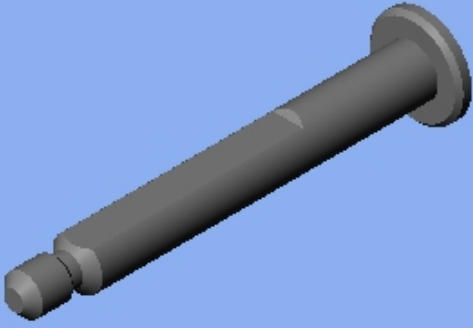


# MACHINING REPORT

Turning report generated by surfsup on 12/15/2009 10:38 AM.

<b>Part Name:</b>	<b>Citizen A20 Metering Screw</b>			
<b>ESPRIT File Path:</b>	C:\VYTAS\ESPRIT\DemoGallery\Turning_Production\Citizen\Citizen A20 Metering Screw.esp			
<b>NC Program Number:</b>	1234.0000	<b>Stock Type:</b>	0	
<b>Name:</b>	METERING SCREW	<b>Diameter:</b>	0.7500	
<b>Unit:</b>	Inch	<b>Length (Part/Total):</b>	3.0950/8.0000	
<b>Overall Cycle Time:</b>	00:01:40	<b>Machine Name:</b>	A20L_VII	
<b>Material Class:</b>				
<b>Condition:</b>				
<b>Comment:</b>				

OP #	OPERATION	SPINDLE# TURRET# HEAD#	STATION# TOOL# ORIENT.	TOOL	SPEED RPM/SPM	FEED UNIT PM/PR (XY/Z)	NC COMP	CYCLE TIME	COMMENT
1	FACE AND TURN OD	1.0000 - 1.0000	S 2.0000 T 2.0000 4V	35DEG	2500.0000 491.0000	5.0000 0.0020	No	00:00:17	-
3	KNURL	1.0000 - 1.0000	S 5.0000 T 5.0000 4V	KNURL	2002.0000 393.0000	4.0040 0.0020	-	00:00:00	-
4	TURN OD	1.0000 - 1.0000	S 2.0000 T 2.0000 4V	35DEG	3000.0000 589.0000	4.5000 0.0015	No	00:00:16	-
29	3/8-32 UNEF	1.0000 - 1.0000	S 3.0000 T 3.0000 4V	THREAD	1004.0000 82.0000	31.3750 0.0313	-	00:00:00	-
5	MILL FLAT	1.0000 - 1.0000	S 7.0000 T 7.0000 X +	.375 CHF END MILL	5256.0000 344.0000	15.0171 15.0171	Off 0.0000	00:00:05	-
7	ENGRAVING	1.0000 - 1.0000	S 8.0000 T 8.0000 X +	ENGRAVER	5011.0000 82.0000	20.0440 20.0440	Off 0.0000	00:00:01	-
8	ENGRAVING	1.0000 - 1.0000	S 8.0000 T 8.0000 X +	ENGRAVER	5000.0000 82.0000	20.0000 20.0000	Off 0.0000	00:00:00	-
9	ENGRAVING	1.0000 - 1.0000	S 8.0000 T 8.0000 X +	ENGRAVER	5000.0000 82.0000	20.0000 20.0000	Off 0.0000	00:00:01	-
10	ENGRAVING	1.0000 - 1.0000	S 8.0000 T 8.0000 X +	ENGRAVER	5000.0000 82.0000	20.0000 20.0000	Off 0.0000	00:00:01	-
11	ENGRAVING	1.0000 - 1.0000	S 8.0000 T 8.0000 X +	ENGRAVER	5000.0000 82.0000	20.0000 20.0000	Off 0.0000	00:00:00	-

12	ENGRAVING	1.0000 - 1.0000	S 8.0000 T 8.0000 X +	ENGRAVER	5000.0000 82.0000	20.0000 20.0000	Off 0.0000	00:00:00	-
13	ENGRAVING	1.0000 - 1.0000	S 8.0000 T 8.0000 X +	ENGRAVER	5000.0000 82.0000	20.0000 20.0000	Off 0.0000	00:00:01	-
14	ENGRAVING	1.0000 - 1.0000	S 8.0000 T 8.0000 X +	ENGRAVER	5000.0000 82.0000	20.0000 20.0000	Off 0.0000	00:00:01	-
15	ENGRAVING	1.0000 - 1.0000	S 8.0000 T 8.0000 X +	ENGRAVER	5000.0000 82.0000	20.0000 20.0000	Off 0.0000	00:00:00	-
25	TURN OD 2	1.0000 - 1.0000	S 2.0000 T 2.0000 4V	35DEG	3000.0000 589.0000	4.5000 0.0015	No	00:00:15	-
28	3/8-32 UNEF 2	1.0000 - 1.0000	S 3.0000 T 3.0000 4V	THREAD	1004.0000 82.0000	31.3750 0.0313	-	00:00:00	-
26	MILL FLAT 2	1.0000 - 1.0000	S 7.0000 T 7.0000 X +	.375 CHF END MILL	5256.0000 344.0000	15.0171 15.0171	Off 0.0000	00:00:05	-
16	ENGRAVING	1.0000 - 1.0000	S 8.0000 T 8.0000 X +	ENGRAVER	5000.0000 82.0000	20.0000 20.0000	Off 0.0000	00:00:00	-
17	ENGRAVING	1.0000 - 1.0000	S 8.0000 T 8.0000 X +	ENGRAVER	5000.0000 82.0000	20.0000 20.0000	Off 0.0000	00:00:00	-
18	ENGRAVING	1.0000 - 1.0000	S 8.0000 T 8.0000 X +	ENGRAVER	5000.0000 82.0000	20.0000 20.0000	Off 0.0000	00:00:00	-
19	ENGRAVING	1.0000 - 1.0000	S 8.0000 T 8.0000 X +	ENGRAVER	5000.0000 82.0000	20.0000 20.0000	Off 0.0000	00:00:01	-
20	ENGRAVING	1.0000 - 1.0000	S 8.0000 T 8.0000 X +	ENGRAVER	5000.0000 82.0000	20.0000 20.0000	Off 0.0000	00:00:00	-
21	ENGRAVING	1.0000 - 1.0000	S 8.0000 T 8.0000 X +	ENGRAVER	5000.0000 82.0000	20.0000 20.0000	Off 0.0000	00:00:01	-
22	ENGRAVING	1.0000 - 1.0000	S 8.0000 T 8.0000 X +	ENGRAVER	5000.0000 82.0000	20.0000 20.0000	Off 0.0000	00:00:00	-
30	TURN OD 3	1.0000 - 1.0000	S 2.0000 T 2.0000 4V	35DEG	3000.0000 589.0000	4.5000 0.0015	No	00:00:17	-
33	CUTOFF	1.0000 - 1.0000	S 1.0000 T 1.0000 3V	.093 CUTOFF	2000.0000 393.0000	4.0000 0.0020	-	00:00:06	-
34	SUB FACE	2.0000 - 2.0000	S 1.0000 T 31.0000 2H	BORING BAR	3000.0000 589.0000	4.5000 0.0015	No	00:00:05	-
35	EJECT	2.0000 - 2.0000	S - T - -	-	0.0000 -	10.0000 -	-	00:00:01	-
32	PICKUP	2.0000 - 2.0000	S - T - -	-	300.0000 -	100.0000 -	-	00:00:02	-