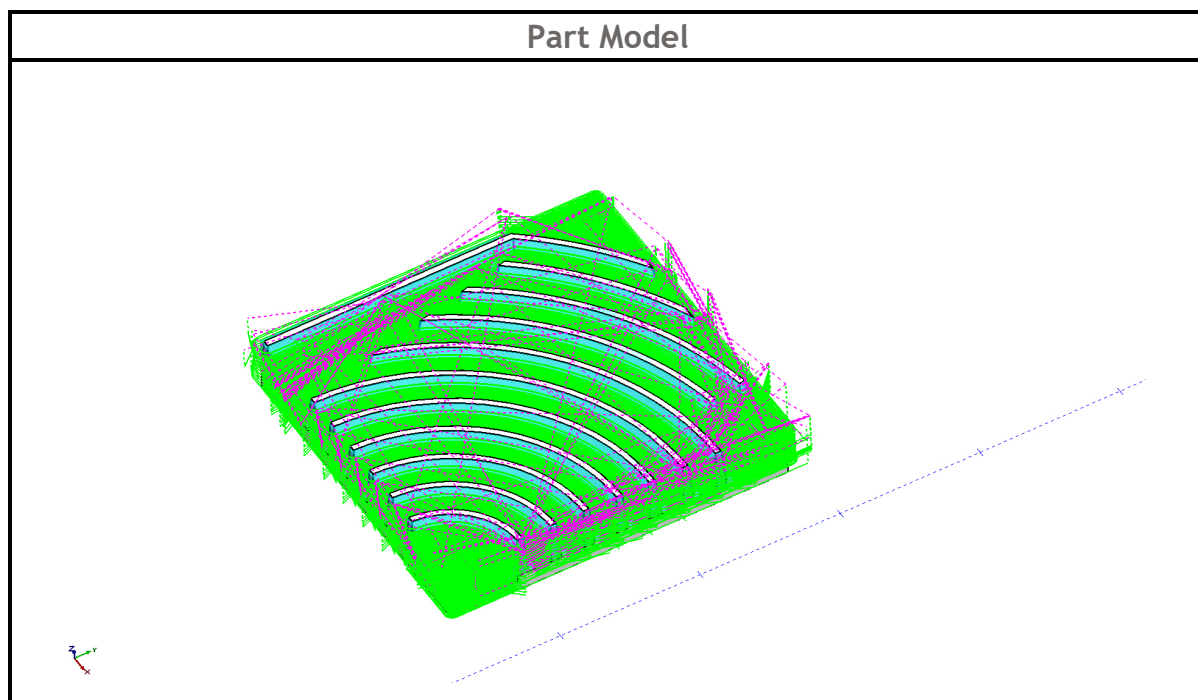




| | |
|-----------------------|--|
| BobCAD File | 2018-002-017 Half Brick custom heatsink v1.01.059.011.bbcd |
| Post Processor | TLR_CNC_Shark_MULTITool_2017-03-10_v1.10.MillPst |
| Machine | CNC Shark HD2 Pro+ |
| Date | Thu. 03/08/2018 05:40:04PM |

| Program Data | | | |
|------------------|--|----------------------|-----------|
| Program Number | 100 | Number of Operations | 4 |
| Unit | Inch | Number of Tools | 4 |
| Cutting Distance | 5596.7625 | Number of Setups | 3 |
| Rapid Distance | 2292.3797 | Total Cycle Time | 3h:1m:44s |
| NC File | X:\BobCAD-CAM Data\BobCAD-CAM Vn\NC\Mill\2018-002-017 Half Brick custom heatsink v1.01.059.011.tap | | |



| Step 1 of 4 | | Center Drill | Cycle Time | 0m:7s |
|--------------------|----------------------------|--|--------------------------------|-------|
| Operation Data | | Tool Data | | |
| Feature Name | Feature Mill Hole - 0.0984 | Tool Name | J: 0.250 90DEG spot drill (#4) | |
| Operation Name | Center Drill | Diameter Offset | 4 | |
| Setup Name | Machine Setup - 3 | Height Offset | 4 | |
| Number of Patterns | 1 | <div>Speeds and Feeds</div> <div>SFM608.6836</div> <div>Spindle Speed9300.0000</div> <div>Cutting Feedrate15.0000</div> <div>Plunge Feedrate9.0000</div> | | |
| Top of Feature | 0.0000 | | | |
| Total Depth | 0.0800 | | | |
| Feed Distance | 0.7200 | | | |
| Rapid Distance | 7.4200 | | | |
| Coolant | Air | | | |

| Step 2 of 4 | | Facing | Cycle Time | 6m:59s |
|-----------------------|--|------------------|------------|--------|
| Operation Data | | Tool Data | | |

| | | | |
|---------------------------|-------------------|-------------------------|--|
| Feature Name | Feature 2 Axis | Tool Name | O: 0.250 RAD EM 2FL 0.75LOC 0.020R (#3) |
| Operation Name | Facing | Diameter Offset | 3 |
| Setup Name | Machine Setup - 2 | Height Offset | 3 |
| Number of Patterns | 1 | | |
| Top of Feature | 0.0000 | Speeds and Feeds | |
| Total Depth | 0.0801 | SFM | 1021.0176 |
| Feed Distance | 198.9972 | Spindle Speed | 15600.0000 |
| Rapid Distance | 197.5057 | Cutting Feedrate | 37.4400 |
| Coolant | Mist | Plunge Feedrate | 9.0000 |

| Step 3 of 4 | | Advanced Rough | | Cycle Time | | 1h:52m:20s | |
|--------------------|--|-------------------|--|------------------|--|--|--|
| Operation Data | | | | Tool Data | | | |
| Feature Name | | Feature 3 Axis | | Tool Name | | H: 0.125 RAD EM 2FL 0.50LOC 0.015R (#1) | |
| Operation Name | | Advanced Rough | | Diameter Offset | | 1 | |
| Setup Name | | Machine Setup - 1 | | Height Offset | | 1 | |
| Number of Patterns | | 1 | | | | | |
| Top of Feature | | 0.0000 | | Speeds and Feeds | | | |
| Total Depth | | 0.0000 | | SFM | | 785.3982 | |
| Feed Distance | | 3251.3230 | | Spindle Speed | | 24000.0000 | |
| Rapid Distance | | 569.4100 | | Cutting Feedrate | | 35.0000 | |
| Coolant | | Mist | | Plunge Feedrate | | 9.0000 | |

| | | | | | |
|--------------------|-------------------------|-------------------------|------------------|------------------------------|-----------|
| Step 4 of 4 | | Advanced Z Level Finish | | Cycle Time | 1h:2m:18s |
| Operation Data | | | Tool Data | | |
| Feature Name | Feature 3 Axis | | Tool Name | Z: 0.125D BALL 0.25 LOC (#2) | |
| Operation Name | Advanced Z Level Finish | | Diameter Offset | 2 | |
| Setup Name | Machine Setup - 1 | | Height Offset | 2 | |
| Number of Patterns | 1 | | | | |
| Top of Feature | 0.0000 | | Speeds and Feeds | | |
| Total Depth | 0.0000 | | SFM | 785.3982 | |
| Feed Distance | 2145.7224 | | Spindle Speed | 24000.0000 | |
| Rapid Distance | 1518.0440 | | Cutting Feedrate | 60.0000 | |
| Coolant | Air | | Plunge Feedrate | 10.0000 | |

| | | | |
|--|--------------------|------------------------|--------|
| H: 0.125 RAD EM 2FL 0.50LOC 0.015R (#1) | | | |
| Tool Type | ENDMILL ROUGH | Diameter | 0.1250 |
| Tool Material | CARBIDE | Corner Radius | 0.0150 |
| Number of Flutes | 2 | | |
| Tool Holder | MuscleChuck Insert | Flute Length | 0.5000 |
| | | Tool Protrusion | 0.7500 |

| | | | |
|-------------------------------------|--------------------|----------------------|--------|
| Z: 0.125D BALL 0.25 LOC (#2) | | | |
| Tool Type | ENDMILL ROUGH | Diameter | 0.1250 |
| Tool Material | CARBIDE | Corner Radius | 0.0625 |
| Number of Flutes | 2 | | |
| Tool Holder | MuscleChuck Insert | Flute Length | 0.5000 |

| | | | |
|--|--------------------|-----------------|---------|
| | | Tool Protrusion | 0.7500 |
| O: 0.250 RAD EM 2FL 0.75LOC 0.020R (#3) | | | |
| Tool Type | ENDMILL ROUGH | Diameter | 0.2500 |
| Tool Material | CARBIDE | Corner Radius | 0.0200 |
| Number of Flutes | 2 | | |
| Tool Holder | MuscleChuck Insert | Flute Length | 0.7500 |
| | | Tool Protrusion | 2.0000 |
| J: 0.250 90DEG spot drill (#4) | | | |
| Tool Type | CENTER DRILL | Diameter | 0.2500 |
| Tool Material | CARBIDE | Tip Angle | 90.0000 |
| Number of Flutes | 2 | Angle | 90.0000 |
| Tool Holder | | Flute Length | 0.0000 |
| | | Tool Protrusion | 0.7500 |