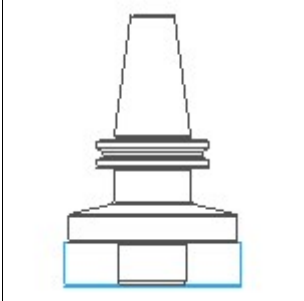
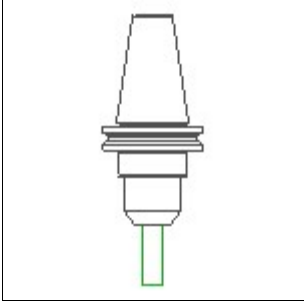


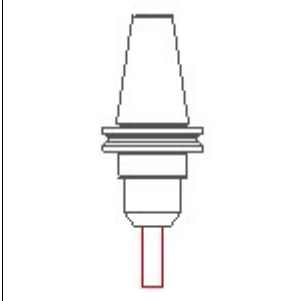
<b>Output File:</b>	D:\ProgramData\SmartCAM\Common\Reports\TLGraphics\Output\MILL_REPORT.HTM	<b>Print Date:</b>	2/12/2018	<b>Print Time:</b>	2:4:42 PM
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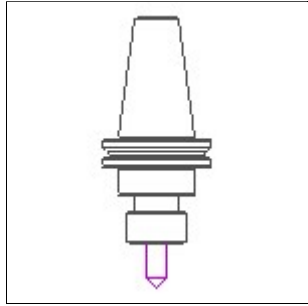
Job Report					
<b>Process Model File:</b>	D:\ProgramData\SmartCAM\SmartCAMv2018\MILL\MDATA\BaseFlangeSolid.pm5				
<b>Job Operations File:</b>	D:\ProgramData\SmartCAM\SmartCAMv2018\MILL\MDATA\BaseFlangeSolid.jof				
<b>Created By:</b>					
<b>Date Created:</b>	12/24/15	<b>Date Revised:</b>	05/02/17	<b>Revisions:</b>	88
<b>Machine:</b>	Example 3-Axis Machining Center				
<b>Machine Type:</b>	Milling	<b>Units:</b>	Inch		
<b>CNC Runtime:</b>		<b>CNC Code Date:</b>	12/24/15		
<b>G-Code File:</b>	BaseFlangeSolid.cod				
<b>Part Description:</b>					
<b>Material Description:</b>					
<b>Notes:</b>	This model demonstrates 2.5 axis roughing and finishing techniques using wireframe geometry processes available in all SmartCAM Milling products. It also demonstrates the use of the Hole Feature process to machine Hole f eature elements created from the solid model using the From Solid Hole function.				

## Tool Report

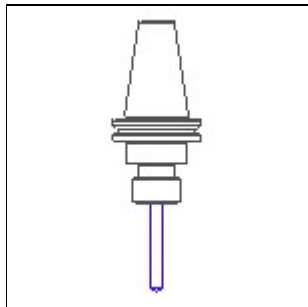
	<b>Tool:</b>	1	<b>Description:</b>	4.0000 Dia. / 0.0310 Rad. 2 Flute Face Mill -		<b>Tool Material:</b>	HSS
	<b>Diameter:</b>	4.0000	<b>Length:</b>	1.0000	<b>Side Angle:</b>	0.0000	<b>Corner Radius:</b> 0.0310
	<b>Tool Notes:</b>						

	<b>Tool:</b>	2	<b>Description:</b>	0.5000 Dia. 2 Flute End Mill -		<b>Tool Material:</b>	HSS
	<b>Diameter:</b>	0.5000	<b>Length:</b>	1.5000	<b>Side Angle:</b>	0.0000	
	<b>Tool Notes:</b>						

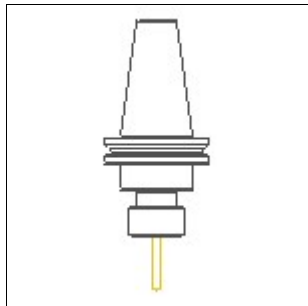
	<b>Tool:</b>	3	<b>Description:</b>	0.5000 Dia. 2 Flute End Mill -		<b>Tool Material:</b>	HSS
	<b>Diameter:</b>	0.5000	<b>Length:</b>	1.5000	<b>Side Angle:</b>	0.0000	
	<b>Tool Notes:</b>						



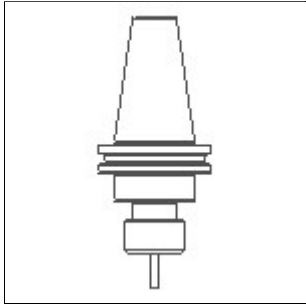
<b>Tool:</b>	4	<b>Description:</b>	0.5000 Dia. x 90.0 Deg. 2 Flute Spot Drill -		<b>Tool Material:</b>	HSS
<b>Diameter:</b>	0.5000	<b>Length:</b>	1.0000	<b>Tip Angle:</b>	90.0000	
<b>Tool Notes:</b>						



<b>Tool:</b>	5	<b>Description:</b>	0.3125 Dia. 2 Flute Twist Drill - 5/16		<b>Tool Material:</b>	HSS
<b>Diameter:</b>	0.3125	<b>Length:</b>	2.5000	<b>Tip Angle:</b>	118.0000	
<b>Tool Notes:</b>						



<b>Tool:</b>	6	<b>Description:</b>	0.1590 Dia. 2 Flute Twist Drill - #21		<b>Tool Material:</b>	HSS
<b>Diameter:</b>	0.1590	<b>Length:</b>	1.2720	<b>Tip Angle:</b>	118.0000	
<b>Tool Notes:</b>						



<b>Tool:</b>	7	<b>Description:</b>	0.1900 Dia. 2 Flute Tap - #10-32			<b>Tool Material:</b>	HSS
<b>Diameter:</b>	0.1900	<b>Length:</b>	0.7600	<b>Pitch:</b>	0.0313		
<b>Tool Notes:</b>							

## Step Report

<b>Step:</b>	10	<b>Step Desc:</b>	Face Stock to Z0.0		
<b>Tool No:</b>	1	<b>Tool Desc:</b>	4.0000 Dia. / 0.0310 Rad. 2 Flute Face Mill -		
<b>Doff:</b>	1	<b>Loff:</b>	1		
<b>Speed:</b>	190 RPM	<b>Feed:</b>	0.3820 IPM	<b>Plunge Feed:</b>	0.1910 IPM

<b>Step:</b>	20	<b>Step Desc:</b>	Rough Pocket and Outer Profile Leaving Finish Allowance		
<b>Tool No:</b>	2	<b>Tool Desc:</b>	0.5000 Dia. 2 Flute End Mill -		
<b>Doff:</b>	2	<b>Loff:</b>	2		
<b>Speed:</b>	1527 RPM	<b>Feed:</b>	4.5837 IPM	<b>Plunge Feed:</b>	2.2918 IPM

<b>Step:</b>	30	<b>Step Desc:</b>	Finish Pocket and Outer Profile to Size		
<b>Tool No:</b>	3	<b>Tool Desc:</b>	0.5000 Dia. 2 Flute End Mill -		
<b>Doff:</b>	3	<b>Loff:</b>	3		
<b>Speed:</b>	1909 RPM	<b>Feed:</b>	5.7296 IPM	<b>Plunge Feed:</b>	2.8648 IPM

<b>Step:</b>	40	<b>Step Desc:</b>	Spot Drill All Holes		
<b>Tool No:</b>	4	<b>Tool Desc:</b>	0.5000 Dia. x 90.0 Deg. 2 Flute Spot Drill -		
<b>Doff:</b>	4	<b>Loff:</b>	4		
<b>Speed:</b>	2291 RPM	<b>Feed:</b>	4.5837 IPM	<b>Dwell:</b>	0.2000

<b>Step:</b>	50	<b>Step Desc:</b>	Drill Thru Holes		
<b>Tool No:</b>	5	<b>Tool Desc:</b>	0.3125 Dia. 2 Flute Twist Drill - 5/16		
<b>Doff:</b>	5	<b>Loff:</b>	5		
<b>Speed:</b>	3666 RPM	<b>Feed:</b>	7.3339 IPM	<b>Dwell:</b>	0.2000

<b>Step:</b>	60	<b>Step Desc:</b>	Tap Drill Blind Holes		
<b>Tool No:</b>	6	<b>Tool Desc:</b>	0.1590 Dia. 2 Flute Twist Drill - #21		
<b>Doff:</b>	6	<b>Loff:</b>	6		
<b>Speed:</b>	7207 RPM	<b>Feed:</b>	10.8105 IPM	<b>Dwell:</b>	0.2000

<b>Step:</b>	70	<b>Step Desc:</b>	Tap #10-32 Blind Holes		
<b>Tool No:</b>	7	<b>Tool Desc:</b>	0.1900 Dia. 2 Flute Tap - #10-32		
<b>Doff:</b>	7	<b>Loff:</b>	7		
<b>Speed:</b>	100 RPM	<b>Feed:</b>	3.1250 IPM		

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