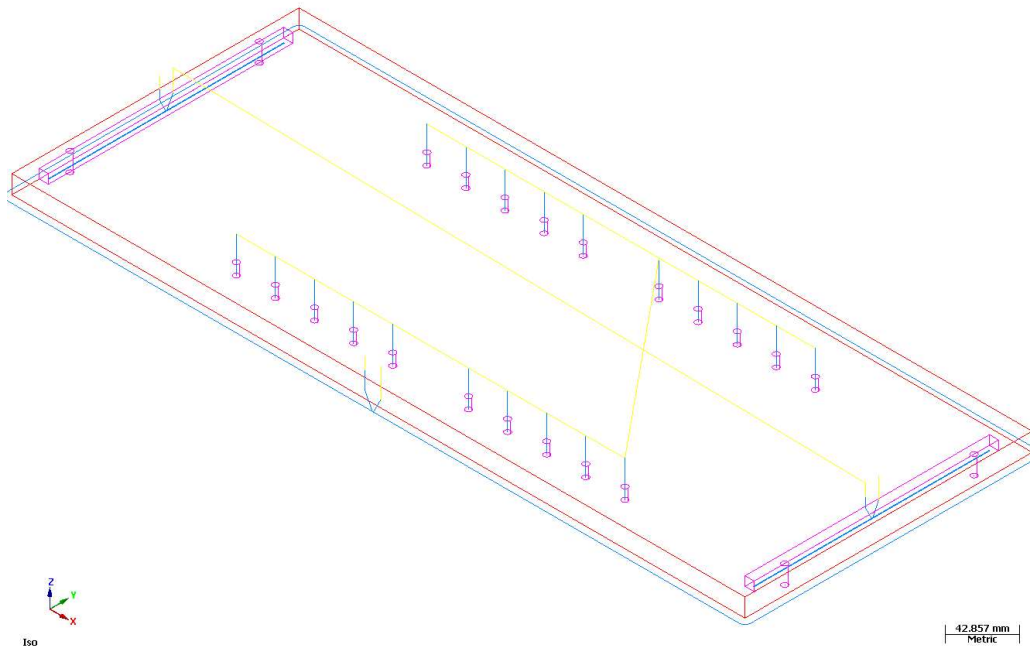


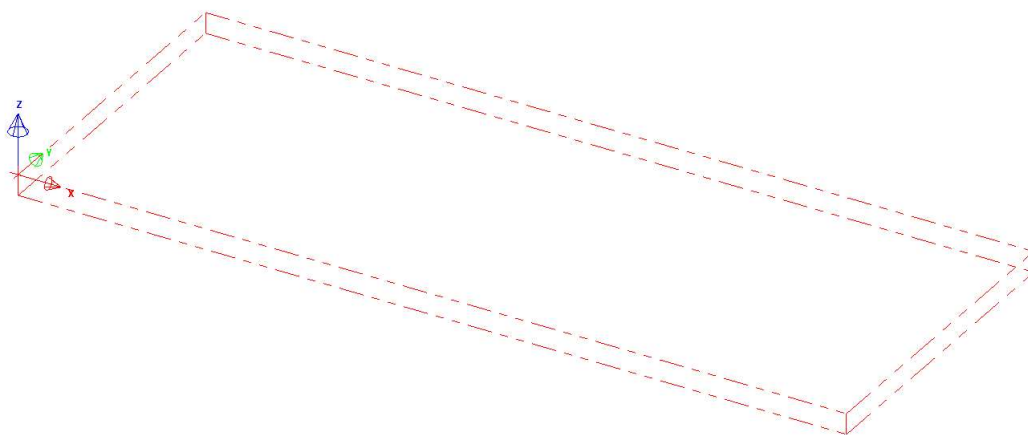
Setup Sheet for ROUTER DEFAULT MM

General Information

Date & Time: Tuesday, October 20, 2015 10:12 PM	Machine Group: Machine Group 1	Units: Metric
Project: Sample Varco Setup Sheet	Customer: Varco Reporting	
Programmer: Jim Varco	Note 1:	
Drawing:	Note 2:	
Revision:	Note 3:	
Mastercam File: V:\VARCO REPORTING\MASTERCAM PART FILES\ROUTER BLOCK DRILL.MCX-9		


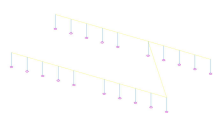


Stock	Shape: Box	Material: ALUMINUM mm - 2024
	Size: X600.000 mm, Y235.000 mm,	


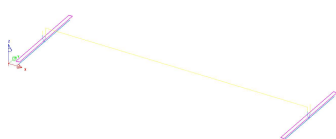


Operations List for "ROUTER BLOCK DRILL EXAMPLE.NC"


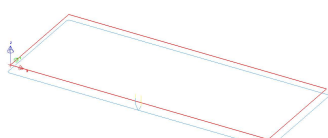
OP# 1:

	Name: Router Block Drill -	Cycle Time: 38h, 59m, 50s	
	Prg. No.: 0	WCS Plane Name: Top T-Plane Name: Top Work Offset Code: G54	
Tool: _____			
Number: 1		Description: #1 - BLOCK DRILL -	

OP# 2:


	Name: Contour (2D)	Cycle Time: 00h, 00m, 10s	
	Prg. No.: 0	WCS Plane Name: Top Comp. Type: Computer Comp. Dir.: Right	
Stk. to Leave XY: 0.0 mm			
Stk. to Leave Z: 0.0 mm			
Tool: _____			
Mfg. Code:		RPM: 10000	
Comment: 7. FLAT BOTTOM BIT		SFM: 219.918	
Asm. Name:		Feedrate: 5000.0	
Tool Type: Straight		Number: 216	
Aggregate: No		Diameter: 7.0 mm	
Lng. Offset: 0		Flute Lng.: 50.0 mm	
Dia. Offset: 0		Flutes: 4	
		Feed/Tooth: 0.1250 mm/rev	
		Plunge Feed: 2500.0	
		Retract Feed: 5.116 mm/min	

OP# 3:

	Name: Contour (2D)	Cycle Time: 00h, 00m, 21s	
	Prg. No.: 0	WCS Plane Name: Top Comp. Type: Computer Comp. Dir.: Right	
Stk. to Leave XY: 0.0 mm			
Stk. to Leave Z: 0.0 mm			
Tool: _____			
Mfg. Code:		RPM: 10000	
Comment: 10. FLAT BOTTOM BIT		SFM: 314.169	
Asm. Name:		Feedrate: 5000.0	
Tool Type: Straight		Number: 219	
Aggregate: No		Diameter: 10.0 mm	
Lng. Offset: 0		Flute Lng.: 50.0 mm	
Dia. Offset: 0		Flutes: 4	
		Feed/Tooth: 0.1250 mm/rev	
		Plunge Feed: 2500.0	
		Retract Feed: 3.581 mm/min	

Tool List for "ROUTER BLOCK DRILL EXAMPLE.NC" (Not Sorted)

T1:

	Tool Type: Block Drill	Cycle Time: 00h, 00m, 00s	⊕ ⊕ ⊕ ⊕ ⊕		
	Description: #1 - BLOCK DRILL -	% of Prg. Cycle: Unavailable			
Stations: _____					
No.	Name	Type	Diameter	Offset	Aqqr ⊕
1	#1 - M5.00 DRILL -	Drill	5.0	X0.000 mm, Y0.000 mm, Z0.000 mm	No
2	#2 - M5.00 DRILL -	Drill	5.0	X32.000 mm, Y0.000 mm, Z0.000 mm	No ⊕
3	#3 - M5.00 DRILL -	Drill	5.0	X64.000 mm, Y0.000 mm, Z0.000 mm	No
4	#4 - M5.00 DRILL -	Drill	5.0	X96.000 mm, Y0.000 mm, Z0.000 mm	No ⊕
5	#5 - M5.00 DRILL -	Drill	5.0	X128.000 mm, Y0.000 mm, Z0.000 mm	No ⊕
6	#6 - M5.00 DRILL -	Drill	5.0	X0.000 mm, Y-32.000 mm, Z0.000 mm	No
7	#7 - M5.00 DRILL -	Drill	5.0	X0.000 mm, Y-64.000 mm, Z0.000 mm	No
8	#8 - M5.00 DRILL -	Drill	5.0	X0.000 mm, Y-96.000 mm, Z0.000 mm	No ⊕
9	#9 - M5.00 DRILL -	Drill	5.0	X0.000 mm, Y-128.000 mm, Z0.000 mm	No

T216: 7. FLAT BOTTOM BIT

<p>Tool Type: Straight Mfg. Code: Name: 7. FLAT BOTTOM BIT Asm. Name: Aggregate: No Units: Metric Holder Name: DEFAULT HOLDER Holder Lng.: 25.0 mm Lng. Offset: 0 Dia. Offset: 0</p>	<p>Material: HSS Diameter: 7.0 mm Overall Lng.: 75.0 mm Shoulder Lng.: 60.0 mm Flute Lng.: 50.0 mm Flutes: 4</p>	<p>Cycle Time: 00h, 00m, 10s % of Prg. Cycle: 0.01% Max. Stock Top: 0 mm Min. Z Depth: -7.52 mm Coolant: Custom opt... Spindle Dir.: CW RPM: 10000 SFM: 18326 Feedrate: 5000.0 Feed/Tooth: 0.1250 mm/rev Plunge Feed: 2500.0 Retract Feed: 5.116 mm/min</p>	
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Operations using tool "T216: 7. FLAT BOTTOM BIT"

No.	Type	Comment
2	2 - Contour (2D)	

T219: 10. FLAT BOTTOM BIT

<p>Tool Type: Straight Mfg. Code: Name: 10. FLAT BOTTOM BIT Asm. Name: Aggregate: No Units: Metric Holder Name: DEFAULT HOLDER Holder Lng.: 25.0 mm Lng. Offset: 0 Dia. Offset: 0</p>	<p>Material: HSS Diameter: 10.0 mm Overall Lng.: 75.0 mm Shoulder Lng.: 60.0 mm Flute Lng.: 50.0 mm Flutes: 4</p>	<p>Cycle Time: 00h, 00m, 21s % of Prg. Cycle: 0.01% Max. Stock Top: 0 mm Min. Z Depth: -16 mm Coolant: Custom opt... Spindle Dir.: CW RPM: 10000 SFM: 26180 Feedrate: 5000.0 Feed/Tooth: 0.1250 mm/rev Plunge Feed: 2500.0 Retract Feed: 3.581 mm/min</p>	
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Operations using tool "T219: 10. FLAT BOTTOM BIT"

No.	Type	Comment
3	3 - Contour (2D)	

Work Offset List for "ROUTER BLOCK DRILL EXAMPLE.NC"

CNC Code	Mastercam No.	View
G54	0	Top