

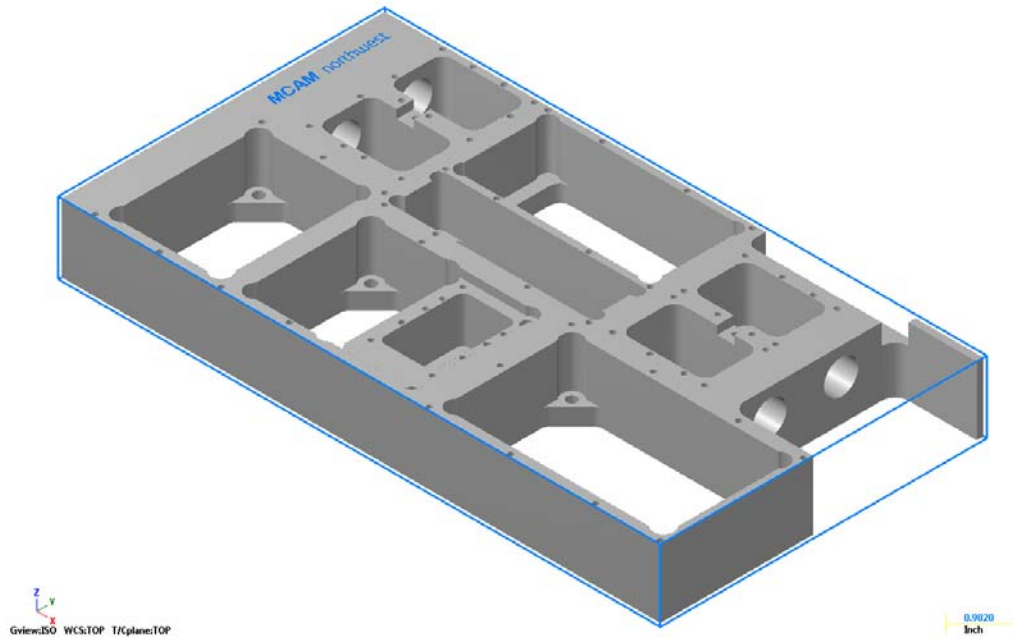


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GENERIC HAAS 4 - AXIS VMC Setup Sheet

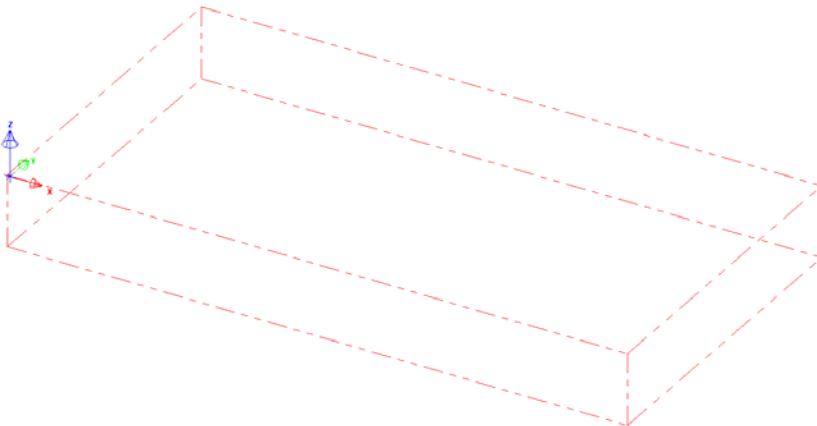
General Information

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

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:

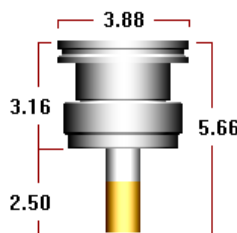
Part thickness after finish facing is 1.281" +/- .01"

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

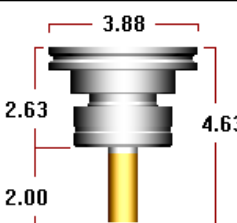
Blind pocket width in X is 1.000" +/- .002", and 1.625" +/- .002" in the Y direction, depth is .8437" +/- .001"

Tool List

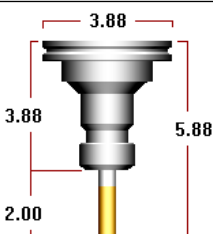
1 1" Flat End Mill

Type:	Endmill1 Flat				
Mfg. Code:	Hanita TF4V0525008				
Holder:	C6C4-1500	CT50	Material:		Carbide
			Min. Z:		-0.032
			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				
Mfg. Code:	Hanita TF4V0519007				
Holder:	C6C3-1000	CT50	Material:		Ti Coated
			Min. Z:		-0.468
			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				
Mfg. Code:	Hanita TF4V6513015				
Holder:	C6C4-0025	CT50	Material:		Carbide
			Min. Z:		-0.768
			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
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