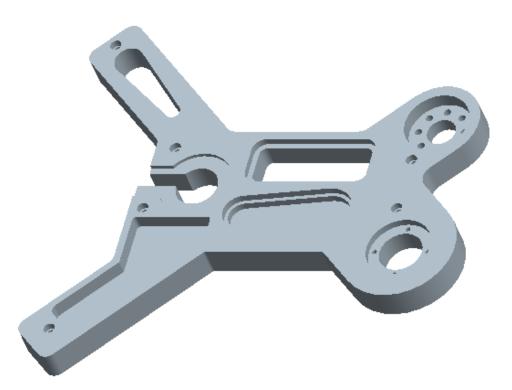


## TRAINING

## GUIDE



## **ADVANCED EXERCISE-1**

camInstructor

## **Advanced Exercise -1 - Instructions**

- The drawing for this part is on the CD accompanying this book. It is called Advance-Exercise-Drawing-1.pdf. It can be printed onto a larger format if necessary.
- 2. The part blank has one face pre-machined to a thickness of 2.1"
- 3. The size of the blank material: Finish size Plus .25" (.125" each side) on width and length Plus 0.1" on thickness.
- 4. Offset material in Job Setup accordingly.
- 5. Material: Aluminium 6061.
- 6. The six hold down holes have been pre drilled and counter bored do not create.
- The part is secured to the fixture with socket head cap screws through the pre drilled holes, with the pre machined face down onto fixture.
- 8. X0 Y0 = your choice.
- 9. Z zero = top of fixture (bottom of part).
- 10. The part is being machined on a vertical spindle machine with a maximum RPM of 5000.
- 11. Ensure you have the appropriate clearance retract, feed planes set.
- 12. Use the appropriate feed rates and spindle speeds for the material and cutters being used.
- 13. Use appropriate tools for rouging and finishing this part.
- 14. When possible use one operation to rough and finish.
- 15. The sequence of machining operations will be decided by the student.
- 16. Face mill the part to thickness in one cut.
- 17. No boring required, all large holes will be milled.
- 18. Please note the arrow pointing down on the drawing denotes depth.

