

Annexure-IV

Sample Report of Operation Summary

Component name: Moving Blade HM4R 500MW

Drawing Number: 1-10102-41004

Machine: CNC 5-AXIS MACHINING CENTRE (Model name/Layout number)

Machine Type :

Operation list

Sl. Nr	Operation Description	Tool Id	Tool offset (D) No.	Tool desc.	Feed [mm/min]	Speed [rpm]	Cutting time	Accum time
1	Roughing rhomboid LE	101	1	Face mill D50 Round insert r6 z5	2101	1401	00:00:54	00:00:54
2	Roughing rhomboid PS	101	1	Face mill D50 Round insert r6 z5	2101	1401	00:00:44	00:01:38
3	Roughing rhomboid TE	101	1	Face mill D50 Round insert r6 z5	2101	1401	00:00:51	00:02:29
4	Roughing rhomboid SS	101	1	Face mill D50 Round insert r6 z5	2101	1401	00:00:44	00:03:13
5	Roughing rooftop PS	101	1	Face mill D50 Round insert r6 z5	2101	1401	00:00:25	00:03:38
6	Roughing rooftop SS1	101	1	Face mill D50 Round insert r6 z5	2101	1401	00:00:26	00:04:04
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12	Finish Root LE	205	2	Finishing Face Mill cutter D80	384	915	00:00:20	00:05:20

				r0.4 z7				
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67	Measuring taper tip ps upper	999	1	Renishaw probe r3	531	531	00:00:07	00:52:01
68	Measuring taper tip ss upper	999	1	Renishaw probe r3	531	531	00:00:08	00:52:09

Cycle Time:

Cutting time:	00:52:09
Tool change time:	00:05:20
Additional probing time:	00:05:30
Part change time:	00:04:00
Machine cleaning time:	00:01:10
Total workpiece cycle time:	01:08:09

Tools Used :

Tool desc.	Tool Id
Face mill D50 Round insert r6 z5	101
Finishing Face Mill cutter D80 r0.4 z7	205
Renishaw probe r3	999
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Indexable Ball nose cutter R8 z3	203
Solid carbide Ball Nose cutter Dia 10,z=4	107
Chamfering tool D10 z4 45deg.	109