

Sheet1

Machine 113/11	Tool Descriptiopn	Position	Unit	Tool
HB32/45-16 Dou	Transfer Bushing	16	6.15.005-1	
	Step Drill	2	VE 30/60	
	Drill	4	VE-40/80	
	Finish Turn	6	EIE-44/80	Rough Turn
	open	8		Rough Turn
	Finish Counter Bore	10	VE-30/60	Recess
	Face Chamfer	12	VE-35/80	Recess
	Tap	14	GWE-30/60	Face
		1	VE-40/80	load
		3	VE-44/80	
			VE-40/80	
		5	VE-44/80	
		7	VE-40/80	tap
		9	Index	Cross Drill
		9v	VE-20/80	
		11	VE-40/80	Recess
		13	VE-35/80	
		15	Transfer	

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	Transfer Bushing	16	6.15.005-1	
	Step Drill	2	VE 30/60	
	Drill	4	VE-40/80	
	Finish Turn	6	EIE-44/80	
	open	8		Face Chamfer
	Finish Counter Bore	10	VE-30/60	
	Face Chamfer	12	VE-35/80	Mill Flats
	Tap	14	GWE-30/60	
	Saw Blade Load/CO	1		
	Chamfer	3	VE-40/80	
	Chamfer OD		VE-40/80	
	Step Drill	5	VE-44/80	
	Face	7	VE-40/80	Recess Turn
	Index 120 deg	9		
		9v	VE-20/80	
		11	Open	Finsih Turn
		13	HDE-45/80	Finsih C bore
		15	Transfer	

Sheet1

Unit	Position	Tool	Unit	Position	Tool	Unit
	16			16		
	2			2		
	4			4		
VE-40/80	6	Turn	VE-44/80	6		
VE-40/80	8	Drill	VE-30/60	8		
EIE-34/60	10	Thread	GWE-30/60	10		
EIE-34/60	12			12	Face	VE-35/60
VE-35/60	14			14		
	1			1		
	3	Komet	VE-40/80	3	Turn	VE-40/80
	5	Komet Swgcr	VE-40/80	5	Drill	VE-44/80
GWE-30/60	7			7		
VE-20/80	9			9		
	9v			9v	Cross Drill	VE-40/80
EIE-45/80	11			11		
	13	Recess Tool	HDE-45/80	13	Recess	HDE-45/80
	15			15		

Unit	Position	Unit	Position
	16		16
	2		2
	4	EIE-44/80	4
	6	VE-40/80	6
VE-30/60	8		8
	10		10
VE-30/60	12		12
	14		14
	1		1
	3		3
	5		5
HDE-40/80	7		7
	9		9
	9v		9v
VE-40/80	11	Finish Turn HDE-45/80	11
VE-35/60	13	Trepan Face VE-35/60	13
	15		15