X4-MU1 - MILL.SET rev8.4.09
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PROGRAM NAME = TR1896 B-CAVITIES-T
MCX FILE - C:\MCX\TR1896\TR1896 B-CAVITIES.MCX
PROGRAM NUMBER = 0004
DATE PROCESSED = SEP. 21 2009
TIME = 8:43 AM
MACHINE NAME = JOHNFORD
GROUP NAME = MACHINE GROUP-1

OPERATION TYPE = SURFACE HIGH SPEED - CORE ROUGHING
TOOL NAME = 2.985 ISCAR W/45 DEG .200 WIDE
TOOL NUM. = 21
TOOL DIA. = 2.9850
DIA. OFFSET = 21
LEN. OFFSET = 21
SPINDLE = 500
FEEDRATE = 12.
STOCK TO LEAVE ON WALLS = .04
STOCK TO LEAVE ON FLOORS = .04
TOTAL TOLERANCE = 0.
MAX_X = +7.5157 MIN_X = -7.5157
MAX_Y = +5.5166 MIN_Y = -5.5166
MAX_Z = +0.6250 MIN_Z = -6.4049
OPERATION TIME = 3 HOURS, 20 MINUTES, 45.66 SECONDS

OPERATION TYPE = DRILL CYCLE - SIMPLE
OPERATION COMMENT = WATCH R-PLANE
TOOL NAME = .3125 CTR DRILL
TOOL NUM. = 4
TOOL DIA. = .3125
DIA. OFFSET = 4
LEN. OFFSET = 4
SPINDLE = 1200
FEEDRATE = 2.
MAX_X = +4.5000 MIN_X = -4.5000
MAX_Y = +2.5000 MIN_Y = -2.5000
MAX_Z = +2.0000 MIN_Z = -6.7600
OPERATION TIME = 1 MINUTE, 10.71 SECONDS

OPERATION TYPE = DRILL CYCLE - PECK
OPERATION COMMENT = WATCH R-PLANE
TOOL NAME = .213 DRILL NUM3
TOOL NUM. = 5
TOOL DIA. = .2130
DIA. OFFSET = 5
LEN. OFFSET = 5
SPINDLE = 717
FEEDRATE = 2.35
MAX_X = +4.5000 MIN_X = -4.5000
MAX_Y = +2.5000 MIN_Y = -2.5000
MAX_Z = +2.0000 MIN_Z = -6.8694
OPERATION TIME = 1 MINUTE, 46.53 SECONDS

OPERATION TYPE = DRILL CYCLE - TAP
OPERATION COMMENT = WATCH R-PLANE
TOOL NAME = 1/4-28 TAP
TOOL NUM. = 6
TOOL DIA. = .2500
DIA. OFFSET = 6
LEN. OFFSET = 6
SPINDLE = 260
FEEDRATE = 9.29
MAX_X = +4.5000 MIN_X = -4.5000
MAX_Y = +2.5000 MIN_Y = -2.5000
MAX_Z = +2.0000 MIN_Z = -6.6983
OPERATION TIME = 4 MINUTES, 12.93 SECONDS

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PROGRAM TOTALS (4 TOOLS):

FEEDRATES: MAX = 12. MIN = 2.
MAX_X = +7.5157 MIN_X = -7.5157
MAX_Y = +5.5166 MIN_Y = -5.5166
MAX_Z = +2.0000 MIN_Z = -6.8694
CYCLE TIME: 3 HOURS, 28 MINUTES, 19.82 SECONDS