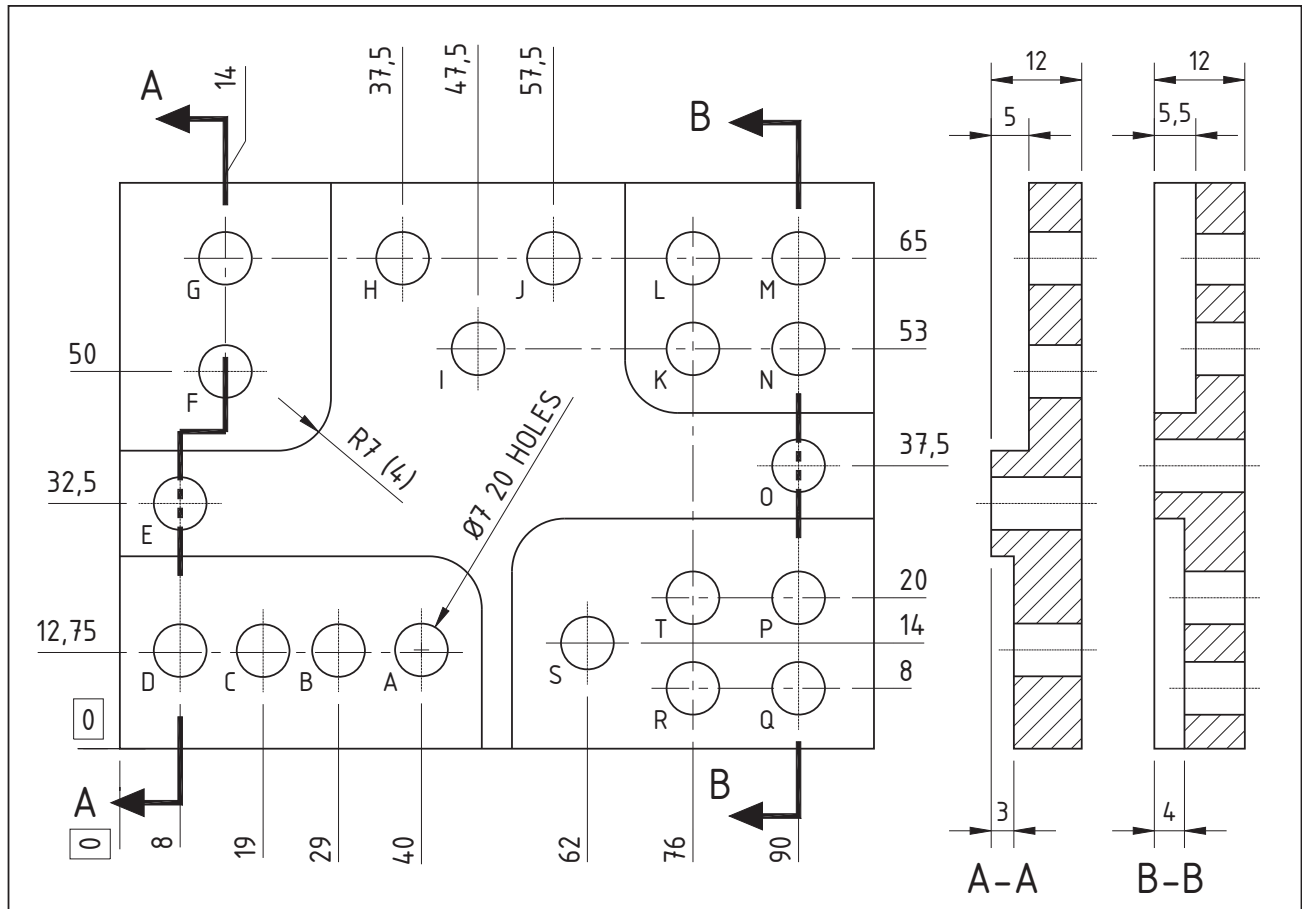


In the project 33-08, the corners have been machined to the variable depths of 3 mm, 4 mm, 5 mm, and 5.5 mm. In this project, the objective is to make a complete program to spot drill and drill the 20 holes, as per drawing. Material is aluminum. This part is similar to another drilling project, 26-11.



☛ To develop the part program, follow these conditions:

1. Use a spot drill to chamfer all holes  $0.3 \times 45^\circ$
2. Use  $\varnothing 7$  mm drill (or  $\varnothing 0.25$  inches) to drill the 20 holes - with 1.5 mm breakthrough clearance
3. Spot drill holes in the order of **A** to **T**, drill the holes in the order of **T** to **A**
4. Start cutting 2 mm above the face for both tools