMILL X 100 DEEP
31 - Pocket (Standard)	4	6730 RPM	33.0 inch/min	5.0488	6.7104	-0.2	18.9462	11.6342	1.0	00:23:09	1/4 ENDMILL X 200 DEEP
32 - Pocket (Standard)	4	6730 RPM	33.0 inch/min	4.9905	5.7229	-0.3	18.6532	6.3299	1.0	00:09:36	1/4 ENDMILL X 300 DEEP
33 - Pocket (Standard)	4	6730 RPM	33.0 inch/min	15. 9234	9.4905	-0.5	17.4201	11.0436	1.0	00:06:10	1/4 ENDMILL X 500 DEEP
34 - Pocket (Standard)	17	8149 RPM	23.3061 inch/min	5.0006	3.4558	-0.21	18.6309	4.051	1.0	00:15:15	3/16 ENDMILL X 210 DEEP

**TOTAL CYCLE 1 HOURS, 56 MINUTES, 30 SECONDS**