

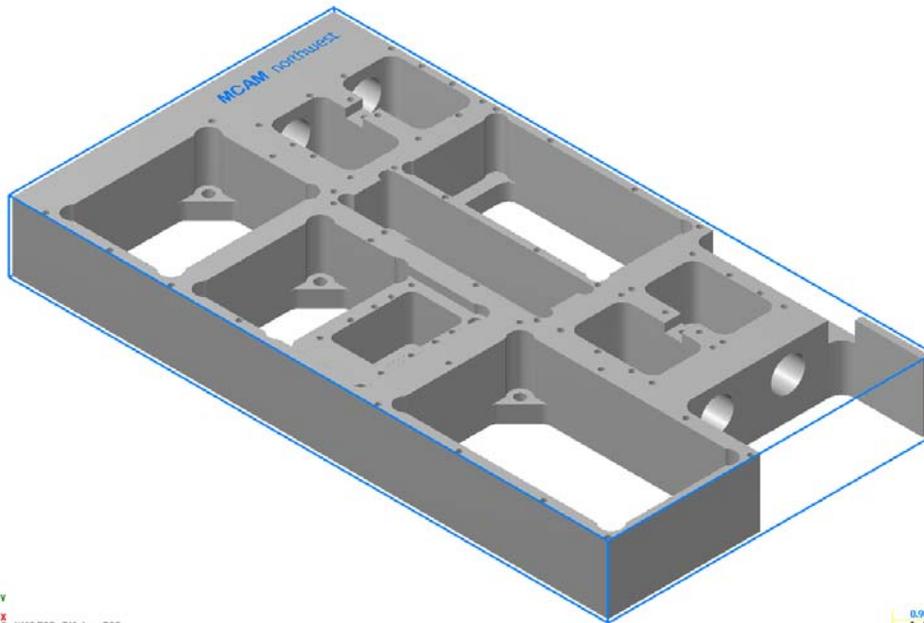


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# GENERIC HAAS 4 - AXIS VMC Setup Sheet

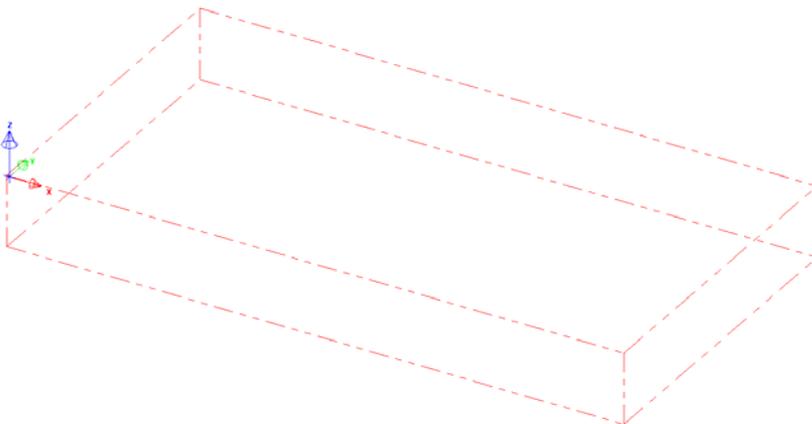
## General Information

Project Name:	Demo4-Fin	Date:	Thursday, January 06, 2011
Customer Name:	MCAM Northwest	Time:	1:41 PM
Programmer:	Jim Varco	Cycle Time:	00:04:35
Drawing:	N/A	Revision:	N/A
Mastercam File:	V:\DEMO4-FIN.MCX-5		
Notes:	Operation 1 of 5 Sample Short Note #2 Sample Short Note #3		



## Stock Info

Stock:	YES	Radius:	NA
Shape:	Box	Length:	NA
Size:	11.062, 5.9995, 1.282	Axis:	NA
IDN:	NA		
File:	NA		



## ***Special Instructions***

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### Fixturing:

2 Kurt Anglock vises with hard jaws, 1 5/8" parallels, and work stop set at left end below the top of the jaws.

### Work Offsets:

G54

X0= X.031" from left edge of stock

Y0= Y.031" from y- edge of stock

Z0= Z-.031" from top of stock

### Notes:

This operation rough and finish faces the part and rough and finish mills two pockets. The pockets are the two pockets in the center of the part in X on the Y- side.

Tool #1 will rough and finish face the part.

Tool #4 will rough two pockets leaving .005" on the walls and .005" on the floor.

Tool #6 will finish the two pockets.

Do not over tighten the vises and spring the material.

### Critical Dimensions:

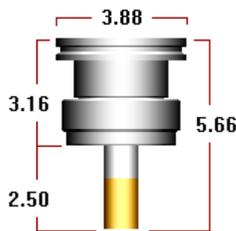
Part thickness after finish facing is 1.281" +/- .01"

Through pocket width in X is 1.625" +/- .002", and 2.375" +/- .002" in the Y direction.

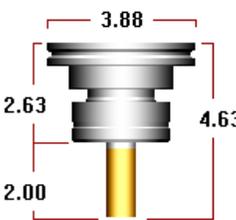
Blind pocket width in X is 1.000" +/- .002", and 1.625" +/- .002" in the Y direction, depth is .8437" +/- .001"

## Tool List

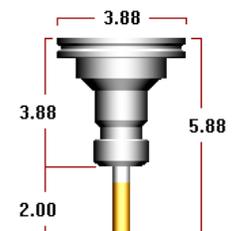
### # 1 1" Flat End Mill

Type:	Endmill1 Flat		Material:	Carbide		
Mfg. Code:	Hanita TF4V0525008		Min. Z:	-0.032		
Holder:	C6C4-1500	CT50	RPM:	1910 RPM		
Diameter:	1.0	Cnr Radius:	0.0	SPM:		2000.0
Lng. Offset:	1	Dia. Offset:	1	FPT:		0.01
No. of Flutes:	4	Min. Length:	_			

### # 4 3/4" Flat End Mill

Type:	Endmill1 Flat		Material:	Ti Coated		
Mfg. Code:	Hanita TF4V0519007		Min. Z:	-0.468		
Holder:	C6C3-1000	CT50	RPM:	5093 RPM		
Diameter:	0.75	Cnr Radius:	0.0	SPM:		999.9346
Lng. Offset:	4	Dia. Offset:	4	FPT:		0.0037
No. of Flutes:	4	Min. Length:	_			

### # 6 1/2" Flat End Mill

Type:	Endmill1 Flat		Material:	Carbide		
Mfg. Code:	Hanita TF4V6513015		Min. Z:	-0.768		
Holder:	C6C4-0025	CT50	RPM:	7640 RPM		
Diameter:	0.5	Cnr Radius:	0.0	SPM:		4000.0
Lng. Offset:	6	Dia. Offset:	6	FPT:		0.005
No. of Flutes:	4	Min. Length:	_			

## Work Offsets

Number: 0 VNum: 1 Origin: -0.031, -0.031, 0.032