



Live

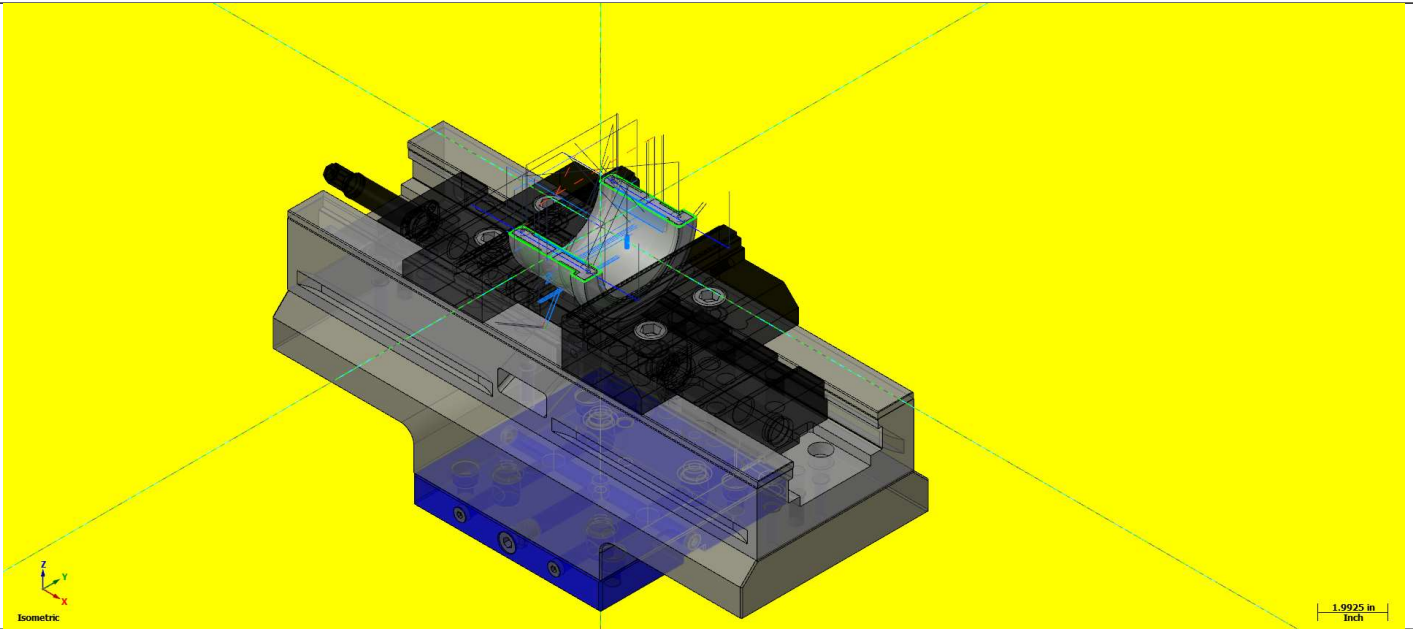
Operation And Setup Sheet

DMG ECOMILL SIEMENS 840D

Program No.

O0061.MPF

Work Order	Customer	Drawing Number	Rev.	Programmer	Date
██████████	██████████	██████████	9	JD	2024-03-07



Machining Information

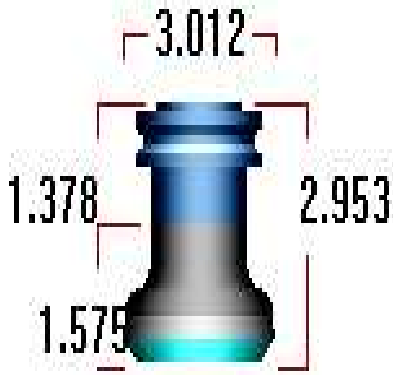
TOTAL CYCLE TIME: **0 HOURS, 51 MINUTES, 48 SECONDS**

OPERATION LIST

OP #	OPERATION	TOOL #	MIN-Z	MAX-Z	CYCLE TIME	ACT. TIME
3		20	-0.2431	2.0	00:01:08	Record Act. Time
4		20	-0.1181	2.0	00:01:15	Record Act. Time
5	SKIM +.005	1	0.005	2.0	00:00:57	Record Act. Time
6	DEBURR	2	-0.01	2.0	00:00:22	Record Act. Time
8		20	-0.5181	2.0	00:01:06	Record Act. Time
9	SLOT ROUGH	3	-1.3925	2.0	00:01:11	Record Act. Time
10		3	-1.3925	2.0	00:01:35	Record Act. Time
11		3	-2.3762	-1.2654	00:00:12	Record Act. Time
12		3	-2.3762	-1.2654	00:00:12	Record Act. Time
13	FINISH SLOT	6	-1.3975	2.0	00:00:42	Record Act. Time
14	SLOT FINISH	6	-2.3787	-1.2654	00:00:06	Record Act. Time
15	SLOT FINISH	6	-2.3787	-1.2654	00:00:06	Record Act. Time
16	helix bore	6	-0.2125	2.0	00:00:17	Record Act. Time

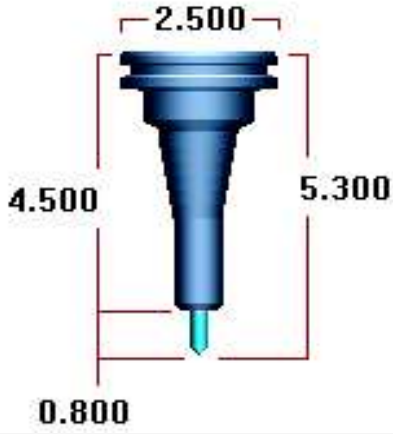
18		20	-0.1181	2.0	00:01:15	Record Act. Time
19	WASHES	18	-0.4452	2.4177	00:07:13	Record Act. Time
20	WASHES	18	-0.4452	2.4177	00:07:13	Record Act. Time
21	INNER WASH	18	-0.7525	2.3107	00:01:17	Record Act. Time
22	INNER WASH	18	-0.7525	2.3107	00:01:17	Record Act. Time
23	SLOT ON JOINTS	4	-0.125	2.0	00:00:21	Record Act. Time
24	SPOT DOWEL HOLES	14	-0.075	2.0	00:00:08	Record Act. Time
25	DRILL FOR 1/8 DOWELS	5	-0.3929	2.0	00:01:06	Record Act. Time
26	REAM FOR .125 SLIP FIT DOWEL	7	-0.31	2.0	00:00:39	Record Act. Time
27	FINAL SKIM	1	0.0	2.0	00:01:20	Record Act. Time
29		20	-0.1181	2.0	00:01:15	Record Act. Time
30	SKIM +.005	1	0.005	2.0	00:00:57	Record Act. Time
31	DEBURR	2	-0.01	2.0	00:00:22	Record Act. Time
32	WASHES	18	-0.4452	2.4177	00:07:13	Record Act. Time
33	WASHES	18	-0.4452	2.4177	00:07:13	Record Act. Time
34	SLOT ON JOINTS	4	-0.125	2.0	00:00:21	Record Act. Time
35	SPOT DOWEL HOLES	14	-0.075	2.0	00:00:08	Record Act. Time
36	DRILL FOR 1/8 DOWELS	5	-0.3929	2.0	00:01:06	Record Act. Time
37	REAM FOR .125 SLIP PRESS DOWEL	8	-0.31	2.0	00:00:39	Record Act. Time
38	FINAL SKIM	1	0.0	2.0	00:01:20	Record Act. Time

TOOL LIST



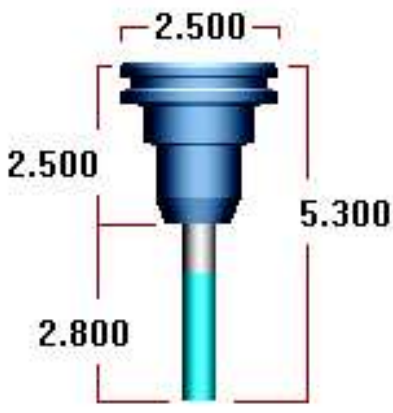
2.5FACE

NUMBER	TYPE:	HOLDER:	
1	Face mill	2.5 FACE HOLDER	
	DIAMETER :	# OF FLUTES:	FLUTE LENGTH:
	3.0117	5	0.25
	STICK OUT:	FOR AUTOCRIB	
	1.5754		
CORNER RADIUS:	0.0		



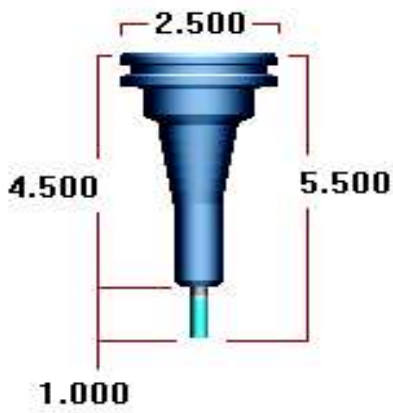
.25DRILLMILL

NUMBER	TYPE:	HOLDER:	
2	Spot drill	CAT40-WE-1/4A-120U	
	DIAMETER :	# OF FLUTES:	FLUTE LENGTH:
	0.25	2	0.75
	STICK OUT:	FOR AUTOCRIB	
	0.8		
CORNER RADIUS:	0.0		



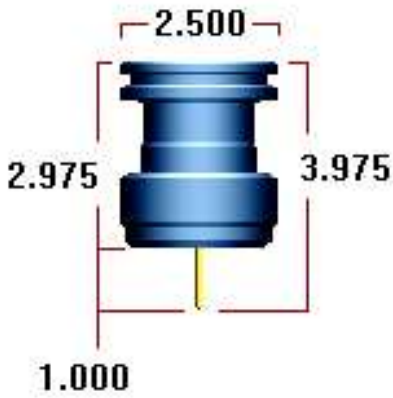
.5ROUGHER

NUMBER	TYPE:	HOLDER:	
3	Flat endmill	CAT40-WE0.5-65U	
	DIAMETER :	# OF FLUTES:	FLUTE LENGTH:
	0.5	4	2.0
	STICK OUT:	FOR AUTOCRIB	
	2.8		
CORNER RADIUS:	0.0		



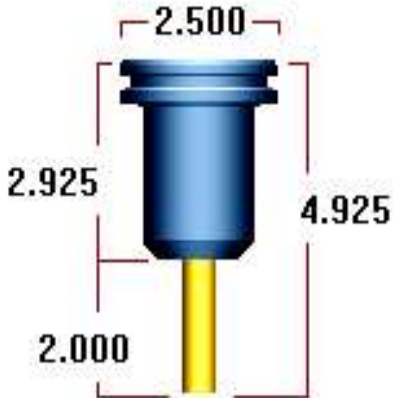
.25END

NUMBER	TYPE:	HOLDER:	
4	Flat endmill	CAT40-WE-1/4A-120U	
	DIAMETER :	# OF FLUTES:	FLUTE LENGTH:
	0.25	4	0.75
	STICK OUT:	FOR AUTOCRIB	
	1.0		
CORNER RADIUS:	0.0		



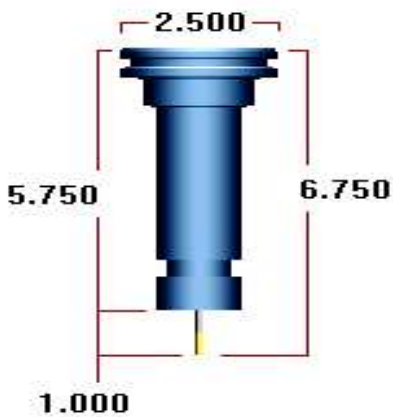
7/64DRILL-HSS

NUMBER	TYPE:	HOLDER:	
5	Drill	CT40 TG10Q 3.25	
	DIAMETER :	# OF FLUTES:	FLUTE LENGTH:
	0.1094	2	1.0
	STICK OUT: FOR AUTOCRIB		
	1.0		
CORNER RADIUS:	0.0		



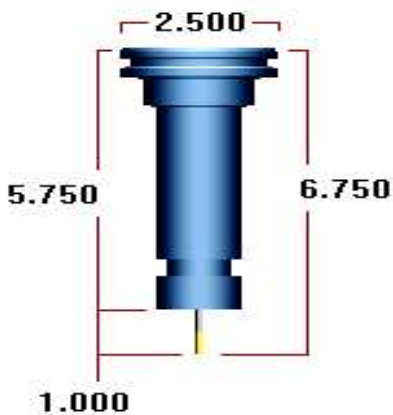
.5END-CARBIDE

NUMBER	TYPE:	HOLDER:	
6	Flat endmill	Briney V40E-075-300	
	DIAMETER :	# OF FLUTES:	FLUTE LENGTH:
	0.5	4	2.0
	STICK OUT: FOR AUTOCRIB		
	2.0		
CORNER RADIUS:	0.0		



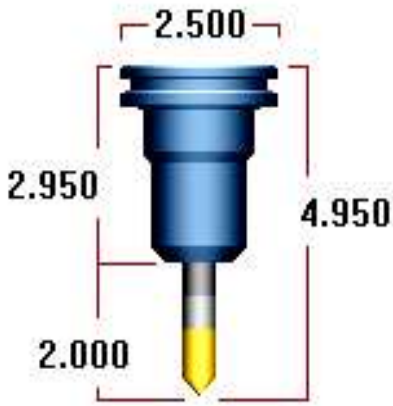
0.126SLIPFIT REAMER

NUMBER	TYPE:	HOLDER:	
7	Reamer	CAT40 ER20-6.00	
	DIAMETER :	# OF FLUTES:	FLUTE LENGTH:
	0.126	6	0.5
	STICK OUT: FOR AUTOCRIB		
	1.0		
CORNER RADIUS:	0.0		

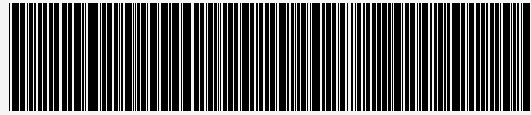


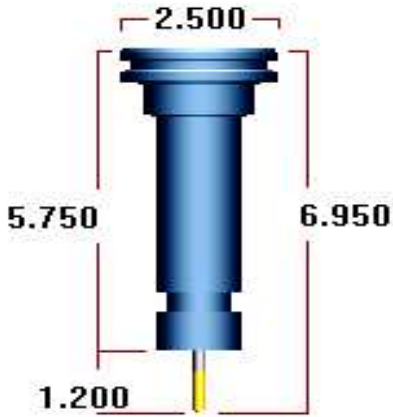
0.125PRESSFIT REAMER

NUMBER	TYPE:	HOLDER:	
8	Reamer	CAT40 ER20-6.00	
	DIAMETER :	# OF FLUTES:	FLUTE LENGTH:
	0.126	6	0.5
	STICK OUT: FOR AUTOCRIB		
	1.0		
CORNER RADIUS:	0.0		

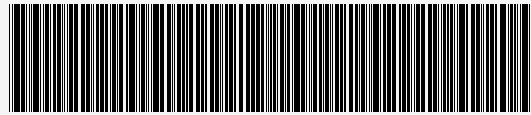


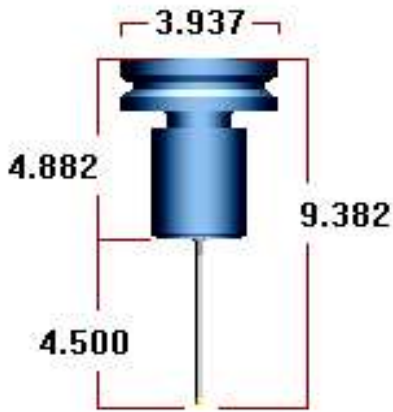
1/2 SPOT DRILL

NUMBER	TYPE:	HOLDER:	
14	Spot drill	BRINEY V40E-052-300	
	DIAMETER :	# OF FLUTES:	FLUTE LENGTH:
	0.5	2	1.0
	STICK OUT:	FOR AUTOCRIB	
	2.0		
CORNER RADIUS:	0.0		

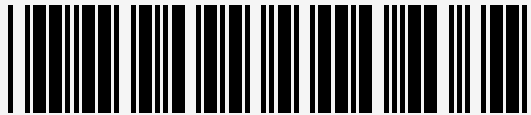


.188BALL

NUMBER	TYPE:	HOLDER:	
18	Ball endmill	CAT40 ER20-6.00	
	DIAMETER :	# OF FLUTES:	FLUTE LENGTH:
	0.1875	4	0.75
	STICK OUT:	FOR AUTOCRIB	
	1.2		
CORNER RADIUS:	0.0938		

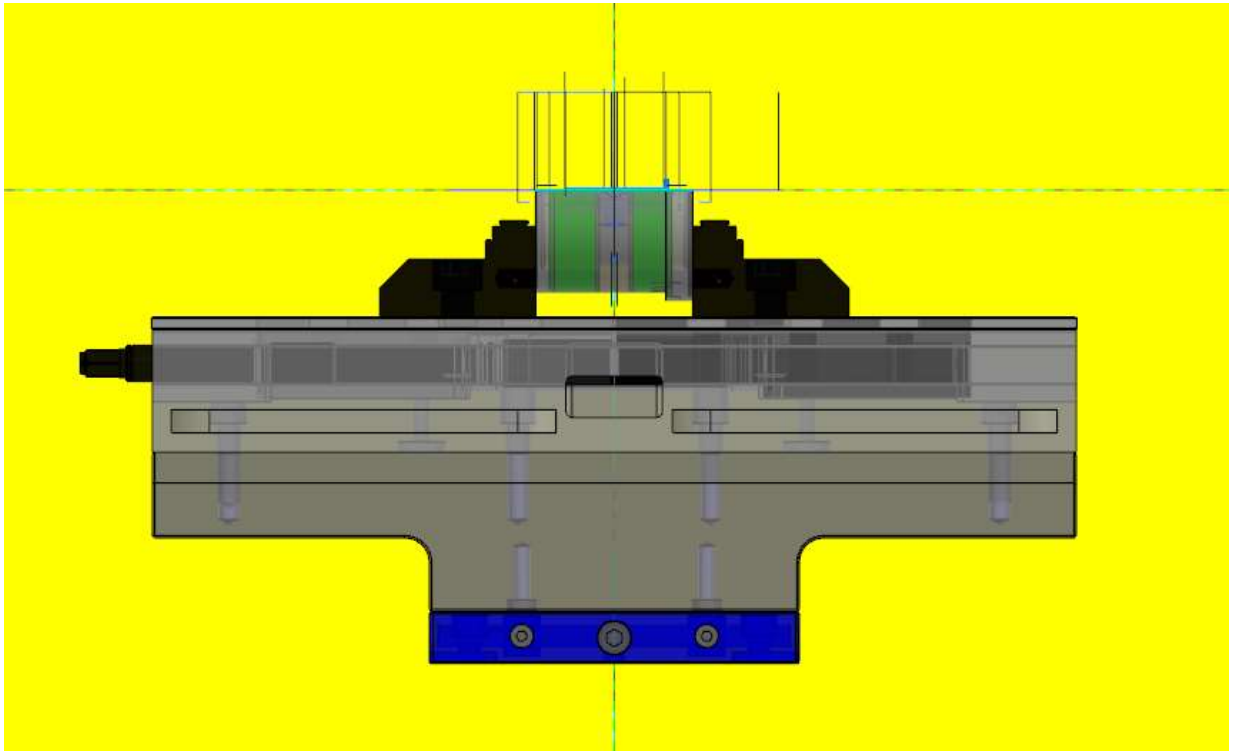


PROBE

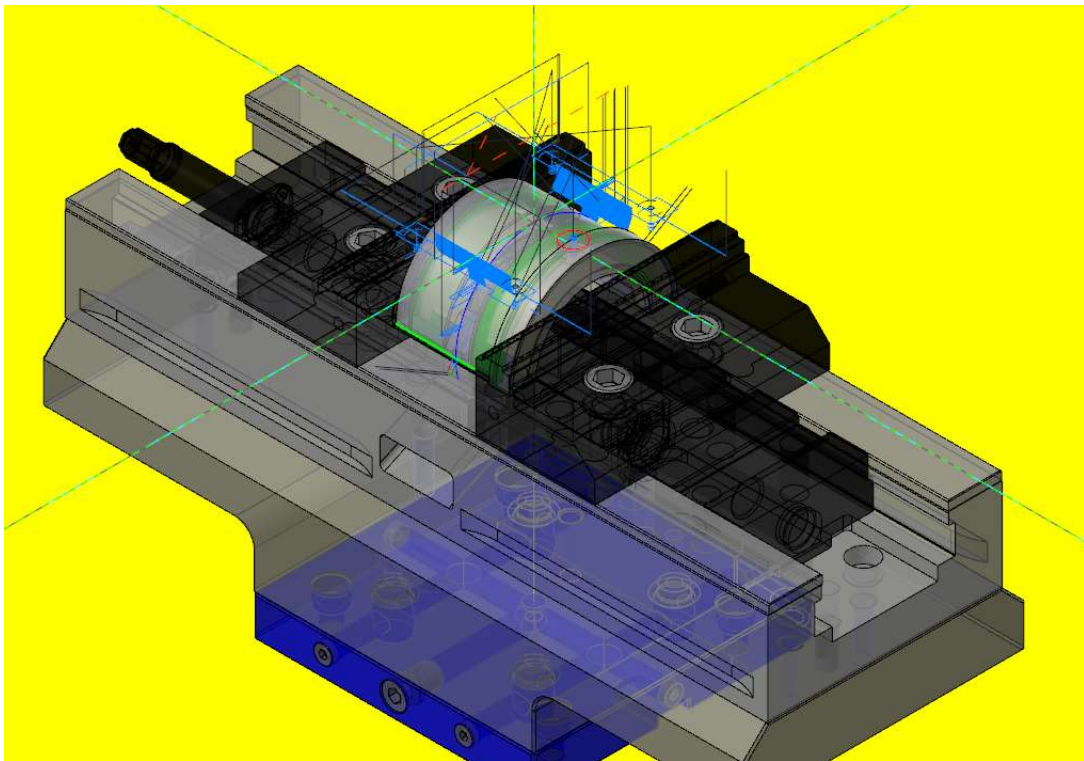
NUMBER	TYPE:	HOLDER:	
20	Lollipop mill	RENISHAW PROBE	
	DIAMETER :	# OF FLUTES:	FLUTE LENGTH:
	0.2362	1	0.2103
	STICK OUT:	FOR AUTOCRIB	
	4.5		
CORNER RADIUS:	0.1181		

SETUP INFO

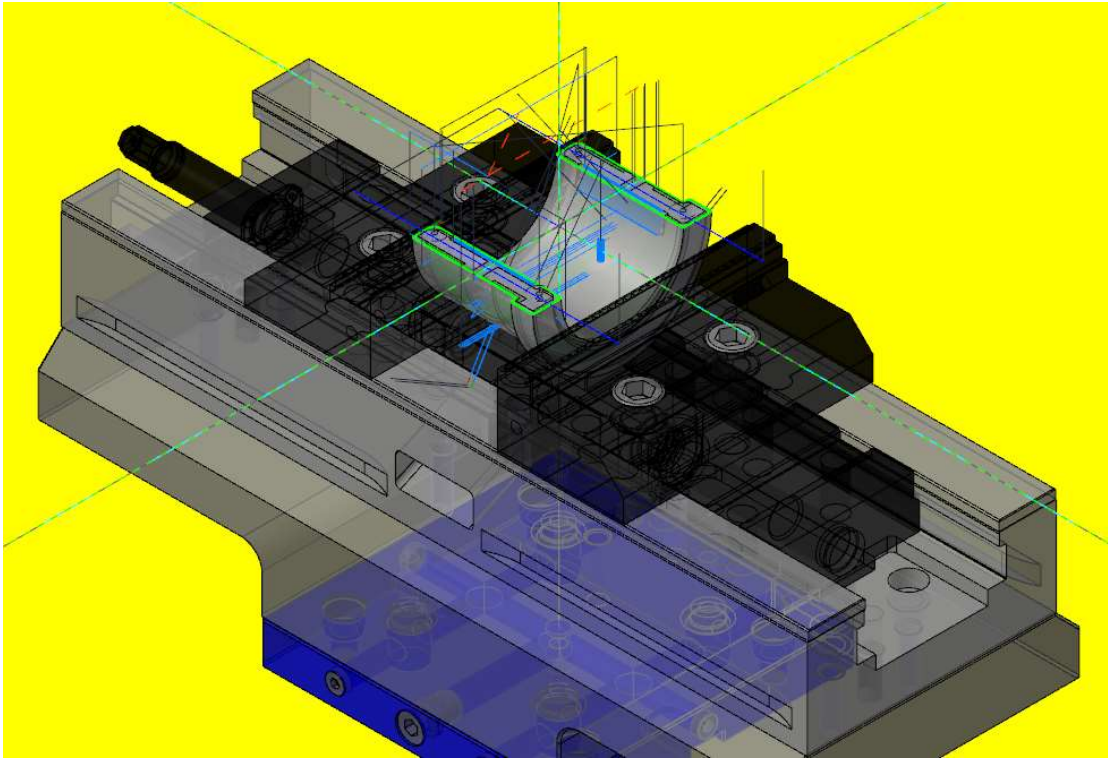
TOP HALF-JOINTS FACING UP



TOP HALF-JOINTS FACING DOWN



BOTTOM HALF-JOINTS FACING UP



COMMENTS

Please leave remarks/comments for M.E.s/T.A.s