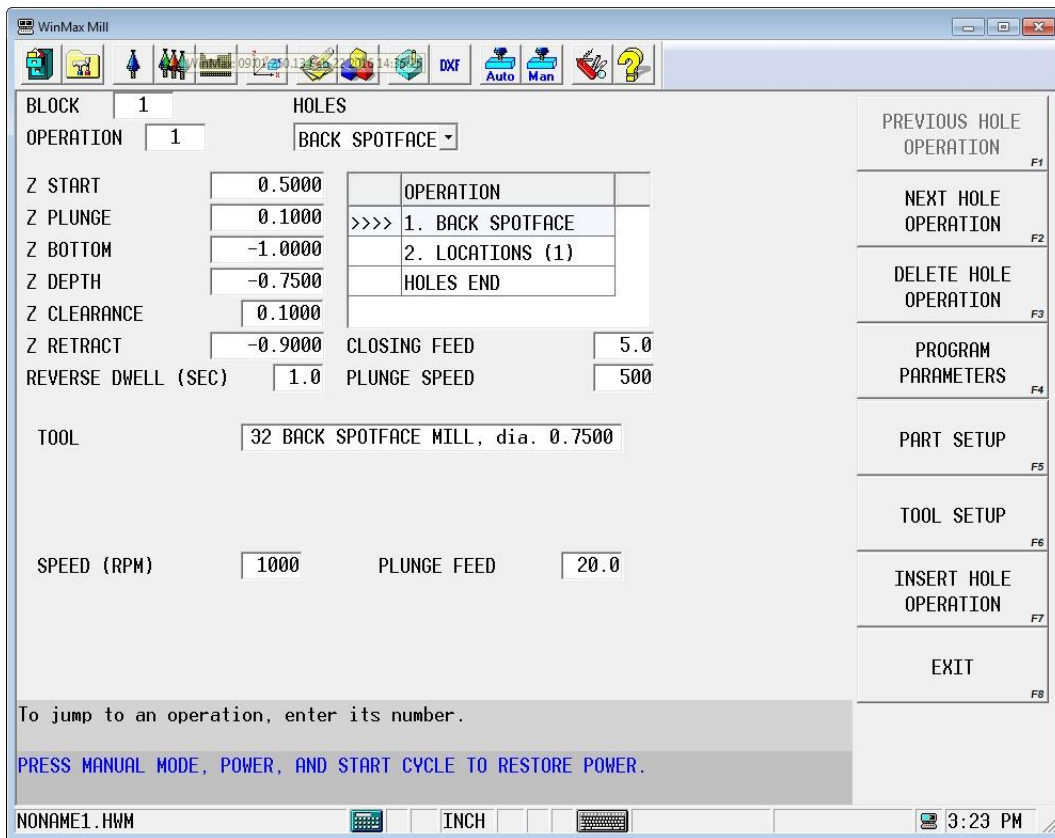


Conversational Back Spot Face Data Block



Z Start- spindle will turn on at plunge feed and will start feeding DOWN at closing feed.

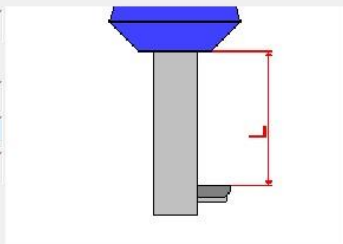
Z Plunge- Once this point is reached, the tool will rapid DOWN to the Z bottom plus the difference between length of cut and tool length in Advance Tool Settings (see images below)

Z Depth- feeds UP to this depth at the plunge feed.

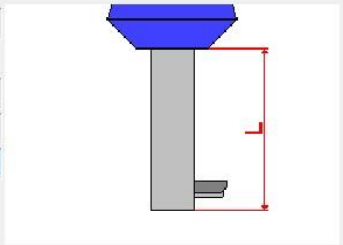
Z-Clearance- Rapids DOWN this amount then reverses spindle

Z- Retract- Feeds DOWN to this position at closing feed, Once this position is hit Z rapids out of the hole.

TOOL TYPE SETUP

GEOMETRY	FEED & SPEED	NC SFQ	SUPPLIER
TOOL TYPE: BACK SPOTFACE MILL			
DIAMETER	0.7500		
SHANK DIAMETER	0.7500		
LENGTH OF CUT	4.0000		
TOOL LENGTH	4.5000		
FLUTES	3		
DIRECTION	CW		
COLOR	 CYAN		

TOOL TYPE SETUP

GEOMETRY	FEED & SPEED	NC SFQ	SUPPLIER
TOOL TYPE: BACK SPOTFACE MILL			
DIAMETER	0.7500		
SHANK DIAMETER	0.7500		
LENGTH OF CUT	4.0000		
TOOL LENGTH	4.5000		
FLUTES	3		
DIRECTION	CW		
COLOR	 CYAN		