



OPERATIONS SETUP SHEET

C238-D

PART NAME: 226C238-D

CUSTOMER NAME: WHIZZ SYSTEMS

PROJECT : C238-D

PROGRAMMER: HARIEASH

Monday, February 20, 2023

10:59 PM

OPERATION LIST

OPERATION NAME	TOOL	SPINDLE SPEED	FEEDRATE	MIN X	MIN Y	MIN Z	MAX X	MAX Y	MAX Z	RUN TIME	COMMENT
1 - Pocket (Standard)	2	5730 RPM	43.548 inch/min	3.25	3.0212	-0.01	19.9462	20.5533	1.0	00:18:51	1/2 ENDMILL X 010 DEEP
2 - Contour (2D)	6	5500 RPM	25.0 inch/min	1.477	1.3992	-0.008	21.9926	20.485	1.0	00:04:54	TEXT ENGRAVING
3 - Drill/Counterbore	16	5500 RPM	10.0 inch/min	2.25	2.25	-0.059	21.25	20.4283	1.0	00:00:19	118 SPOT DRILL
4 - Drill/Counterbore	16	5500 RPM	10.0 inch/min	3.5	3.4017	-0.07	20.0	22.25	1.0	00:01:37	#28 140 SPOT DRILL
5 - Peck Drill	10	5500 RPM	50.0 inch/min	2.25	2.25	-0.2955	21.25	20.4283	1.0	00:00:21	118 DRILL X THRU
6 - Peck Drill	8	5500 RPM	50.0 inch/min	3.5	3.4017	-0.3021	20.0	22.25	1.0	00:01:47	140 DRILL X THRU FOR 6-32 CLEAR
7 - Contour (2D)	5	9165 RPM	26.401 inch/min	0.9375	0.9375	-0.26	22.5625	22.5625	1.0	00:03:19	1/8 ROUTER X THRU PARTOUT

TOTAL CYCLE 0 HOURS, 31 MINUTES, 11 SECONDS