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[Page 001] M:\CAMWAREDB_NEW\USR\FRANKS - ANACONDA RINGS\55 INSERT RING.I64\00003601.VDM - Machine In
(Project: FRANKS - ANACONDA RINGS, PartName: 5.5 INSERT RING)
#00003601 (2003004122C OP1 RA)
Date Monday 27th February 2012 Time 14:29:04
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UNo. MAT OD-MAX ID-MIN LENGTH RPM FIN-X FIN-Z WORK FACE MPX FIN-LENGTH
0ALUMINUM 180. 125. 100. 1400 1. 0.2 2. * *

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

UNo. UNIT # CPT-X CPT-Z RV FV R-FEED R-DEP. R-TOOL F-TOOL
2BAR FCE 0 178. -1. 500 600 0.4 1. GNL OUT F
SEQ SHP S-CNR SPT-X SPT-Z FPT-X FPT-Z F-CNR/$ RADIUS/Ø ROUGH
1LIN * * 150. 0. * 0.2

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

UNo. UNIT # CPT-X CPT-Z RV FV R-FEED R-DEP. R-TOOL F-TOOL
4BAR OUT 0 178. -2. 500 600 0.8 6. GNL OUT F GNL OUT G
SEQ SHP S-CNR SPT-X SPT-Z FPT-X FPT-Z F-CNR/$ RADIUS/Ø ROUGH
1TPR 158.192 -0.1 159.326 0. 80. 0.2
2LIN R 2.387 * * 165.1 97. * 0.2

UNo. UNIT # CPT-X CPT-Z RV FV R-FEED R-DEP. R-TOOL F-TOOL
5BAR IN 0 125. -2. 500 600 0.6 5.5 GNL IN A
SEQ SHP S-CNR SPT-X SPT-Z FPT-X FPT-Z F-CNR/$ RADIUS/Ø ROUGH
1TPR 162.5 -0.1 161.349 0. 80. 0.2
2LIN R 2.387 * * 155.575 15.875 * 0.2
3TPR R 0.2 142.875 15.875 142.875 22.225 0.2
4TPR 142.875 22.225 152.4 56.138 0.2
5LIN * * 152.4 62.488 * 0.2
6TPR R 0.2 142.875 62.488 142.875 82. 0.2

UNo. UNIT # 1 # 2 # 3 # 4 # 5 # 6 # 7 # 8 # 9 #10 #11 #12
6M 0

UNo. UNIT # CPT-X CPT-Z RV FV R-FEED R-DEP. R-TOOL F-TOOL
7BAR IN 0 140. -0.5 500 600 0.5 4.2 GNL IN B
SEQ SHP S-CNR SPT-X SPT-Z FPT-X FPT-Z F-CNR/$ RADIUS/Ø ROUGH
1TPR 162.5 -0.1 160.349 0. 80.
2LIN R 2.387 * * 155.575 15.905 * 0.2
3TPR R 0.2 142.875 15.905 142.875 22.225 0.2
4TPR 142.875 22.225 152.4 56.138 0.2
5LIN * * 152.4 62.488 * 0.2
6TPR R 0.2 142.875 62.488 142.875 82. 0.2

UNo. UNIT # 1 # 2 # 3 # 4 # 5 # 6 # 7 # 8 # 9 #10 #11 #12
8M 0

UNo.UNIT MODE POS-B POS-C TORNA. DIA DEPTH CHMF BTM PITCH1 PITCH2
9 CIRC MIL ZY * 0. 1 12. 25. 0. 8 0. 2.
SNo. TOOL NOM-Ø HOLE-Ø HOLE-DEP PRE-DIA PRE-DEP RGH DEPTH C-SP FR M M
1 E-MILL 8. B 12. 13. * CCW 8 C 0. 300 0.1 8 1
FIG SHP SPT-Z SPT-Y SPT-R CZ/PZ CY/PY F M N ANGLE P Q R
1 PT 32. -2. 82.5 * * * * * 0 * 0

UNo.UNIT MODE POS-B POS-C SRV-A SRV-R RGH FIN-A FIN-R
10 LINE IN ZY * 0. 24. 1. 8 0.1 0.25
SNo. TOOL NOM-Ø APRCH-1 APRCH-2 TYPE AFD DEP-A DEP-R C-SP FR M M
R 1 E-MILL 8. B 32.225 -2. CCW G01 6. * 300 0.12 8 1
F 2 E-MILL 6. B 26.725 2. CCW G01 * * 300 0.12 8 1
FIG SHPSHIFT-R P1Z/CZ P1Y/CY P3Z/R P3Y CNR
1 SQR 59. 22.225 -41.325 62.488 41.325 R 0.15

PNo. MODE COUNTER RETURN WK.No. CONT. NUM. SHIFT
11END 0 0

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