

[Page 001] M:\CAMWAREDB_NEW\USR\FRANKS - ANACONDA RINGS\55 INSERT RING.I64\00003600.VDM - Machine In
(Project: FRANKS - ANACONDA RINGS, Part Name: 5.5 INSERT RING)
#00003600 (2003004122C PREP RA)
Date Monday 27th February 2012 Time 14:27:33
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|      |          |        |        |        |      |       |       |      |      |     |            |
|------|----------|--------|--------|--------|------|-------|-------|------|------|-----|------------|
| UNo. | MAT      | OD-MAX | ID-MIN | LENGTH | RPM  | FIN-X | FIN-Z | WORK | FACE | MPX | FIN-LENGTH |
| 0    | ALUMINUM | 180.   | 125.   | 100.   | 1400 | 0.8   | 0.1   |      | 3.   | *   | *          |

  

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

  

|      |           |   |       |       |  |       |       |          |          |        |           |
|------|-----------|---|-------|-------|--|-------|-------|----------|----------|--------|-----------|
| UNo. | UNIT      | # | CPT-X | CPT-Z |  | RV    | FV    | R-FEED   | R-DEP.   | R-TOOL | F-TOOL    |
| 2    | BAR FCE   | 0 | 180.  | -1.7  |  | 500   | 600   | 0.5      | 0.8      |        | GNL OUT F |
| SEQ  | SHP S-CNR |   | SPT-X | SPT-Z |  | FPT-X | FPT-Z | F-CNR/\$ | RADIUS/ø |        | ROUGH     |
| 1    | LIN       |   | *     | *     |  | 125.  | 0.    |          |          | *      | 0.3       |

  

|      |           |   |       |       |  |       |       |          |          |        |          |
|------|-----------|---|-------|-------|--|-------|-------|----------|----------|--------|----------|
| UNo. | UNIT      | # | CPT-X | CPT-Z |  | RV    | FV    | R-FEED   | R-DEP.   | R-TOOL | F-TOOL   |
| 3    | BAR IN    | 0 | 125.  | -1.   |  | 500   | 600   | 0.5      | 2.       |        | GNL IN A |
| SEQ  | SHP S-CNR |   | SPT-X | SPT-Z |  | FPT-X | FPT-Z | F-CNR/\$ | RADIUS/ø |        | ROUGH    |
| 1    | LIN       |   | *     | *     |  | 133.  | -1.   |          |          | *      | 0.3      |
| 2    | TPR       |   | 132.  | -1.   |  | 128.  | 1.    |          |          | 45.    | 0.3      |
| 3    | LIN       |   | *     | *     |  | 128.  | 11.   |          |          | *      | 0.3      |

  

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