



In this second of the three exercises, a 1/4 drill will be used to drill to the 1.125 full diameter depth. Material is 1020 steel.

Apply the following requirements, then answer the five questions below:

- ☐ Start peck drilling cycle at X0.75 Y0.5 Z0.1
- ☐ Calculate the drill point length
- ☐ Calculate the final Z-depth
- ☐ FOUR pecks per hole required
- ☐ Calculate the peck depth amount Q

➡ Answer these questions:

1. What is the drill point length? _____
2. What is the final Z-depth? _____
3. Specify the selected Q-value for each peck _____
4. With the four pecks, what is the last peck depth ? _____
5. Write the fixed cycle block required to peck the hole:
