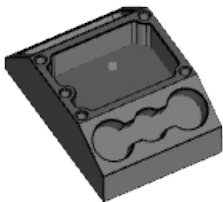
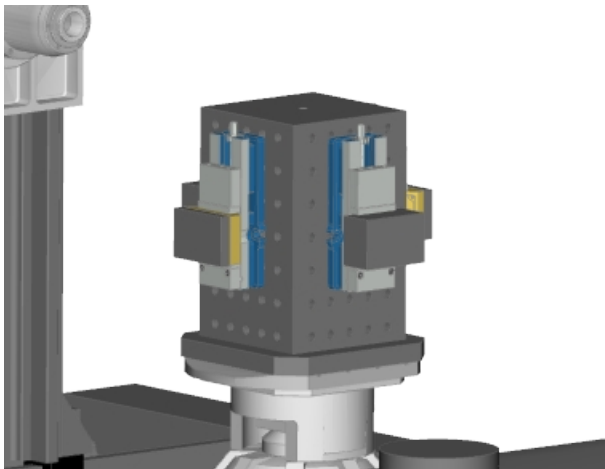








































# MACHINING REPORT





























































Part Name	Lesson_6_Completed.esprit	Machine Name	Horizontal_Mill_4-axis
Program Number	1		
Unit	Inch		



#	Op Name		Tool Name		T#	T $\varnothing$	TL	Operation Comment	WC	Speed RPM/SPM	Feed PM/PR	DOC/ Step	Op Time
1		Facing   Side 1		FM 2.5 in	T1	2.5	1.5	---	G54	306 200	3.672 0.002	0.05 1.25	00:11:02
2		Facing   Side 2		FM 2.5 in	T1	2.5	1.5	---	G54	306 200	3.672 0.002	0.05 1.25	00:50:07

#	Op Name		Tool Name		T#	T Ø	TL	Operation Comment	WC	Speed RPM/SPM	Feed PM/PR	DOC/ Step	Op Time
3		Facing   Op 2		FM 2.5 in	T1	2.5	1.5	---	G55	306 200	3.672 0.002	0.05 1.25	02:45:53
4		Facing   Side 1		FM 2.5 in	T1	2.5	1.5	---	G56	306 200	3.672 0.002	0.05 1.25	00:11:02
5		Facing   Side 2		FM 2.5 in	T1	2.5	1.5	---	G56	306 200	3.672 0.002	0.05 1.25	00:50:07
6		Facing   Side 3		FM 2.5 in	T1	2.5	1.5	---	G56	306 200	3.672 0.002	0.05 1.25	00:33:00
7		Facing   Op 2		FM 2.5 in	T1	2.5	1.5	---	G57	306 200	3.672 0.002	0.05 1.25	02:45:53
8		Facing   Side 3		FM 2.5 in	T1	2.5	1.5	---	G54	306 200	3.672 0.002	0.05 1.25	00:33:00
9		Pocketing   Side 1		EM 0.75 in	T2	0.75	3	---	G54	1019 200	4.076 0.002	0.75 0.375	00:34:00
10		Pocketing   Side 2		EM 0.75 in	T2	0.75	3	---	G54	1019 200	4.076 0.002	0.75 0.375	00:20:07
11		Pocketing   Side 1		EM 0.75 in	T2	0.75	3	---	G56	1019 200	4.076 0.002	0.75 0.375	00:34:00
12		Pocketing   Side 2		EM 0.75 in	T2	0.75	3	---	G56	1019 200	4.076 0.002	0.75 0.375	00:20:07
13		Pocketing   Side 3		EM 0.5 in	T2	0.5	1.5	---	G56	1528 200	6.112 0.002	0.5 0.25	00:13:28
14		Pocketing   Side 3		EM 0.5 in	T2	0.5	1.5	---	G54	1528 200	6.112 0.002	0.5 0.25	00:13:28
15		Contouring   Finish Outside		EM 0.75 in	T2	0.75	3	---	G56	1019 200	4.076 0.002	0.75 0.15	00:15:36
16		Contouring   Finish Outside		EM 0.75 in	T2	0.75	3	---	G54	1019 200	4.076 0.002	0.75 0.15	00:15:36
17		Contouring   Finish Side 1		EM 0.25 in	T3	0.25	1.375	---	G54	3056 200	12.224 0.002	0 0.095	00:01:04
18		Contouring   Finish Side 2 Upper		EM 0.25 in	T3	0.25	1.375	---	G54	3056 200	12.224 0.002	0 0.095	00:00:53
19		Contouring   Finish Side 2 Lower		EM 0.25 in	T3	0.25	1.375	---	G54	3056 200	12.224 0.002	0 0.05	00:01:32

#	Op Name		Tool Name		T#	T $\emptyset$	TL	Operation Comment	WC	Speed RPM/SPM	Feed PM/PR	DOC/ Step	Op Time
20		Contouring   Finish Side 1		EM 0.25 in	T3	0.25	1.375	---	G56	3056 200	12.224 0.002	0 0.095	00:01:04
21		Contouring   Finish Side 2 Upper		EM 0.25 in	T3	0.25	1.375	---	G56	3056 200	12.224 0.002	0 0.095	00:00:53
22		Contouring   Finish Side 2 Lower		EM 0.25 in	T3	0.25	1.375	---	G56	3056 200	12.224 0.002	0 0.05	00:01:32
23		Contouring   Finish Side 3		EM 0.25 in	T3	0.25	1.375	---	G56	3056 200	12.224 0.002	0.75 0.125	00:00:57
24		Contouring   Finish Side 3		EM 0.25 in	T3	0.25	1.375	---	G54	3056 200	12.224 0.002	0.75 0.125	00:00:57
25		Spot Drilling   Side 1		SDR 0.5 in	T4	0.5	2.5	---	G54	1528 200	3.056 0.002	N/A N/A	00:00:33
26		Drilling   Though Hole Side 1		DR 0.257 in (F)	T5	0.257	1.3	---	G54	2973 200	5.946 0.002	N/A N/A	00:02:19
27		Spiraling   Counterbore		EM 0.25 in	T3	0.25	1.375	---	G54	3056 200	12.224 0.002	0.05 0	00:01:06
28		Contouring   Chamfer Side 1		CM 0.5 in	T6	0.25	2	---	G54	3056 200	12.224 0.002	0 0.05	00:01:01
29		Spot Drilling   Side 3		SDR 0.5 in	T4	0.5	2.5	---	G54	1528 200	3.056 0.002	N/A N/A	00:00:23
30		Spot Drilling   Side 1		SDR 0.5 in	T4	0.5	2.5	---	G56	1528 200	3.056 0.002	N/A N/A	00:00:33
31		Drilling   Through Holes		DR 0.25 in	T6	0.25	1.25	---	G54	3056 200	6.112 0.002	N/A N/A	00:00:31
32		Drilling   Though Hole Op2		DR 0.5 in	T8	0.5	2.5	---	G57	1528 200	3.056 0.002	N/A N/A	00:00:55
33		Drilling   Though Hole Op2		DR 0.5 in	T8	0.5	2.5	---	G55	1528 200	3.056 0.002	N/A N/A	00:00:55
34		Contouring   Chamfer Op 2		CM 0.5 in	T6	0.25	2	---	G55	3056 200	12.224 0.002	0 0.05	00:00:09
35		Contouring   Chamfer Op 2		CM 0.5 in	T6	0.25	2	---	G55	3056 200	12.224 0.002	0 0.05	00:00:09
36		Contouring   Chamfer Op 2		CM 0.5 in	T6	0.25	2	---	G55	3056 200	12.224 0.002	0 0.05	00:00:09

#	Op Name		Tool Name		T#	T Ø	TL	Operation Comment	WC	Speed RPM/SPM	Feed PM/PR	DOC/ Step	Op Time
37		Contouring   Chamfer Op 2		CM 0.5 in	T6	0.25	2	---	G55	3056 200	12.224 0.002	0 0.05	00:00:09
38		Threading   Op 2		TM 1/2 - 13	T10	0.42	1.5	---	G55	5093 500	20.372 0.002	N/A N/A	00:00:07
39		Drilling   Though Hole Side 1		DR 0.257 in (F)	T5	0.257	1.3	---	G56	2973 200	5.946 0.002	N/A N/A	00:02:19
40		Spiraling   Counterbore		EM 0.25 in	T3	0.25	1.375	---	G56	3056 200	12.224 0.002	0.05 0	00:01:06
41		Contouring   Chamfer Side 1		CM 0.5 in	T6	0.25	2	---	G56	3056 200	12.224 0.002	0 0.05	00:01:01
42		Contouring   Chamfer Op 2		CM 0.5 in	T6	0.25	2	---	G57	3056 200	12.224 0.002	0 0.05	00:00:09
43		Contouring   Chamfer Op 2		CM 0.5 in	T6	0.25	2	---	G57	3056 200	12.224 0.002	0 0.05	00:00:09
44		Contouring   Chamfer Op 2		CM 0.5 in	T6	0.25	2	---	G57	3056 200	12.224 0.002	0 0.05	00:00:09
45		Contouring   Chamfer Op 2		CM 0.5 in	T6	0.25	2	---	G57	3056 200	12.224 0.002	0 0.05	00:00:09
46		Spot Drilling   Side 3		SDR 0.5 in	T4	0.5	2.5	---	G56	1528 200	3.056 0.002	N/A N/A	00:00:23
47		Drilling   Through Holes		DR 0.25 in	T6	0.25	1.25	---	G56	3056 200	6.112 0.002	N/A N/A	00:00:31
48		Threading   Op 2		TM 1/2 - 13	T10	0.42	1.5	---	G57	5093 500	20.372 0.002	N/A N/A	00:00:07