



DO NOT EDIT PROGRAM WITHOUT PERMISSION.

SET-UP SHEET

PART NAME:	0044-35895	PROGRAM #:	4475	PROVEN:	YES
HOLDING:	CUSTOM FIXTURE ASSET #657 ON ST30 ROTARY AXIS	EST.CYCLE:	35 MIN	WORK #:	54145
NC FILE:	0044-35895 REV 02 MILL OP4	PROGRAMMER:	ADEM BEGIC	OPERATION:	04
MACHINE:	VF3 HAAS WITH ROTARY 4TH AXIS	DRAWING:	0044-35895	DRAWING REV:	02
COMMENTS:	Click or tap here to enter text.				

DESCRIPTION OF OPERATIONS:

**DRILL SIDE HOLES AND C'BORES
34X**

MATERIAL TYPE:

ALUM 6061

MATERIAL SIZE:

14.5" DIA FROM PREVIOUS OP

WORK HOLDING:

**CUSTOM FIXTURE WITH 4TH,
SIT ON PINS**

WORK OFFSET:

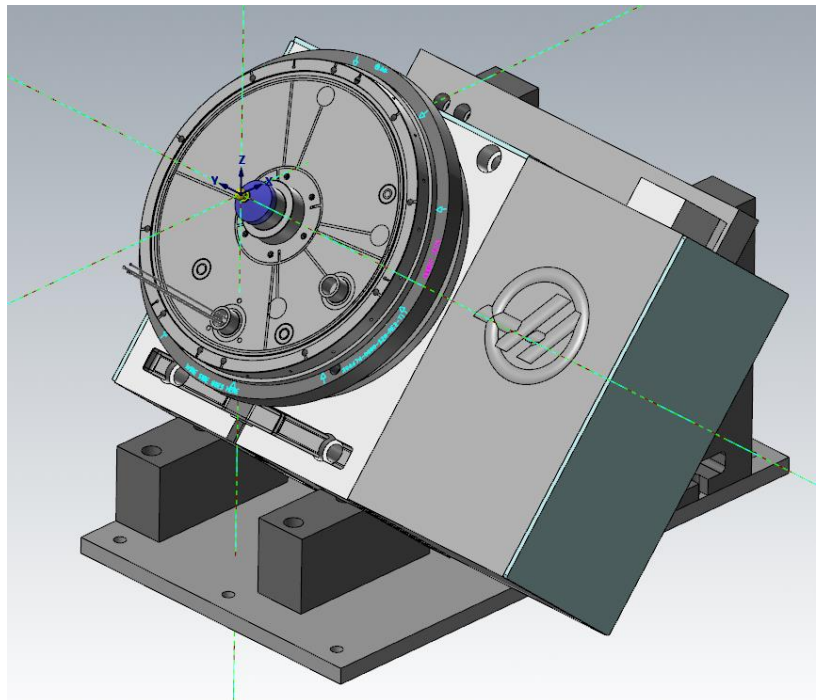
G54

X / Z ZERO LOCATION:

CENTER OF TOOLING BALL

VISUAL REPRESENTATION / SETUP INSTRUCTIONS

(CLICK TO ADD PICTURE)



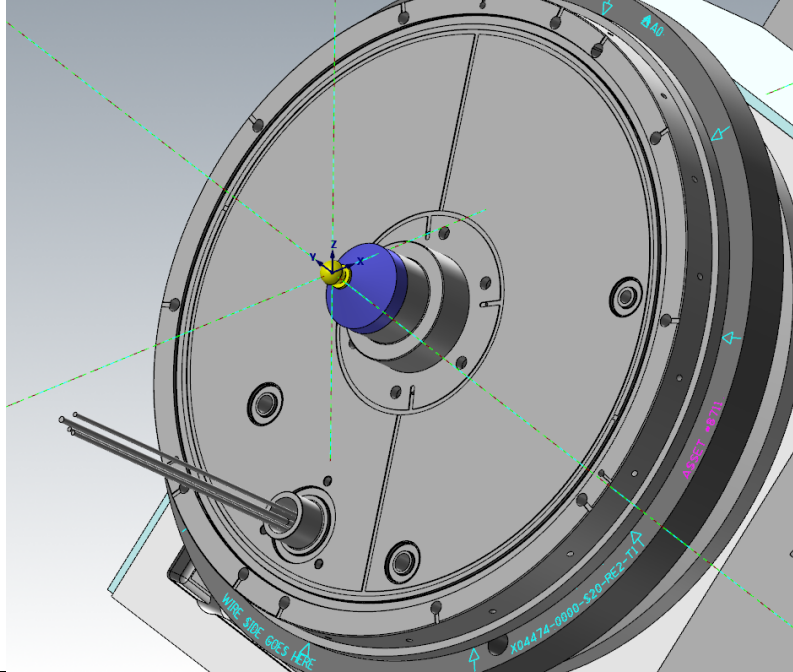
ADDITIONAL COMMENTS:

FOLLOW INSTRUCTIONS IN PROGRAM – WATCH FOR CHIPS ON 3/32 DRILL, ADJUST COOLANT AS NEEDED

ADDITIONAL COMMENTS:

VISUAL REPRESENTATION / SETUP INSTRUCTIONS CONTINUED
(CLICK TO ADD PICTURE)

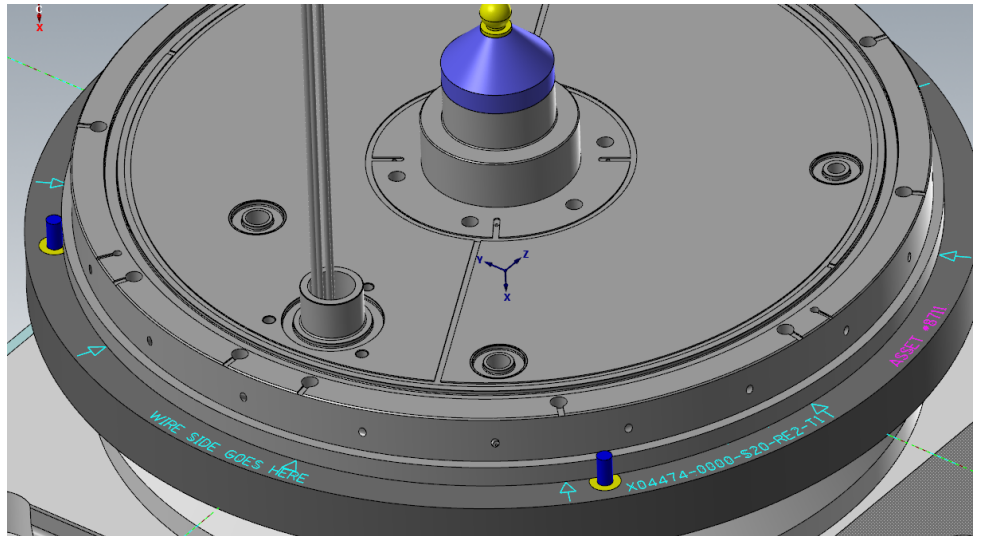
**G54, XYZ CENTER OF TOOLING
BALL**



ADDITIONAL COMMENTS:

VISUAL REPRESENTATION / SETUP INSTRUCTIONS CONTINUED
(CLICK TO ADD PICTURE)

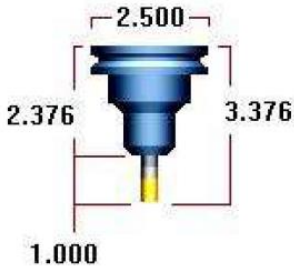
**PLACE PART AGAIN 2 X .250
PINS**

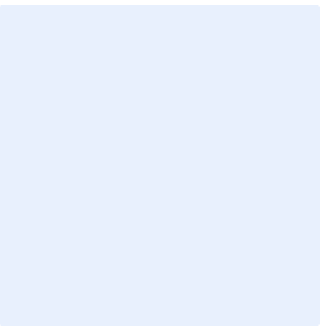


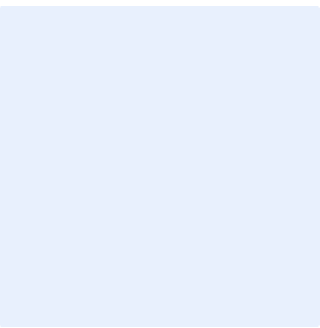
DETAILED OPERATION PROCESS

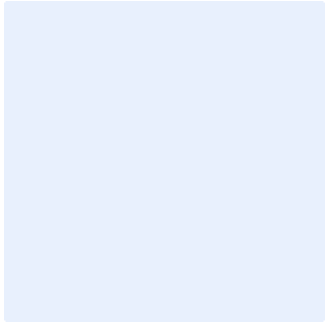
#	TOOL #	TOOL NAME	H #	D #	SPEED	FEED	COOLANT	DESCRIPTION / COMMENT
1	01	3/8 FLAT ENDMILL	1	N/A	3500	15.	flood	SPOT FLAT FOR C'BORES
2	02	3/16 HSS SPOTDRILL	2	N/A	3500	15	thru	SPOT FOR 3/32 DRILL
3	02	3/16 HSS SPOTDRILL	2	N/A	3500	15	thru	SPOT FOR .25 C'BORE
4	03	3/32 STUB DRILL	3	N/A	6500	20	thru	DRILL .093 DIA HOLES THRU
5	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
6	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
7	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
8	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
9	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
10	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
11	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
12	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
13	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
14	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
15	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
16	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
17	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
18	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
19	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
20	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
21	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
22	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
23	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
24	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
25	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
26	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
27	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>
28	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>enter</i>	<i>choose</i>	<i>please enter process</i>

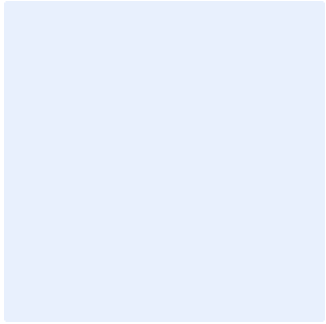
DETAILED TOOL LIST

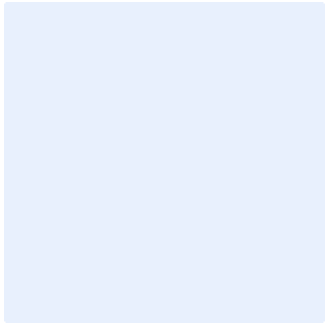
TOOL # 1	NAME: 3/8 3FL .500 LOC ALUM FINISHER EM			<p style="text-align: center;">VISUAL TOOL REPRESENTATION</p>  <p style="text-align: center;">Reference Only!</p>
TOOL TYPE:	ENDMILL	ORIENTATION:	choose	
HOLDER MFG ID:	CT40 COMMAND H21	HAND:	choose	
HOLDER NAME:	SOLID	# OF FLUTES	3	
INSERT/TOOL:	HELICAL 03332	LENGTH OF CUT	.5125	
SHAPE:	enter text	COATING	NONE	
RADIUS:	0	COMMENT	OK TO USE OLD TOOL AS LONG AS CUT IS FLAT FOR SPOT DRILL	
(TO ADD TOOLS COPY AND PASTE TOOL BOX)				

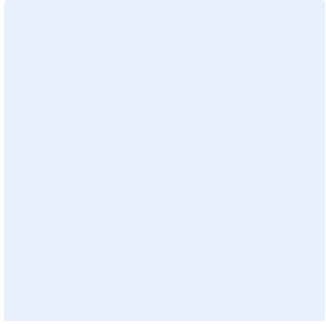
TOOL # enter	NAME: enter text			<p style="text-align: center;">VISUAL TOOL REPRESENTATION</p>  <p style="text-align: center;">Reference Only!</p>
TOOL TYPE:	enter text	ORIENTATION:	choose	
HOLDER MFG ID:	enter text	HAND:	choose	
HOLDER NAME:	enter text	# OF FLUTES	enter text	
INSERT/TOOL:	enter text	LENGTH OF CUT	enter text	
SHAPE:	enter text	COATING	enter text	
RADIUS:	enter text	COMMENT	enter text	
(TO ADD TOOLS COPY AND PASTE TOOL BOX)				

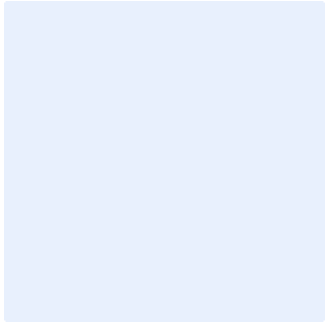
TOOL # enter	NAME: enter text			<p style="text-align: center;">VISUAL TOOL REPRESENTATION</p>  <p style="text-align: center;">Reference Only!</p>
TOOL TYPE:	enter text	ORIENTATION:	choose	
HOLDER MFG ID:	enter text	HAND:	choose	
HOLDER NAME:	enter text	# OF FLUTES	enter text	
INSERT/TOOL:	enter text	LENGTH OF CUT	enter text	
SHAPE:	enter text	COATING	enter text	
RADIUS:	enter text	COMMENT	enter text	
(TO ADD TOOLS COPY AND PASTE TOOL BOX)				

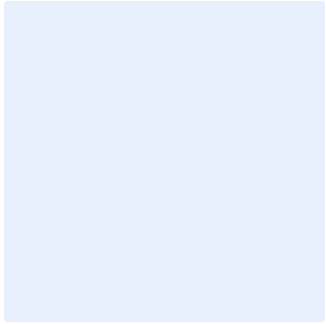
TOOL # enter	NAME: enter text			VISUAL TOOL REPRESENTATION  Reference Only!
TOOL TYPE:	enter text	ORIENTATION:	choose	
HOLDER MFG ID:	enter text	HAND:	choose	
HOLDER NAME:	enter text	# OF FLUTES	enter text	
INSERT/TOOL:	enter text	LENGTH OF CUT	enter text	
SHAPE:	enter text	COATING	enter text	
RADIUS:	enter text	COMMENT	enter text	
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TOOL TYPE:	enter text	ORIENTATION:	choose	
HOLDER MFG ID:	enter text	HAND:	choose	
HOLDER NAME:	enter text	# OF FLUTES	enter text	
INSERT/TOOL:	enter text	LENGTH OF CUT	enter text	
SHAPE:	enter text	COATING	enter text	
RADIUS:	enter text	COMMENT	enter text	
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HOLDER MFG ID:	enter text	HAND:	choose	
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SHAPE:	enter text	COATING	enter text	
RADIUS:	enter text	COMMENT	enter text	
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HOLDER MFG ID:	enter text	HAND:	choose	
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INSERT/TOOL::	enter text	LENGTH OF CUT	enter text	
SHAPE:	enter text	COATING	enter text	
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HOLDER MFG ID:	enter text	HAND:	choose	
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INSERT/TOOL:	enter text	LENGTH OF CUT	enter text	
SHAPE:	enter text	COATING	enter text	
RADIUS:	enter text	COMMENT	enter text	
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TOOL TYPE:	enter text	ORIENTATION:	choose	
HOLDER MFG ID:	enter text	HAND:	choose	
HOLDER NAME:	enter text	# OF FLUTES	enter text	
INSERT/TOOL:	enter text	LENGTH OF CUT	enter text	
SHAPE:	enter text	COATING	enter text	
RADIUS:	enter text	COMMENT	enter text	
(TO ADD TOOLS COPY AND PASTE TOOL BOX)				