

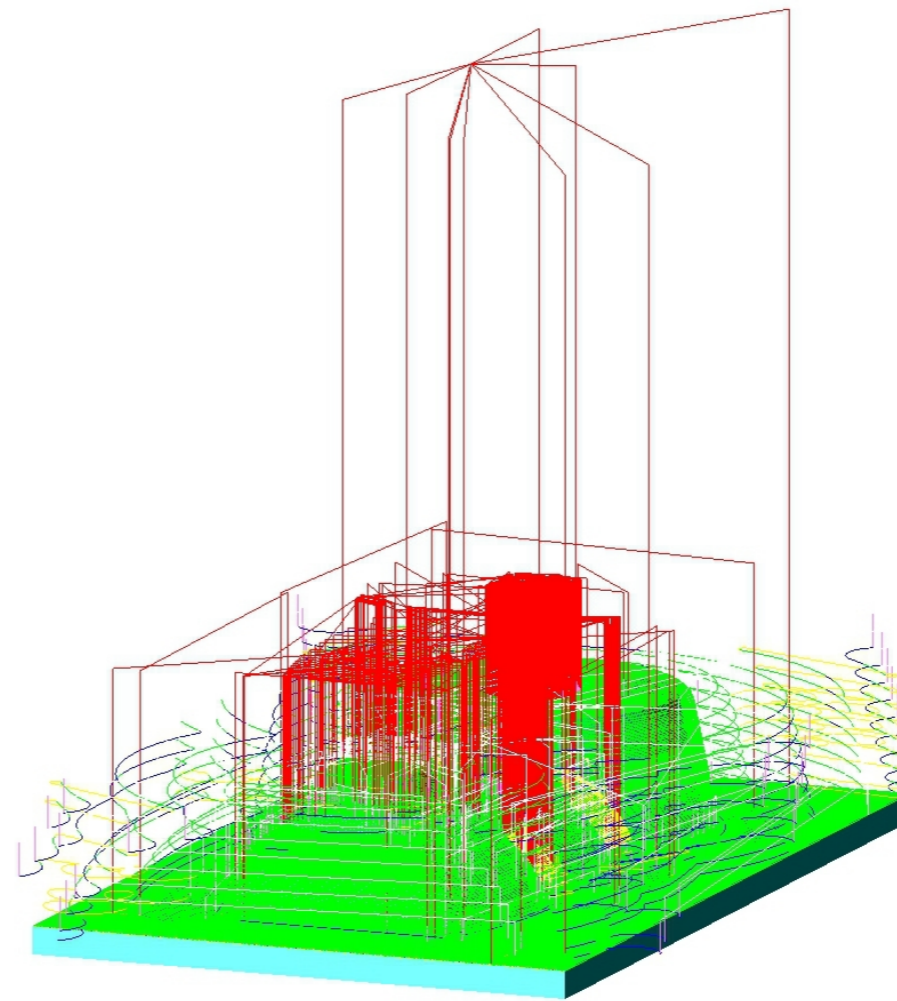
WORK PROCEDURE

AUTHOR	KswadEcp	
DATE	2013/5/28 14:40	
WORK RANGE	MIN	MAX
X	-100.449958	100.449958
Y	-70.449958	70.387498
Z	-0.000103	141.533000
MATERIAL		
MACHINE NAME		
MATERIAL SIZE	X=160.000000 Y=100.000000 Z=30.000000	
ORIGIN	X=0.000000 Y=0.000000 Z=141.533000	
POST NAME	K:\ECP\KswadEcpV18.0\ecp.post\fanuc-6mb.pcf	
TOTAL TIME	7h 50.31m	

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No	Tool Path	Tool No (T)	Tool Type	Diameter	Corner R	Minz	Diameter Comp (D)	Feed Speed	No of Rev (Right)	Pitch	Finish Allowance	Accuracy	Machining Time (min)	Machining Method	O Number	Length of Cut	Clearance Z	Comment
1	KKSWARDr0101.nc	1	BULL	20	5	0.200684	0	1000	4000	10	0.2	0.05	14.91	ROUGH	O0001	17056	141.533	
2	KKSWARDr0102.nc	2	BALL	8	4	0.200684	0	1000	4000	1.6	0.2	0.05	6.96	ROUGH	O0002	7401	141.533	
3	KKSWARDr0103.nc	3	FLAT	5	0	0.200684	0	1000	4000	3.5	0.2	0.05	5.29	ROUGH	O0003	6234	141.533	
4	KKSWADC1.nc	4	BALL	6	3	0.090272	0	500	4000	0	0.05	0.01	76.54	CONTOUR	O0004	42320	141.533	
5	KKSWADC1-F.nc	4	BALL	6	3	0.05	0	500	4000	0.3	0.05	0.01	88.75	CONTOUR	O0004	45366	141.533	
6	KKSWARDr1.nc	4	BALL	6	3	0	0	500	4000	0.3	0	0.01	88.38	SIDE	O0005	45496	141.533	
7	KKSWARDP1.nc	5	BALL	3	1.5	0	0	500	4000	0.3	0	0.01	1.43	PENCIL	O0006	1198	141.533	
8	KKSWARDG1.nc	5	BALL	3	1.5	0	0	500	4000	0.3	0	0.01	161.88	SQUARE(X)	O0007	64354	141.533	
9	KKSWADU1.nc	4	BALL	6	3	-0.000103	0	500	4000	0.5	0	0.01	316	SURFACE	O0008	11335	141.533	
10	KKSWADO1.nc	6	FLAT	2	0	0	0	500	4000	0	0	0.01	15	OUTLINE	O0009	3860	141.533	