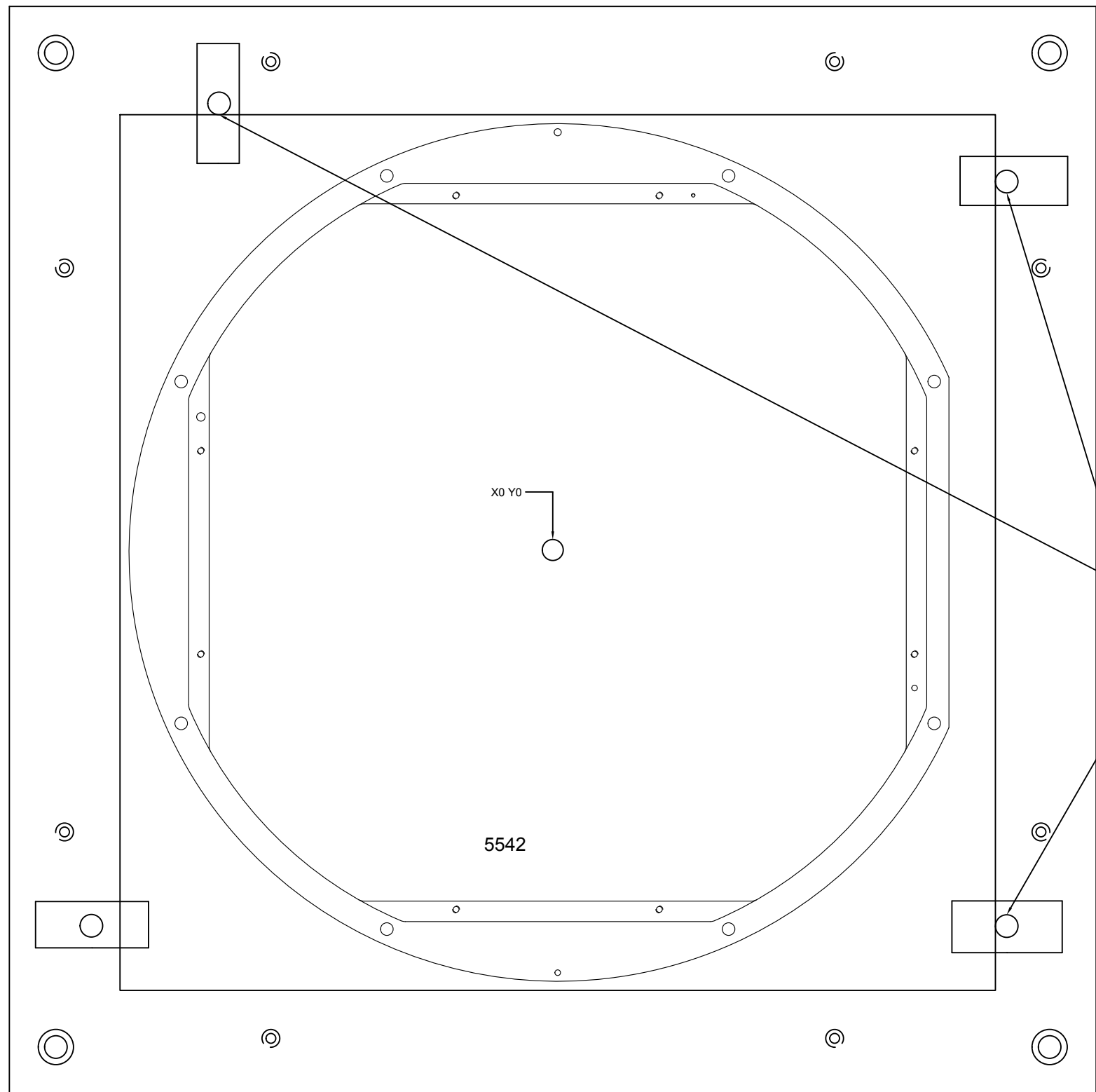


FADAL

WORK CTR 15

CUSTOMER	PART NUMBER	REV. LEVEL	OPER. NO.	PROGRAM NO.	FIXTURE NO.	FIX. LOCATION
EAGLE	HAR5542G	1	1	2434	1330	FB2
CYCLE TIME PER LOAD		XX.X	MATERIAL ALUM. 19.38 X 19.38 X 1/2 THICK			
CYCLE TIME PER PART		XXX	FIXTURE NAME-HAR5540,5541.5542			



	TOOLS	DESCRIPTION
1	3/8 SPOT DRILL	USE CUTTER COMP
2	.1406 DRILL	9/64 drill
3	.1575 reamer	
4	.1870 reamer	
5	.1719 drill	11/64 drill
6	.070 drill	NO. 50 DRILL
7	1/2 SKI CARB ENDMILL	
8	1/4 CARBIDE 3 FLUTE	
9	.1250 REAMER	
10	.1094 DRILL	7/64 DRILL
11	2-56 CUT TAP	
12	.130 drill	3.3mm
13	M4 x .7 CUT TAP	
14	.1245 REAMER	
15	3.0 ISCAR FACEMILL	
16	.281 DRILL	9/32 DRILL
17	ENGRAVING TOOL	
18	1/4 SKI CARB	

SETUP NOTES:

BUMP PLATE AGAINST THESE 3 CLAMP SCREWS.

CENTER OF PLATE IS X0 Y0. CLAMP PLATE DOWN ON 4 PLACES. PROGRAM WILL STOP AFTER TAPPING THE M5 HOLES, PLACE (8) M5 x 45MM LONG BOLTS IN FROM THE BACK BEFORE CONTINUING TO RUN PROGRAM. LAST TOOL IS 3/8 SPOT DRILL, USE TO CHAMFER PART. YOU WILL NEED TO ADD AN OFFSET AMOUNT TO D1 AND D10 TO GET ALL CHAMFERS TO WORK.



HAR5542G REV.1 SETUP OP1.DWG, RICK L. , 8/2/13 , MS-ACTION MACHINING