



OPERATIONS SETUP SHEET

G59-BLOCK-1

PART NAME: 226C238-D

CUSTOMER NAME: WHIZZ SYSTEMS

PROJECT : G59-BLOCK-1

PROGRAMMER: HARIEASH

Tuesday, February 21, 2023

1:10 AM

OPERATION LIST

OPERATION NAME	TOOL	SPINDLE SPEED	FEEDRATE	MIN X	MIN Y	MIN Z	MAX X	MAX Y	MAX Z	RUN TIME	COMMENT
35 - Drill/Counterbore	16	3056 RPM	7.64 inch/min	- 0.5001	-0.25	-0.0532	-0.4999	0.25	1.0	00:00:03	6-32 SPOT DRILL
36 - Chip Break	9	9685 RPM	13.559 inch/min	- 0.5001	-0.25	-0.6045	-0.4999	0.25	1.0	00:00:07	0.1065 DRILL X 500 DEEP FOR 6-32 TAP
37 - Tap	3	1661 RPM	51.9063 inch/min	- 0.5001	-0.25	-0.5625	-0.4999	0.25	1.0	00:00:05	6-32 TAP X 500 DEEP

TOTAL CYCLE 0 HOURS, 0 MINUTES, 16 SECONDS