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Program Name: NX_FAST_DOCUMENTS_REVA_OP1

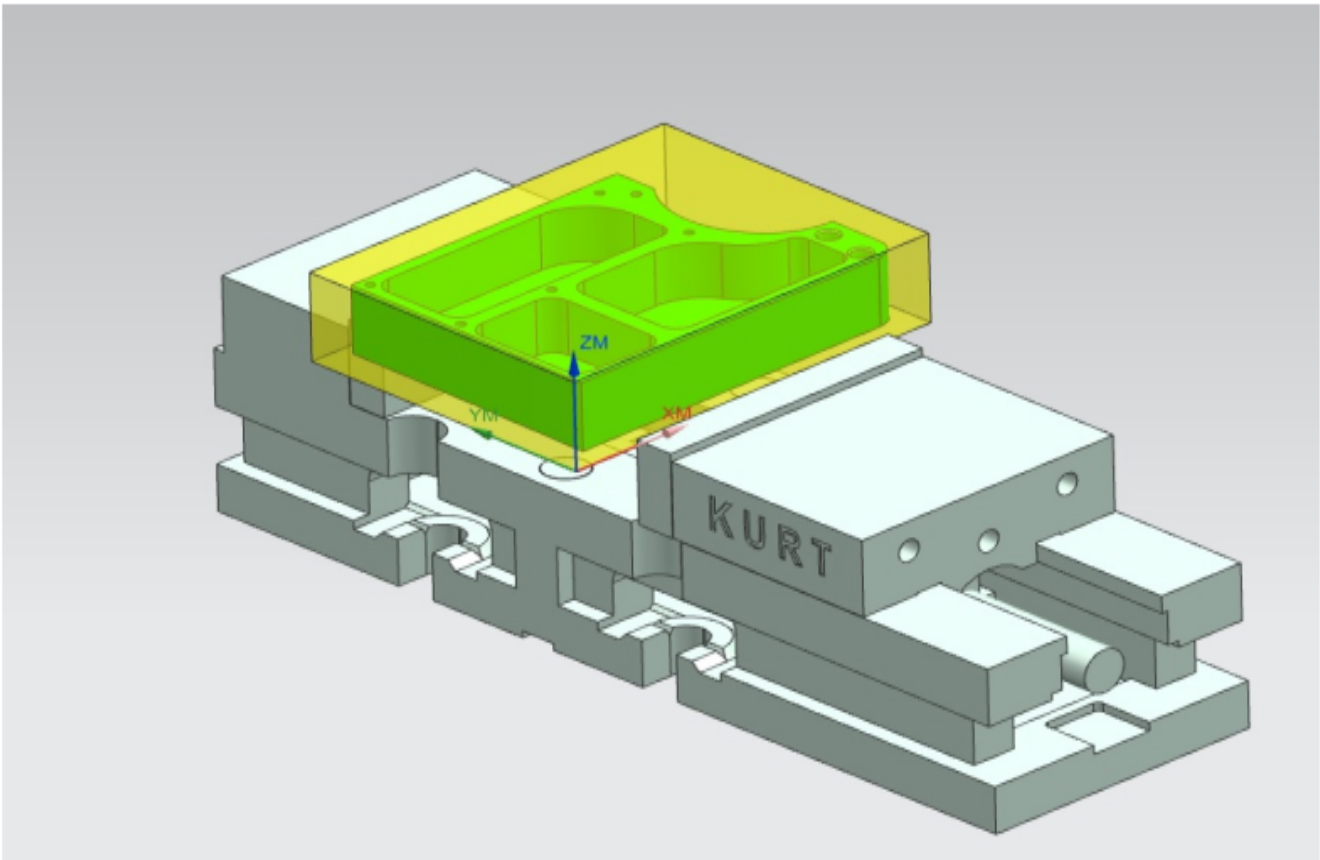|		
Programmer : Jeff Smith	Part Number: 751A1234-1	Part Rev: C
Customer : PDX Bxx	Drawing Number: 751A1234	Drawing Rev: C
Material : AL 7075-T751	Fixture : Kurt Vise	Mfg Operation: OP5

Document Time Stamp: 2/17/2021 8:43:17 PM

Program Time Stamp: (POST DATE: MON JAN 07 2019   05:20:10)

NX File : C:\Users\Jeff-Laptop\Documents\ToolcribMaster_NXSetupDocs\NX_SampleParts\model1.prt

Program Name: NX_FAST_DOCUMENTS_REVA_OP1

Part Number: 751A1234-1   Part Rev: C   Mfg Operation: OP5

NX File : C:\Users\Jeff-Laptop\Documents\ToolcribMaster_NXSetupDocs\NX_SampleParts\model1.prt
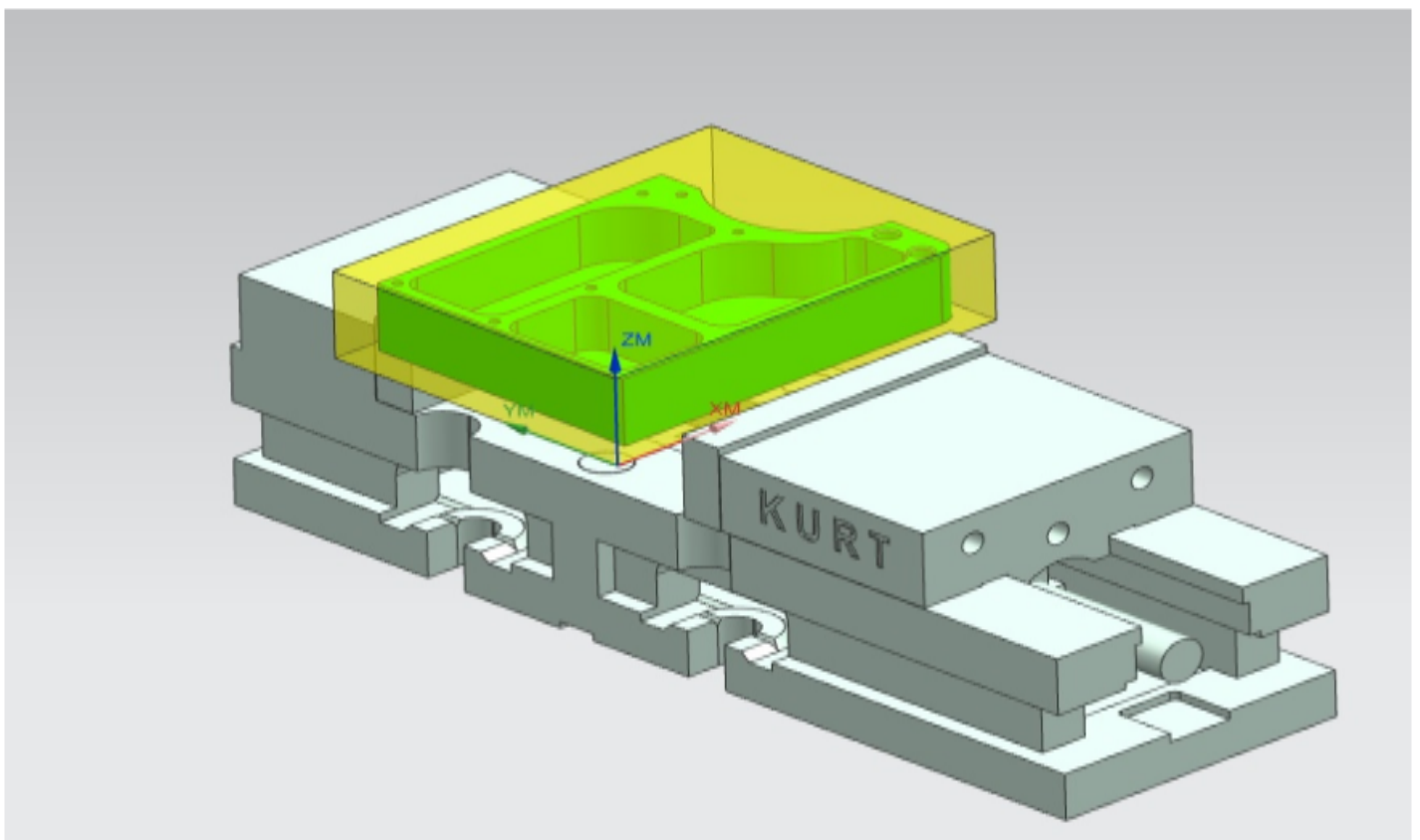
Fixtures: Kurt Vise

Material: AL 7075-T751

Setup Instructions: Clamp part on Dovetails

                    X0 = LEFT END OF MATL
                    Y0 = NEAR SIDE OF MATL

                    Z0 = BOTTOM OF MATL

Operations List

Op. Name: FACE_TOP **Op. Descrip:** Face Top of part leave .05 stock

Tool Name: FM_1.500X.062CRX.65FL_DAPRA_FACEMILL

Tool #	Dia.	Cor. Rad.	# Flutes	Fl. Length	Stick Out	RPM	Feed Rate
13	1.5000	0.0620	4	0.6500	1.51	334.00	8.49

Op. Name: ROUGH_PERIPHERY **Op. Descrip:** Rough Outside leave .015

Tool Name: EM-.500X.00CRX1.25FL_4FL_ROUGHER

Tool #	Dia.	Cor. Rad.	# Flutes	Fl. Length	Stick Out	RPM	Feed Rate
118	1.0000	0.0000	2	2.0000	3.00	1008.00	7.06

Op. Name: ROUGH_POCKETS **Op. Descrip:** Rough pockets

Tool Name: EM_.500X.125CRX1.25_FINISHER

Tool #	Dia.	Cor. Rad.	# Flutes	Fl. Length	Stick Out	RPM	Feed Rate
137	0.5000	0.1250	4	1.2500	1.75	2009.00	32.95

Op. Name: FINISH_FLOORS **Op. Descrip:** Rough pockets

Tool Name: EM_.500X.125CRX1.25_FINISHER

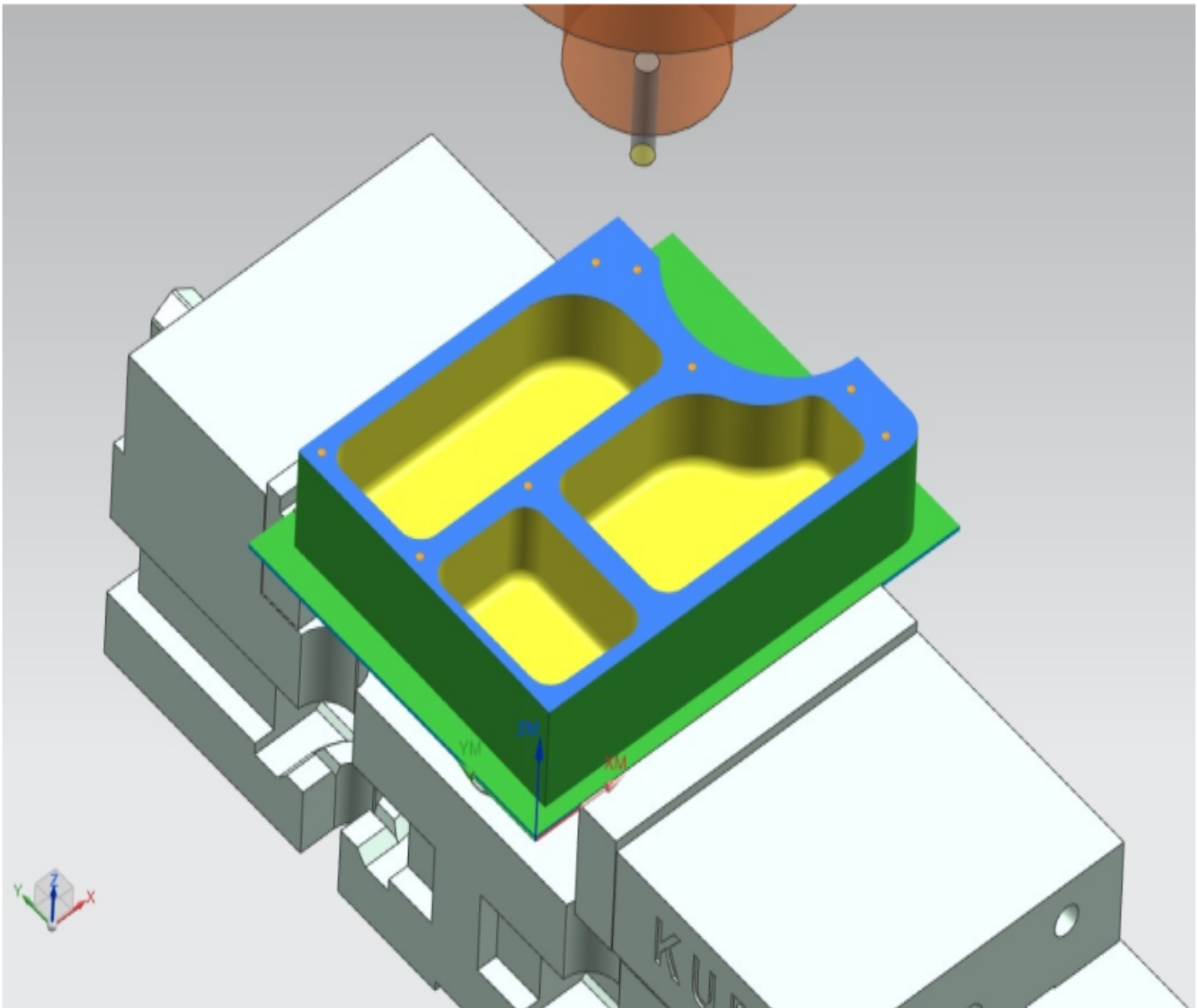| Tool #	Dia.	Cor. Rad.	# Flutes	Fl. Length	Stick Out	RPM	Feed Rate
137	0.5000	0.1250	4	1.2500	1.75	2009.00	32.95

Op. Name: FINISH_PERIPHERY   Op. Descrip: Finish outside

Tool Name: EM_.500X.125CRX1.25_FINISHER

Tool #	Dia.	Cor. Rad.	# Flutes	Fl. Length	Stick Out	RPM	Feed Rate
137	0.5000	0.1250	4	1.2500	1.75	2009.00	32.95

CHECK WALL THICKNESSES - .125 TYP

Op. Name: SPOT_DRILLING_ALL_HOLES   **Op. Descrip:**

Tool Name: DR_.250X90DEG_SPOT_DRILL

Tool #	Dia.	Cor. Rad.	# Flutes	Fl. Length	Stick Out	RPM	Feed Rate
901	0.2500	0.1250	2	0.0000	1.00	1528.00	9.17

Op. Name: DRILLING_.134_HOLES   **Op. Descrip:**

Tool Name: DR_.134X120INCLUDEDANGLE_CARBIDE

Tool #	Dia.	Cor. Rad.	# Flutes	Fl. Length	Stick Out	RPM	Feed Rate
912	0.1344	0.0000	2	2.6250	2.70	6537.00	23.07

Op. Name: TAPPING_.3125-18   **Op. Descrip:**

Tool Name: UGTI0371_024

Tool #	Dia.	Cor. Rad.	# Flutes	Fl. Length	Stick Out	RPM	Feed Rate
932	0.3125	0.0000	1	0.4720	1.93	250.00	13.89

Op. Name: TAP_DRILL_LETTER_F   **Op. Descrip:**

Tool Name: UGTI0301_079

Tool #	Dia.	Cor. Rad.	# Flutes	Fl. Length	Stick Out	RPM	Feed Rate
905	0.2580	0.0000	2	3.1875	3.27	4886.00	29.54

Tools List

Tool Name: FM_1.500X.062CRX.65FL_DAPR/ **Tool Descrip:** 1.500 Dapra

Tool #	Dia.	Cor. Rad.	# Flutes	Fl. Length	Stick Out	Holder Name	Holder Description
13	1.5000	0.0620	0	0.6500	1.5100	HLDI001_00011	Small facemill adaptor

Tool Name: EM-.500X.00CRX1.25FL_4FL_RO **Tool Descrip:**

Tool #	Dia.	Cor. Rad.	# Flutes	Fl. Length	Stick Out	Holder Name	Holder Description
118	1.0000	0.0000	0	2.0000	3.0000	HLDI001_00007	Large weldon

Tool Name: EM_.500X.125CRX1.25_FINISHEI **Tool Descrip:** End Mill 1/2"

Tool #	Dia.	Cor. Rad.	# Flutes	Fl. Length	Stick Out	Holder Name	Holder Description
137	0.5000	0.1250	0	1.2500	1.7480	HLDI001_00002	Small weldon

Tool Name: DR_.250X90DEG_SPOT_DRILL **Tool Descrip:** NC-Center Drill 1/4"

Tool #	Dia.	Cor. Rad.	# Flutes	Fl. Length	Stick Out	Holder Name	Holder Description
901	0.2500	0.1250	0	0.0000	1.0000	HLDI001_00010	Small compression

Tool Name: DR_.134X120INCLUDEDANGLE_ **Tool Descrip:** Twist Drill 15/64"

Tool #	Dia.	Cor. Rad.	# Flutes	Fl. Length	Stick Out	Holder Name	Holder Description
912	0.1344	0.0000	0	2.6250	2.7037	HLDI001_00013	Medium shrinkfit

Tool Name: UGTI0371_024 **Tool Descrip:** Tap 5/16 - 18 UNC

Tool #	Dia.	Cor. Rad.	# Flutes	Fl. Length	Stick Out	Holder Name	Holder Description
932	0.3125	0.0000	0	0.4720	1.9313	HLDI001_00010	Small compression

Tool Name: UGTI0301_079 **Tool Descrip:** Twist Drill 5/16"

Tool #	Dia.	Cor. Rad.	# Flutes	Fl. Length	Stick Out	Holder Name	Holder Description
905	0.2580	0.0000	0	3.1875	3.2662	HLDI001_00023	Large compression