

UNo.	MAT	OD-MAX	ID-MIN	LENGTH	RPM	FIN-X	FIN-Z	WORK	FACE	MPX	FIN-LENGTH
0	ALUMINUM	180.	138.	100.	1400	0.8	0.1	15.		*	*

UNo.	UNIT	# 1	# 2	# 3	# 4	# 5	# 6	# 7	# 8	# 9	#10	#11	#12
1	M	153											

UNo.	UNIT	#	CPT-X	CPT-Z		RV	FV	R-FEED	R-DEP.	R-TOOL	F-TOOL
2	BAR OUT	0	168.	-15.		500	600	0.5	4.5	GNL OUT F	GNL OUT F
SEQ	SHP S-CNR		SPT-X	SPT-Z		FPT-X	FPT-Z	F-CNR/\$	RADIUS/ø		ROUGH
1	LIN		*	*		138.	0.			*	0.25
2	CVX		160.326	0.		165.1	2.387			2.387	0.25
3	TPR		165.1	2.387		167.016	7.821			10.	0.25

UNo.	UNIT	#	CPT-X	CPT-Z		RV	FV	R-FEED	R-DEP.	R-TOOL	F-TOOL
3	BAR IN	0	140.	-1.		400	600	0.5	4.		GNL IN B
SEQ	SHP S-CNR		SPT-X	SPT-Z		FPT-X	FPT-Z	F-CNR/\$	RADIUS/ø		ROUGH
1	TPR		154.818	-1.		143.475	0.			80.	0.25
2	CVX		143.475	0.		142.875	0.3			0.3	0.25
3	TPR		142.875	0.3		140.	8.452			10.	0.25

PNo.	MODE	COUNTER	RETURN	WK.No.	CONT.	NUM.	SHIFT
4	END	0	1		0		