

SAMPLE SET UP SHEET FOR 4X HORIZONTAL MILL WITH SUB-PROGRAMS

CUSTOMIZABLE MILL SETUP SHEET - MILL.SET
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PROGRAM NAME = HOUSING FINAL
PROGRAM NUMBER = 0100
DATE PROCESSED = MAY. 02 2010
TIME = 12:21 PM
MATERIAL TYPE = ALUMINUM inch - 2024
STOCK SIZE = X21.8901 Y17.1650 Z1.5000
STOCK ORIGIN = X-4.4727 Y-1.0825 Z.12(AT CENTER, Z AT TOP)
MACHINE NAME = GENERIC MILL
GROUP NAME = MACHINE GROUP-2

OPERATION TYPE = CONTOUR
TOOL NAME = 3 IN FACE MILL TOOL 1
TOOL NUM. = 1
TOOL DIA. = 3.0000
NUMBER OF FLUTES = 4
FLUTE LEN. = .25
OVERALL LEN. = 2.
SHOULDER LEN. = .75
ARBOR DIA. = .5
HOLDER DIA. = 2.
DIA. OFFSET = 41
LEN. OFFSET = 1
SPINDLE = 3500
FEEDRATE = 60.
CUTTER COMP. = OFF
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 60.
MAX_X = -1.1125 MIN_X = -3.1125
MAX_Y = +1.9675 MIN_Y = -11.6325
MAX_Z = +0.5000 MIN_Z = +0.0000
TOOL FEED CUT LENGTH = 27.4
TOOL RAPID TRAVERSE LENGTH = 27.0116
RAPID TIME = 5.4 SECONDS
FEED TIME = 27.32 SECONDS
OPERATION TIME = 32.72 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/4 FINISHER TOOL 27
TOOL NUM. = 27
TOOL DIA. = .7500

NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.
ARBOR DIA. = .75
HOLDER DIA. = 2.
DIA. OFFSET = 67
LEN. OFFSET = 27
SPINDLE = 7000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = .005
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +0.6273 MIN_X = -4.6050
MAX_Y = +0.3800 MIN_Y = -10.0450
MAX_Z = +0.5000 MIN_Z = -1.3850
TOOL FEED CUT LENGTH = 128.7994
TOOL RAPID TRAVERSE LENGTH = 34.6515
RAPID TIME = 6.93 SECONDS
FEED TIME = 2 MINUTES, 48.02 SECONDS
OPERATION TIME = 2 MINUTES, 54.95 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/4 FINISHER TOOL 27
TOOL NUM. = 27
TOOL DIA. = .7500
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.
ARBOR DIA. = .75
HOLDER DIA. = 2.
DIA. OFFSET = 67
LEN. OFFSET = 27
SPINDLE = 7000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
MAX_X = +0.6223 MIN_X = -4.6000
MAX_Y = +0.3750 MIN_Y = -10.0400
MAX_Z = +0.5000 MIN_Z = -1.3850
TOOL FEED CUT LENGTH = 32.3879
TOOL RAPID TRAVERSE LENGTH = 28.8854
RAPID TIME = 5.78 SECONDS
FEED TIME = 42.09 SECONDS
OPERATION TIME = 47.87 SECONDS

OPERATION TYPE = DRILL CYCLE - SIMPLE
TOOL NAME = 1/4 DIA 82 DEG SPOT DRILL TOOL 32
TOOL NUM. = 32

TOOL DIA. = .2500
DRILL TIP ANGLE = 82.
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.5
ARBOR DIA. = .25
HOLDER DIA. = 2.
DIA. OFFSET = 72
LEN. OFFSET = 32
SPINDLE = 10000
FEEDRATE = 20.
MAX_X = -0.2000 MIN_X = -4.0250
MAX_Y = -0.2000 MIN_Y = -9.4650
MAX_Z = +0.5000 MIN_Z = -0.0850
TOOL FEED CUT LENGTH = 1.11
TOOL RAPID TRAVERSE LENGTH = 60.1414
RAPID TIME = 12.03 SECONDS
FEED TIME = 3.33 SECONDS
OPERATION TIME = 15.36 SECONDS

OPERATION TYPE = DRILL CYCLE - COUNTERBORE
TOOL NAME = 1/4 DIA 82 DEG SPOT DRILL TOOL 32
TOOL NUM. = 32
TOOL DIA. = .2500
DRILL TIP ANGLE = 82.
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.5
ARBOR DIA. = .25
HOLDER DIA. = 2.
DIA. OFFSET = 72
LEN. OFFSET = 32
SPINDLE = 10000
FEEDRATE = 20.
MAX_X = -1.0475 MIN_X = -3.1775
MAX_Y = -1.9375 MIN_Y = -8.6175
MAX_Z = +0.5000 MIN_Z = -0.1090
TOOL FEED CUT LENGTH = 1.672
TOOL RAPID TRAVERSE LENGTH = 47.4321
RAPID TIME = 9.49 SECONDS
FEED TIME = 5.02 SECONDS
OPERATION TIME = 14.5 SECONDS

OPERATION TYPE = DRILL CYCLE - CHIP BREAK
TOOL NAME = 23/64 TWIST DRILL TOOL 16
TOOL NUM. = 16
TOOL DIA. = .3594
DRILL TIP ANGLE = 118.
FLUTE LEN. = 2.5
OVERALL LEN. = 4.
SHOULDER LEN. = 3.
ARBOR DIA. = 1.

HOLDER DIA. = 2.
DIA. OFFSET = 56
LEN. OFFSET = 16
SPINDLE = 8000
FEEDRATE = 20.
FEEDRATES: MAX = 20. MIN = 20.
MAX_X = -1.0475 MIN_X = -3.1775
MAX_Y = -1.9375 MIN_Y = -8.6175
MAX_Z = +0.5000 MIN_Z = -0.6700
TOOL FEED CUT LENGTH = 11.76
TOOL RAPID TRAVERSE LENGTH = 57.5201
RAPID TIME = 11.5 SECONDS
FEED TIME = 35.28 SECONDS
OPERATION TIME = 46.78 SECONDS

OPERATION TYPE = POCKET
TOOL NAME = 3/8 END MILL TOOL 11
TOOL NUM. = 11
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.375
OVERALL LEN. = 2.
SHOULDER LEN. = 1.375
ARBOR DIA. = .375
HOLDER DIA. = 2.
DIA. OFFSET = 51
LEN. OFFSET = 11
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
ROUGHING ANGLE = 0.
ROUGHING STEP SIZE = .225
NUMBER OF FINISH PASSES = 1.
FINISH PASS STEP SIZE = .005
FINISH ALLOWANCE = 0.
MAX_X = -0.3875 MIN_X = -3.8375
MAX_Y = -0.4375 MIN_Y = -9.2275
MAX_Z = +0.5000 MIN_Z = -0.8500
TOOL FEED CUT LENGTH = 384.4776
TOOL RAPID TRAVERSE LENGTH = 82.855
RAPID TIME = 16.57 SECONDS
FEED TIME = 10 MINUTES, 10.06 SECONDS
OPERATION TIME = 10 MINUTES, 26.63 SECONDS

OPERATION TYPE = DRILL CYCLE - SIMPLE
TOOL NAME = 3/8 END MILL TOOL 11
TOOL NUM. = 11
TOOL DIA. = .3750
DRILL TIP ANGLE = 45.
FLUTE LEN. = 1.375

OVERALL LEN. = 2.
SHOULDER LEN. = 1.375
ARBOR DIA. = .375
HOLDER DIA. = 2.
DIA. OFFSET = 51
LEN. OFFSET = 11
SPINDLE = 6500
FEEDRATE = 45.
FEEDRATES: MAX = 45. MIN = 36.
MAX_X = -1.0475 MIN_X = -3.1775
MAX_Y = -1.9375 MIN_Y = -8.6175
MAX_Z = +0.5000 MIN_Z = -0.6750
TOOL FEED CUT LENGTH = 6.2
TOOL RAPID TRAVERSE LENGTH = 53.357
RAPID TIME = 10.67 SECONDS
FEED TIME = 10.33 SECONDS
OPERATION TIME = 21 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 1/4 CHF TOOL 40
TOOL NUM. = 40
TOOL DIA. = .2500
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = .25
HOLDER DIA. = 2.
DIA. OFFSET = 80
LEN. OFFSET = 40
SPINDLE = 10000
FEEDRATE = 120.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 120. MIN = 100.
MAX_X = -0.2105 MIN_X = -4.0145
MAX_Y = -0.2605 MIN_Y = -9.4045
MAX_Z = +0.5000 MIN_Z = -0.0150
TOOL FEED CUT LENGTH = 35.2511
TOOL RAPID TRAVERSE LENGTH = 38.5373
RAPID TIME = 7.71 SECONDS
FEED TIME = 17.66 SECONDS
OPERATION TIME = 25.37 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 1/4 CHF TOOL 40
TOOL NUM. = 40
TOOL DIA. = .2500
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.
OVERALL LEN. = 2.

SHOULDER LEN. = 1.2
ARBOR DIA. = .25
HOLDER DIA. = 2.
DIA. OFFSET = 80
LEN. OFFSET = 40
SPINDLE = 10000
FEEDRATE = 120.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 120. MIN = 100.
MAX_X = -0.8705 MIN_X = -3.3545
MAX_Y = -1.7605 MIN_Y = -8.7945
MAX_Z = +0.5000 MIN_Z = -0.0150
TOOL FEED CUT LENGTH = 11.9275
TOOL RAPID TRAVERSE LENGTH = 48.9912
RAPID TIME = 9.8 SECONDS
FEED TIME = 6.06 SECONDS
OPERATION TIME = 15.85 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 1/4 CHF TOOL 40
TOOL NUM. = 40
TOOL DIA. = .2500
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = .25
HOLDER DIA. = 2.
DIA. OFFSET = 80
LEN. OFFSET = 40
SPINDLE = 10000
FEEDRATE = 120.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
MAX_X = +0.0929 MIN_X = -4.2355
MAX_Y = +0.0105 MIN_Y = -9.6755
MAX_Z = +0.5000 MIN_Z = -0.0270
TOOL FEED CUT LENGTH = 28.2417
TOOL RAPID TRAVERSE LENGTH = 28.1165
RAPID TIME = 5.62 SECONDS
FEED TIME = 14.13 SECONDS
OPERATION TIME = 19.76 SECONDS

OPERATION TYPE = DRILL CYCLE - CHIP BREAK
TOOL NAME = 3-3 MM TWIST DRILL TOOL17
TOOL NUM. = 17
TOOL DIA. = .1299
DRILL TIP ANGLE = 118.
FLUTE LEN. = 1.

OVERALL LEN. = 2.
SHOULDER LEN. = 1.5
ARBOR DIA. = .149
HOLDER DIA. = 2.
DIA. OFFSET = 57
LEN. OFFSET = 17
SPINDLE = 10000
FEEDRATE = 20.
MAX_X = -0.2000 MIN_X = -4.0250
MAX_Y = -0.2000 MIN_Y = -9.4650
MAX_Z = +0.5000 MIN_Z = -0.4690
TOOL FEED CUT LENGTH = 10.0142
TOOL RAPID TRAVERSE LENGTH = 62.3959
RAPID TIME = 12.48 SECONDS
FEED TIME = 30.04 SECONDS
OPERATION TIME = 42.52 SECONDS

OPERATION TYPE = DRILL CYCLE - TAP
TOOL NAME = M4 x 7 TAP TOOL 18
TOOL NUM. = 18
TOOL DIA. = .1574
DRILL TIP ANGLE = 118.
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.5
ARBOR DIA. = .25
HOLDER DIA. = 2.
DIA. OFFSET = 58
LEN. OFFSET = 18
SPINDLE = 500
FEEDRATE = 13.75
MAX_X = -0.2000 MIN_X = -4.0250
MAX_Y = -0.2000 MIN_Y = -9.4650
MAX_Z = +0.5000 MIN_Z = -0.3650
TOOL FEED CUT LENGTH = 7.98
TOOL RAPID TRAVERSE LENGTH = 49.9819
RAPID TIME = 10 SECONDS
FEED TIME = 34.82 SECONDS
OPERATION TIME = 44.81 SECONDS

OPERATION TYPE = DRILL CYCLE - SIMPLE
TOOL NAME = 1/4 DIA 82 DEG SPOT DRILL TOOL 32
TOOL NUM. = 32
TOOL DIA. = .2500
DRILL TIP ANGLE = 82.
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.5
ARBOR DIA. = .25
HOLDER DIA. = 2.
DIA. OFFSET = 72
LEN. OFFSET = 32

SPINDLE = 10000
FEEDRATE = 20.
MAX_X = +1.0800 MIN_X = +1.0800
MAX_Y = -1.9375 MIN_Y = -7.5475
MAX_Z = +0.5000 MIN_Z = -0.1090
TOOL FEED CUT LENGTH = .836
TOOL RAPID TRAVERSE LENGTH = 38.8305
RAPID TIME = 7.77 SECONDS
FEED TIME = 2.51 SECONDS
OPERATION TIME = 10.27 SECONDS

OPERATION TYPE = DRILL CYCLE - CHIP BREAK
TOOL NAME = TAP DRILL 190-32 TOOL 37
TOOL NUM. = 37
TOOL DIA. = .1770
DRILL TIP ANGLE = 118.
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = 1.
HOLDER DIA. = 2.
DIA. OFFSET = 77
LEN. OFFSET = 37
SPINDLE = 10000
FEEDRATE = 20.
MAX_X = +1.0800 MIN_X = +1.0800
MAX_Y = -1.9375 MIN_Y = -7.5475
MAX_Z = +0.5000 MIN_Z = -0.5682
TOOL FEED CUT LENGTH = 7.8727
TOOL RAPID TRAVERSE LENGTH = 41.0848
RAPID TIME = 8.22 SECONDS
FEED TIME = 23.62 SECONDS
OPERATION TIME = 31.84 SECONDS

OPERATION TYPE = DRILL CYCLE - TAP
TOOL NAME = 190-32 TAP TOOL 39
TOOL NUM. = 39
TOOL DIA. = .1900
DRILL TIP ANGLE = 118.
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.5
ARBOR DIA. = .25
HOLDER DIA. = 2.
DIA. OFFSET = 79
LEN. OFFSET = 39
SPINDLE = 500
FEEDRATE = 15.63
MAX_X = +1.0800 MIN_X = +1.0800
MAX_Y = -1.9375 MIN_Y = -7.5475
MAX_Z = +0.5000 MIN_Z = -0.4650
TOOL FEED CUT LENGTH = 6.12

TOOL RAPID TRAVERSE LENGTH = 36.3945
RAPID TIME = 7.28 SECONDS
FEED TIME = 23.5 SECONDS
OPERATION TIME = 30.78 SECONDS

OPERATION TYPE = DRILL CYCLE - SIMPLE
TOOL NAME = 1/4 DIA 82 DEG SPOT DRILL TOOL 32
TOOL NUM. = 32
TOOL DIA. = .2500
DRILL TIP ANGLE = 82.
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.5
ARBOR DIA. = .25
HOLDER DIA. = 2.
DIA. OFFSET = 72
LEN. OFFSET = 32
SPINDLE = 10000
FEEDRATE = 20.
MAX_X = -1.0800 MIN_X = -1.0800
MAX_Y = -2.8175 MIN_Y = -7.5475
MAX_Z = +0.5000 MIN_Z = -0.1090
TOOL FEED CUT LENGTH = .627
TOOL RAPID TRAVERSE LENGTH = 34.1997
RAPID TIME = 6.84 SECONDS
FEED TIME = 1.88 SECONDS
OPERATION TIME = 8.72 SECONDS

OPERATION TYPE = DRILL CYCLE - PECK
TOOL NAME = TAP DRILL 190-32 TOOL 37
TOOL NUM. = 37
TOOL DIA. = .1770
DRILL TIP ANGLE = 118.
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = 1.
HOLDER DIA. = 2.
DIA. OFFSET = 77
LEN. OFFSET = 37
SPINDLE = 10000
FEEDRATE = 20.
MAX_X = -1.0800 MIN_X = -1.0800
MAX_Y = -2.8175 MIN_Y = -7.5475
MAX_Z = +0.5000 MIN_Z = -0.5682
TOOL FEED CUT LENGTH = 5.9045
TOOL RAPID TRAVERSE LENGTH = 59.2773
RAPID TIME = 11.86 SECONDS
FEED TIME = 17.71 SECONDS
OPERATION TIME = 29.57 SECONDS

OPERATION TYPE = DRILL CYCLE - TAP
TOOL NAME = 190-32 TAP TOOL 39
TOOL NUM. = 39
TOOL DIA. = .1900
DRILL TIP ANGLE = 118.
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.5
ARBOR DIA. = .25
HOLDER DIA. = 2.
DIA. OFFSET = 79
LEN. OFFSET = 39
SPINDLE = 500
FEEDRATE = 15.63
FEEDRATES: MAX = 15.63 MIN = 15.63
MAX_X = -1.0800 MIN_X = -1.0800
MAX_Y = -2.8175 MIN_Y = -7.5475
MAX_Z = +0.5000 MIN_Z = -0.4800
TOOL FEED CUT LENGTH = 4.68
TOOL RAPID TRAVERSE LENGTH = 36.1829
RAPID TIME = 7.24 SECONDS
FEED TIME = 17.97 SECONDS
OPERATION TIME = 25.21 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/4 FINISHER TOOL 27
TOOL NUM. = 27
TOOL DIA. = .7500
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.
ARBOR DIA. = .75
HOLDER DIA. = 2.
DIA. OFFSET = 67
LEN. OFFSET = 27
SPINDLE = 7000
FEEDRATE = 80.
CUTTER COMP. = OFF
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 80.
MAX_X = +0.0195 MIN_X = -10.5825
MAX_Y = +7.3633 MIN_Y = +3.1383
MAX_Z = +0.5000 MIN_Z = +0.0600
TOOL FEED CUT LENGTH = 85.5229
TOOL RAPID TRAVERSE LENGTH = 30.9707
RAPID TIME = 6.19 SECONDS
FEED TIME = 1 MINUTE, 4.12 SECONDS
OPERATION TIME = 1 MINUTE, 10.31 SECONDS

OPERATION TYPE = CONTOUR

TOOL NAME = 3/4 FINISHER TOOL 27
TOOL NUM. = 27
TOOL DIA. = .7500
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.
ARBOR DIA. = .75
HOLDER DIA. = 2.
DIA. OFFSET = 67
LEN. OFFSET = 27
SPINDLE = 7000
FEEDRATE = 80.
CUTTER COMP. = OFF
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 80.
MAX_X = +0.0195 MIN_X = -10.5825
MAX_Y = +7.3633 MIN_Y = +3.1383
MAX_Z = +0.5000 MIN_Z = +0.0100
TOOL FEED CUT LENGTH = 85.5731
TOOL RAPID TRAVERSE LENGTH = 31.9661
RAPID TIME = 6.39 SECONDS
FEED TIME = 1 MINUTE, 4.15 SECONDS
OPERATION TIME = 1 MINUTE, 10.54 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/4 FINISHER TOOL 27
TOOL NUM. = 27
TOOL DIA. = .7500
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.
ARBOR DIA. = .75
HOLDER DIA. = 2.
DIA. OFFSET = 67
LEN. OFFSET = 27
SPINDLE = 7000
FEEDRATE = 80.
CUTTER COMP. = OFF
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 80.
MAX_X = +0.0195 MIN_X = -10.5825
MAX_Y = +7.3633 MIN_Y = +3.1383
MAX_Z = +0.5000 MIN_Z = +0.0000
TOOL FEED CUT LENGTH = 85.5829
TOOL RAPID TRAVERSE LENGTH = 31.0307
RAPID TIME = 6.21 SECONDS
FEED TIME = 1 MINUTE, 4.15 SECONDS
OPERATION TIME = 1 MINUTE, 10.36 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 1/2 IN END MILL TOOL 2
TOOL NUM. = 2
TOOL DIA. = .5000
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = .5
HOLDER DIA. = 2.
DIA. OFFSET = 42
LEN. OFFSET = 2
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +10.1460 MIN_X = +8.8460
MAX_Y = +0.4250 MIN_Y = -4.6500
MAX_Z = +0.5000 MIN_Z = -0.0150
TOOL FEED CUT LENGTH = 4.3986
TOOL RAPID TRAVERSE LENGTH = 23.4493
RAPID TIME = 4.69 SECONDS
FEED TIME = 5.7 SECONDS
OPERATION TIME = 10.39 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 1/2 IN END MILL TOOL 2
TOOL NUM. = 2
TOOL DIA. = .5000
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = .5
HOLDER DIA. = 2.
DIA. OFFSET = 42
LEN. OFFSET = 2
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = .002
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +9.8515 MIN_X = -0.4000
MAX_Y = -0.0230 MIN_Y = -4.2020
MAX_Z = +0.5000 MIN_Z = -0.0150
TOOL FEED CUT LENGTH = 23.7652
TOOL RAPID TRAVERSE LENGTH = 24.8587
RAPID TIME = 4.97 SECONDS
FEED TIME = 31.6 SECONDS

OPERATION TIME = 36.57 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 1/2 IN END MILL TOOL 2
TOOL NUM. = 2
TOOL DIA. = .5000
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = .5
HOLDER DIA. = 2.
DIA. OFFSET = 42
LEN. OFFSET = 2
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. = OFF
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +7.4950 MIN_X = -0.3750
MAX_Y = -2.1125 MIN_Y = -2.1137
MAX_Z = +0.5000 MIN_Z = -0.0150
TOOL FEED CUT LENGTH = 7.985
TOOL RAPID TRAVERSE LENGTH = 26.3635
RAPID TIME = 5.27 SECONDS
FEED TIME = 10.56 SECONDS
OPERATION TIME = 15.84 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 1/2 IN END MILL TOOL 2
TOOL NUM. = 2
TOOL DIA. = .5000
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = .5
HOLDER DIA. = 2.
DIA. OFFSET = 42
LEN. OFFSET = 2
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = .002
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +9.6170 MIN_X = -0.7900
MAX_Y = -0.0480 MIN_Y = -4.1770
MAX_Z = +0.5000 MIN_Z = -0.0150
TOOL FEED CUT LENGTH = 43.9949
TOOL RAPID TRAVERSE LENGTH = 27.5257

RAPID TIME = 5.51 SECONDS
FEED TIME = 58.49 SECONDS
OPERATION TIME = 1 MINUTE, 4 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 1/8 IN END MILL TOOL 19
TOOL NUM. = 19
TOOL DIA. = .1250
NUMBER OF FLUTES = 4
FLUTE LEN. = .5
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = .125
HOLDER DIA. = 2.
DIA. OFFSET = 59
LEN. OFFSET = 19
SPINDLE = 10000
FEEDRATE = 32.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 32.
MAX_X = +7.8780 MIN_X = -0.1025
MAX_Y = -1.4400 MIN_Y = -2.7850
MAX_Z = +0.5000 MIN_Z = -0.0150
TOOL FEED CUT LENGTH = 18.6044
TOOL RAPID TRAVERSE LENGTH = 26.7097
RAPID TIME = 5.34 SECONDS
FEED TIME = 34.74 SECONDS
OPERATION TIME = 40.08 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 1/8 IN END MILL TOOL 19
TOOL NUM. = 19
TOOL DIA. = .1250
NUMBER OF FLUTES = 4
FLUTE LEN. = .5
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = .125
HOLDER DIA. = 2.
DIA. OFFSET = 59
LEN. OFFSET = 19
SPINDLE = 10000
FEEDRATE = 32.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
MAX_X = +9.4275 MIN_X = -0.1025
MAX_Y = -0.2375 MIN_Y = -3.9875
MAX_Z = +0.5000 MIN_Z = -0.0150
TOOL FEED CUT LENGTH = 23.6058

TOOL RAPID TRAVERSE LENGTH = 25.098
RAPID TIME = 5.02 SECONDS
FEED TIME = 44.11 SECONDS
OPERATION TIME = 49.13 SECONDS

OPERATION TYPE = DRILL CYCLE - SIMPLE
TOOL NAME = 1/4 DIA 82 DEG SPOT DRILL TOOL 32
TOOL NUM. = 32
TOOL DIA. = .2500
DRILL TIP ANGLE = 82.
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.5
ARBOR DIA. = .25
HOLDER DIA. = 2.
DIA. OFFSET = 72
LEN. OFFSET = 32
SPINDLE = 10000
FEEDRATE = 20.
MAX_X = +9.4850 MIN_X = +0.5500
MAX_Y = -0.1800 MIN_Y = -4.0450
MAX_Z = +0.5000 MIN_Z = -0.0980
TOOL FEED CUT LENGTH = 12.87
TOOL RAPID TRAVERSE LENGTH = 164.9132
RAPID TIME = 32.98 SECONDS
FEED TIME = 38.61 SECONDS
OPERATION TIME = 1 MINUTE, 11.59 SECONDS

OPERATION TYPE = DRILL CYCLE - CHIP BREAK
TOOL NAME = DRILL FOR 164-32 TAP TOOL 34
TOOL NUM. = 34
TOOL DIA. = .1640
DRILL TIP ANGLE = 118.
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = 1.
HOLDER DIA. = 2.
DIA. OFFSET = 74
LEN. OFFSET = 34
SPINDLE = 10000
FEEDRATE = 20.
MAX_X = +9.4850 MIN_X = +0.5500
MAX_Y = -0.1800 MIN_Y = -4.0450
MAX_Z = +0.5000 MIN_Z = -0.4493
TOOL FEED CUT LENGTH = 36.7143
TOOL RAPID TRAVERSE LENGTH = 180.5607
RAPID TIME = 36.11 SECONDS
FEED TIME = 1 MINUTE, 50.14 SECONDS
OPERATION TIME = 2 MINUTES, 26.25 SECONDS

OPERATION TYPE = DRILL CYCLE - TAP
TOOL NAME = 164 -32 TAP TOOL 15
TOOL NUM. = 15
TOOL DIA. = .1640
DRILL TIP ANGLE = 118.
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.5
ARBOR DIA. = .25
HOLDER DIA. = 2.
DIA. OFFSET = 55
LEN. OFFSET = 15
SPINDLE = 500
FEEDRATE = 15.63
MAX_X = +9.4850 MIN_X = +0.5500
MAX_Y = -0.1800 MIN_Y = -4.0450
MAX_Z = +0.5000 MIN_Z = -0.3500
TOOL FEED CUT LENGTH = 63.7
TOOL RAPID TRAVERSE LENGTH = 119.4352
RAPID TIME = 23.89 SECONDS
FEED TIME = 4 MINUTES, 4.61 SECONDS
OPERATION TIME = 4 MINUTES, 28.5 SECONDS

OPERATION TYPE = DRILL CYCLE - CHIP BREAK
TOOL NAME = DRILL FOR 138-32 TAP TOOL 36
TOOL NUM. = 36
TOOL DIA. = .1380
DRILL TIP ANGLE = 118.
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = 1.
HOLDER DIA. = 2.
DIA. OFFSET = 76
LEN. OFFSET = 36
SPINDLE = 10000
FEEDRATE = 20.
MAX_X = +8.6175 MIN_X = +1.9375
MAX_Y = -1.0475 MIN_Y = -3.1775
MAX_Z = +0.5000 MIN_Z = -0.8115
TOOL FEED CUT LENGTH = 10.1717
TOOL RAPID TRAVERSE LENGTH = 56.5123
RAPID TIME = 11.3 SECONDS
FEED TIME = 30.52 SECONDS
OPERATION TIME = 41.82 SECONDS

OPERATION TYPE = DRILL CYCLE - TAP
TOOL NAME = 138-32 TAP TOOL 13
TOOL NUM. = 13
TOOL DIA. = .1380
DRILL TIP ANGLE = 118.
FLUTE LEN. = 1.

OVERALL LEN. = 2.
SHOULDER LEN. = 1.5
ARBOR DIA. = .25
HOLDER DIA. = 2.
DIA. OFFSET = 53
LEN. OFFSET = 13
SPINDLE = 500
FEEDRATE = 15.63
MAX_X = +8.6175 MIN_X = +1.9375
MAX_Y = -1.0475 MIN_Y = -3.1775
MAX_Z = +0.5000 MIN_Z = -0.3200
TOOL FEED CUT LENGTH = 9.92
TOOL RAPID TRAVERSE LENGTH = 39.8782
RAPID TIME = 7.98 SECONDS
FEED TIME = 38.09 SECONDS
OPERATION TIME = 46.07 SECONDS

OPERATION TYPE = DRILL CYCLE - CHIP BREAK
TOOL NAME = 27/64 TWIST DRILL TOOL 38
TOOL NUM. = 38
TOOL DIA. = .4210
DRILL TIP ANGLE = 118.
FLUTE LEN. = 1.9
OVERALL LEN. = 3.
SHOULDER LEN. = 2.
ARBOR DIA. = .4375
HOLDER DIA. = .4375
DIA. OFFSET = 78
LEN. OFFSET = 38
SPINDLE = 6500
FEEDRATE = 20.
FEEDRATES: MAX = 20. MIN = 20.
MAX_X = +9.0800 MIN_X = +2.4000
MAX_Y = -1.0475 MIN_Y = -3.1775
MAX_Z = +0.5000 MIN_Z = -1.2700
TOOL FEED CUT LENGTH = 21.36
TOOL RAPID TRAVERSE LENGTH = 64.3944
RAPID TIME = 12.88 SECONDS
FEED TIME = 1 MINUTE, 4.08 SECONDS
OPERATION TIME = 1 MINUTE, 16.96 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320

DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. = OFF
STOCK TO LEAVE (XY)= 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +3.2800 MIN_X = +2.3550
MAX_Y = -0.5850 MIN_Y = -1.5100
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 24.3863
TOOL RAPID TRAVERSE LENGTH = 24.6058
RAPID TIME = 4.92 SECONDS
FEED TIME = 32.31 SECONDS
OPERATION TIME = 37.23 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY)= 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +3.3175 MIN_X = +2.3175
MAX_Y = -0.5475 MIN_Y = -1.5475
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 18.4459
TOOL RAPID TRAVERSE LENGTH = 28.8165
RAPID TIME = 5.76 SECONDS
FEED TIME = 20.62 SECONDS
OPERATION TIME = 26.39 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.

SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +3.2742 MIN_X = +2.3925
MAX_Y = -0.6225 MIN_Y = -1.4725
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 16.767
TOOL RAPID TRAVERSE LENGTH = 29.0533
RAPID TIME = 5.81 SECONDS
FEED TIME = 18.39 SECONDS
OPERATION TIME = 24.2 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. = OFF
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +2.4000 MIN_X = +1.4750
MAX_Y = -2.7150 MIN_Y = -3.6400
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 24.3863
TOOL RAPID TRAVERSE LENGTH = 26.8871
RAPID TIME = 5.38 SECONDS
FEED TIME = 32.31 SECONDS
OPERATION TIME = 37.69 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25

TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +2.4375 MIN_X = +1.4375
MAX_Y = -2.6775 MIN_Y = -3.6775
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 18.4459
TOOL RAPID TRAVERSE LENGTH = 31.0948
RAPID TIME = 6.22 SECONDS
FEED TIME = 20.62 SECONDS
OPERATION TIME = 26.84 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +2.3942 MIN_X = +1.5125
MAX_Y = -2.7525 MIN_Y = -3.6025
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 16.767
TOOL RAPID TRAVERSE LENGTH = 31.3337
RAPID TIME = 6.27 SECONDS
FEED TIME = 18.39 SECONDS
OPERATION TIME = 24.65 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. = OFF
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +4.1700 MIN_X = +3.2450
MAX_Y = -2.7150 MIN_Y = -3.6400
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 24.3863
TOOL RAPID TRAVERSE LENGTH = 26.0846
RAPID TIME = 5.22 SECONDS
FEED TIME = 32.31 SECONDS
OPERATION TIME = 37.53 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +4.2075 MIN_X = +3.2075
MAX_Y = -2.6775 MIN_Y = -3.6775
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 18.4459
TOOL RAPID TRAVERSE LENGTH = 30.2805

RAPID TIME = 6.06 SECONDS
FEED TIME = 20.62 SECONDS
OPERATION TIME = 26.68 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +4.1642 MIN_X = +3.2825
MAX_Y = -2.7525 MIN_Y = -3.6025
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 16.7671
TOOL RAPID TRAVERSE LENGTH = 30.5276
RAPID TIME = 6.11 SECONDS
FEED TIME = 18.39 SECONDS
OPERATION TIME = 24.49 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. = OFF
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +6.0000 MIN_X = +5.0750

MAX_Y = -2.7150 MIN_Y = -3.6400
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 24.3871
TOOL RAPID TRAVERSE LENGTH = 25.4462
RAPID TIME = 5.09 SECONDS
FEED TIME = 32.31 SECONDS
OPERATION TIME = 37.4 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +6.0375 MIN_X = +5.0375
MAX_Y = -2.6775 MIN_Y = -3.6775
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 18.4459
TOOL RAPID TRAVERSE LENGTH = 29.6313
RAPID TIME = 5.93 SECONDS
FEED TIME = 20.62 SECONDS
OPERATION TIME = 26.55 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT

STOCK TO LEAVE (XY)= 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +5.9942 MIN_X = +5.1125
MAX_Y = -2.7525 MIN_Y = -3.6025
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 16.7671
TOOL RAPID TRAVERSE LENGTH = 29.8859
RAPID TIME = 5.98 SECONDS
FEED TIME = 18.39 SECONDS
OPERATION TIME = 24.36 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. = OFF
STOCK TO LEAVE (XY)= 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +5.6000 MIN_X = +4.6750
MAX_Y = -0.5850 MIN_Y = -1.5100
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 24.3863
TOOL RAPID TRAVERSE LENGTH = 23.5665
RAPID TIME = 4.71 SECONDS
FEED TIME = 32.31 SECONDS
OPERATION TIME = 37.02 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65

LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +5.6375 MIN_X = +4.6375
MAX_Y = -0.5475 MIN_Y = -1.5475
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 18.4459
TOOL RAPID TRAVERSE LENGTH = 27.7589
RAPID TIME = 5.55 SECONDS
FEED TIME = 20.62 SECONDS
OPERATION TIME = 26.18 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +5.5942 MIN_X = +4.7125
MAX_Y = -0.6225 MIN_Y = -1.4725
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 16.767
TOOL RAPID TRAVERSE LENGTH = 28.0084
RAPID TIME = 5.6 SECONDS
FEED TIME = 18.39 SECONDS
OPERATION TIME = 23.99 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8

ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. = OFF
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +8.0100 MIN_X = +7.0850
MAX_Y = -2.7150 MIN_Y = -3.6400
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 24.3863
TOOL RAPID TRAVERSE LENGTH = 25.0019
RAPID TIME = 5 SECONDS
FEED TIME = 32.31 SECONDS
OPERATION TIME = 37.31 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +8.0475 MIN_X = +7.0475
MAX_Y = -2.6775 MIN_Y = -3.6775
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 18.4459
TOOL RAPID TRAVERSE LENGTH = 29.1777
RAPID TIME = 5.84 SECONDS
FEED TIME = 20.62 SECONDS
OPERATION TIME = 26.46 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750

NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +8.0042 MIN_X = +7.1225
MAX_Y = -2.7525 MIN_Y = -3.6025
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 16.767
TOOL RAPID TRAVERSE LENGTH = 29.4388
RAPID TIME = 5.89 SECONDS
FEED TIME = 18.39 SECONDS
OPERATION TIME = 24.27 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. = OFF
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +9.0800 MIN_X = +8.1550
MAX_Y = -1.6450 MIN_Y = -2.5700
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 24.3863
TOOL RAPID TRAVERSE LENGTH = 23.8174
RAPID TIME = 4.76 SECONDS
FEED TIME = 32.31 SECONDS
OPERATION TIME = 37.07 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +9.1175 MIN_X = +8.1175
MAX_Y = -1.6075 MIN_Y = -2.6075
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 18.4459
TOOL RAPID TRAVERSE LENGTH = 27.9901
RAPID TIME = 5.6 SECONDS
FEED TIME = 20.62 SECONDS
OPERATION TIME = 26.22 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +9.0742 MIN_X = +8.1925
MAX_Y = -1.6825 MIN_Y = -2.5325
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 16.767
TOOL RAPID TRAVERSE LENGTH = 28.2533
RAPID TIME = 5.65 SECONDS

FEED TIME = 18.39 SECONDS
OPERATION TIME = 24.04 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. = OFF
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +8.0100 MIN_X = +7.0850
MAX_Y = -0.5850 MIN_Y = -1.5100
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 24.3863
TOOL RAPID TRAVERSE LENGTH = 22.9003
RAPID TIME = 4.58 SECONDS
FEED TIME = 32.31 SECONDS
OPERATION TIME = 36.89 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +8.0475 MIN_X = +7.0475
MAX_Y = -0.5475 MIN_Y = -1.5475

MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 18.4459
TOOL RAPID TRAVERSE LENGTH = 27.0776
RAPID TIME = 5.42 SECONDS
FEED TIME = 20.62 SECONDS
OPERATION TIME = 26.04 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 3/8 END MILL 1/32 rad TOOL 25
TOOL NUM. = 25
TOOL DIA. = .3750
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.5
OVERALL LEN. = 3.
SHOULDER LEN. = 2.8
ARBOR DIA. = .375
HOLDER DIA. = .375
TOOL CORNER RAD. = .0320
DIA. OFFSET = 65
LEN. OFFSET = 25
SPINDLE = 8000
FEEDRATE = 45.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 45.
MAX_X = +8.0042 MIN_X = +7.1225
MAX_Y = -0.6225 MIN_Y = -1.4725
MAX_Z = +0.5000 MIN_Z = -1.2750
TOOL FEED CUT LENGTH = 16.767
TOOL RAPID TRAVERSE LENGTH = 27.3376
RAPID TIME = 5.47 SECONDS
FEED TIME = 18.39 SECONDS
OPERATION TIME = 23.85 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 1/4 END MILL TOOL 22
TOOL NUM. = 22
TOOL DIA. = .2500
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = .25
HOLDER DIA. = .25
DIA. OFFSET = 58
LEN. OFFSET = 18
SPINDLE = 10000
FEEDRATE = 44.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.

FEEDRATES: MAX = 100. MIN = 44.
MAX_X = -0.0080 MIN_X = -0.3580
MAX_Y = +0.2600 MIN_Y = -4.4850
MAX_Z = +0.5000 MIN_Z = -0.4200
TOOL FEED CUT LENGTH = 22.76
TOOL RAPID TRAVERSE LENGTH = 46.2799
RAPID TIME = 9.26 SECONDS
FEED TIME = 26.99 SECONDS
OPERATION TIME = 36.25 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 1/4 END MILL TOOL 22
TOOL NUM. = 22
TOOL DIA. = .2500
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = .25
HOLDER DIA. = .25
DIA. OFFSET = 58
LEN. OFFSET = 18
SPINDLE = 10000
FEEDRATE = 44.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 44.
MAX_X = +0.0020 MIN_X = -0.3480
MAX_Y = +0.2500 MIN_Y = -4.4750
MAX_Z = +0.5000 MIN_Z = -0.4200
TOOL FEED CUT LENGTH = 5.405
TOOL RAPID TRAVERSE LENGTH = 30.7922
RAPID TIME = 6.16 SECONDS
FEED TIME = 6.58 SECONDS
OPERATION TIME = 12.73 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 1/4 END MILL TOOL 22
TOOL NUM. = 22
TOOL DIA. = .2500
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = .25
HOLDER DIA. = .25
DIA. OFFSET = 58
LEN. OFFSET = 18
SPINDLE = 10000
FEEDRATE = 44.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT

STOCK TO LEAVE (XY)= 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 44.
MAX_X = +0.0750 MIN_X = -0.3220
MAX_Y = +0.2600 MIN_Y = -4.4850
MAX_Z = +0.5000 MIN_Z = -0.2100
TOOL FEED CUT LENGTH = 10.748
TOOL RAPID TRAVERSE LENGTH = 35.3191
RAPID TIME = 7.06 SECONDS
FEED TIME = 13.26 SECONDS
OPERATION TIME = 20.32 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 1/4 END MILL TOOL 22
TOOL NUM. = 22
TOOL DIA. = .2500
NUMBER OF FLUTES = 4
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = .25
HOLDER DIA. = .25
DIA. OFFSET = 58
LEN. OFFSET = 18
SPINDLE = 10000
FEEDRATE = 44.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY)= 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 100. MIN = 44.
MAX_X = +0.0850 MIN_X = -0.3120
MAX_Y = +0.2500 MIN_Y = -4.4750
MAX_Z = +0.5000 MIN_Z = -0.2100
TOOL FEED CUT LENGTH = 5.079
TOOL RAPID TRAVERSE LENGTH = 30.3252
RAPID TIME = 6.07 SECONDS
FEED TIME = 6.45 SECONDS
OPERATION TIME = 12.52 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 1/4 - 45 DEG CHF TOOL 40
TOOL NUM. = 40
TOOL DIA. = .2500
NUMBER OF FLUTES = 2
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = .25
HOLDER DIA. = .25
DIA. OFFSET = 80
LEN. OFFSET = 40
SPINDLE = 13000

FEEDRATE = 120.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY)= 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 120. MIN = 100.
MAX_X = +9.3710 MIN_X = -0.2900
MAX_Y = -0.2940 MIN_Y = -3.9310
MAX_Z = +0.5000 MIN_Z = -0.0100
TOOL FEED CUT LENGTH = 42.9459
TOOL RAPID TRAVERSE LENGTH = 26.8453
RAPID TIME = 5.37 SECONDS
FEED TIME = 21.49 SECONDS
OPERATION TIME = 26.86 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 1/4 - 45 DEG CHF TOOL 40
TOOL NUM. = 40
TOOL DIA. = .2500
NUMBER OF FLUTES = 2
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = .25
HOLDER DIA. = .25
DIA. OFFSET = 80
LEN. OFFSET = 40
SPINDLE = 13000
FEEDRATE = 120.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY)= 0.
STOCK TO LEAVE (Z) = 0.
FEEDRATES: MAX = 120. MIN = 100.
MAX_X = +9.2990 MIN_X = +1.2560
MAX_Y = -0.3660 MIN_Y = -3.8590
MAX_Z = +0.5000 MIN_Z = -0.0100
TOOL FEED CUT LENGTH = 49.6155
TOOL RAPID TRAVERSE LENGTH = 53.1359
RAPID TIME = 10.63 SECONDS
FEED TIME = 24.98 SECONDS
OPERATION TIME = 35.61 SECONDS

OPERATION TYPE = CONTOUR
TOOL NAME = 1/4 - 45 DEG CHF TOOL 40
TOOL NUM. = 40
TOOL DIA. = .2500
NUMBER OF FLUTES = 2
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = .25
HOLDER DIA. = .25
DIA. OFFSET = 80

LEN. OFFSET = 40
SPINDLE = 13000
FEEDRATE = 120.
CUTTER COMP. (WEAR, IN CONTROL) = LEFT
STOCK TO LEAVE (XY) = 0.
STOCK TO LEAVE (Z) = 0.
MAX_X = +9.6760 MIN_X = -0.2900
MAX_Y = +0.0110 MIN_Y = -4.2360
MAX_Z = +0.5000 MIN_Z = -0.0300
TOOL FEED CUT LENGTH = 23.9244
TOOL RAPID TRAVERSE LENGTH = 24.771
RAPID TIME = 4.95 SECONDS
FEED TIME = 11.98 SECONDS
OPERATION TIME = 16.93 SECONDS

OPERATION TYPE = DRILL CYCLE - SIMPLE
TOOL NAME = 1/4 DIA 82 DEG SPOT DRILL TOOL 32
TOOL NUM. = 32
TOOL DIA. = .2500
DRILL TIP ANGLE = 82.
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.5
ARBOR DIA. = .25
HOLDER DIA. = 2.
DIA. OFFSET = 73
LEN. OFFSET = 32
SPINDLE = 10000
FEEDRATE = 20.
MAX_X = +0.2950 MIN_X = +0.2950
MAX_Y = -2.1075 MIN_Y = -2.1075
MAX_Z = +0.5000 MIN_Z = -0.1090
TOOL FEED CUT LENGTH = .209
TOOL RAPID TRAVERSE LENGTH = 26.026
RAPID TIME = 5.21 SECONDS
FEED TIME = .63 SECONDS
OPERATION TIME = 5.83 SECONDS

OPERATION TYPE = DRILL CYCLE - CHIP BREAK
TOOL NAME = TAP DRILL 190-32 TOOL 37
TOOL NUM. = 37
TOOL DIA. = .1770
DRILL TIP ANGLE = 118.
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.2
ARBOR DIA. = 1.
HOLDER DIA. = 2.
DIA. OFFSET = 77
LEN. OFFSET = 37
SPINDLE = 10000
FEEDRATE = 20.

MAX_X = +0.2950 MIN_X = +0.2950
MAX_Y = -2.1075 MIN_Y = -2.1075
MAX_Z = +0.5000 MIN_Z = -0.5332
TOOL FEED CUT LENGTH = 1.8332
TOOL RAPID TRAVERSE LENGTH = 27.6502
RAPID TIME = 5.53 SECONDS
FEED TIME = 5.5 SECONDS
OPERATION TIME = 11.03 SECONDS

OPERATION TYPE = DRILL CYCLE - TAP
TOOL NAME = 190-32 TAP TOOL 39
TOOL NUM. = 39
TOOL DIA. = .1900
DRILL TIP ANGLE = 118.
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.5
ARBOR DIA. = .25
HOLDER DIA. = 2.
DIA. OFFSET = 79
LEN. OFFSET = 39
SPINDLE = 500
FEEDRATE = 15.63
MAX_X = +0.2950 MIN_X = +0.2950
MAX_Y = -2.1075 MIN_Y = -2.1075
MAX_Z = +0.5000 MIN_Z = -0.4500
TOOL FEED CUT LENGTH = 1.5
TOOL RAPID TRAVERSE LENGTH = 25.417
RAPID TIME = 5.08 SECONDS
FEED TIME = 5.76 SECONDS
OPERATION TIME = 10.84 SECONDS

OPERATION TYPE = DRILL CYCLE - SIMPLE
TOOL NAME = #1 82 DEG CENTER DRILL TOOL 5
TOOL NUM. = 5
TOOL DIA. = .2500
DRILL TIP ANGLE = 82.
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.5
ARBOR DIA. = .25
HOLDER DIA. = 2.
DIA. OFFSET = 72
LEN. OFFSET = 5
SPINDLE = 10000
FEEDRATE = 20.
MAX_X = -0.3100 MIN_X = -0.3100
MAX_Y = -0.1750 MIN_Y = -4.0500
MAX_Z = +0.5000 MIN_Z = -0.2300
TOOL FEED CUT LENGTH = 1.98
TOOL RAPID TRAVERSE LENGTH = 34.6403
RAPID TIME = 6.93 SECONDS

FEED TIME = 5.94 SECONDS
OPERATION TIME = 12.87 SECONDS

OPERATION TYPE = DRILL CYCLE - CHIP BREAK
TOOL NAME = DRILL FOR 112-40 TAP TOOL 12
TOOL NUM. = 12
TOOL DIA. = .1130
DRILL TIP ANGLE = 118.
FLUTE LEN. = 1.5
OVERALL LEN. = 2.
SHOULDER LEN. = 1.7
ARBOR DIA. = 1.
HOLDER DIA. = 2.
DIA. OFFSET = 52
LEN. OFFSET = 12
SPINDLE = 10000
FEEDRATE = 20.
MAX_X = -0.3100 MIN_X = -0.3100
MAX_Y = -0.1750 MIN_Y = -4.0500
MAX_Z = +0.5000 MIN_Z = -0.5339
TOOL FEED CUT LENGTH = 11.0037
TOOL RAPID TRAVERSE LENGTH = 43.6637
RAPID TIME = 8.73 SECONDS
FEED TIME = 33.01 SECONDS
OPERATION TIME = 41.74 SECONDS

OPERATION TYPE = DRILL CYCLE - TAP
TOOL NAME = 112-40 TAP TOOL 7
TOOL NUM. = 7
TOOL DIA. = .1120
DRILL TIP ANGLE = 118.
FLUTE LEN. = 1.
OVERALL LEN. = 2.
SHOULDER LEN. = 1.5
ARBOR DIA. = .25
HOLDER DIA. = 2.
DIA. OFFSET = 47
LEN. OFFSET = 7
SPINDLE = 500
FEEDRATE = 12.5
MAX_X = -0.3100 MIN_X = -0.3100
MAX_Y = -0.1750 MIN_Y = -4.0500
MAX_Z = +0.5000 MIN_Z = -0.3750
TOOL FEED CUT LENGTH = 8.1
TOOL RAPID TRAVERSE LENGTH = 33.2021
RAPID TIME = 6.64 SECONDS
FEED TIME = 38.88 SECONDS
OPERATION TIME = 45.52 SECONDS

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PROGRAM TOTALS (71 TOOLS):

FEEDRATES: MAX = 120. MIN = 12.5
MAX_X = +10.1460 MIN_X = -10.5825
MAX_Y = +7.3633 MIN_Y = -11.6325
MAX_Z = +0.5000 MIN_Z = -1.3850
TOTAL FEED CUT LENGTH = 1908.9287
TOTAL RAPID TRAVERSE LENGTH = 2841.5567
TOTAL RAPID TIME = 9 MINUTES, 28.31 SECONDS
TOTAL FEED TIME = 46 MINUTES, 7.02 SECONDS
CYCLE TIME: 1 HOUR, 2 MINUTES, 41.33 SECONDS