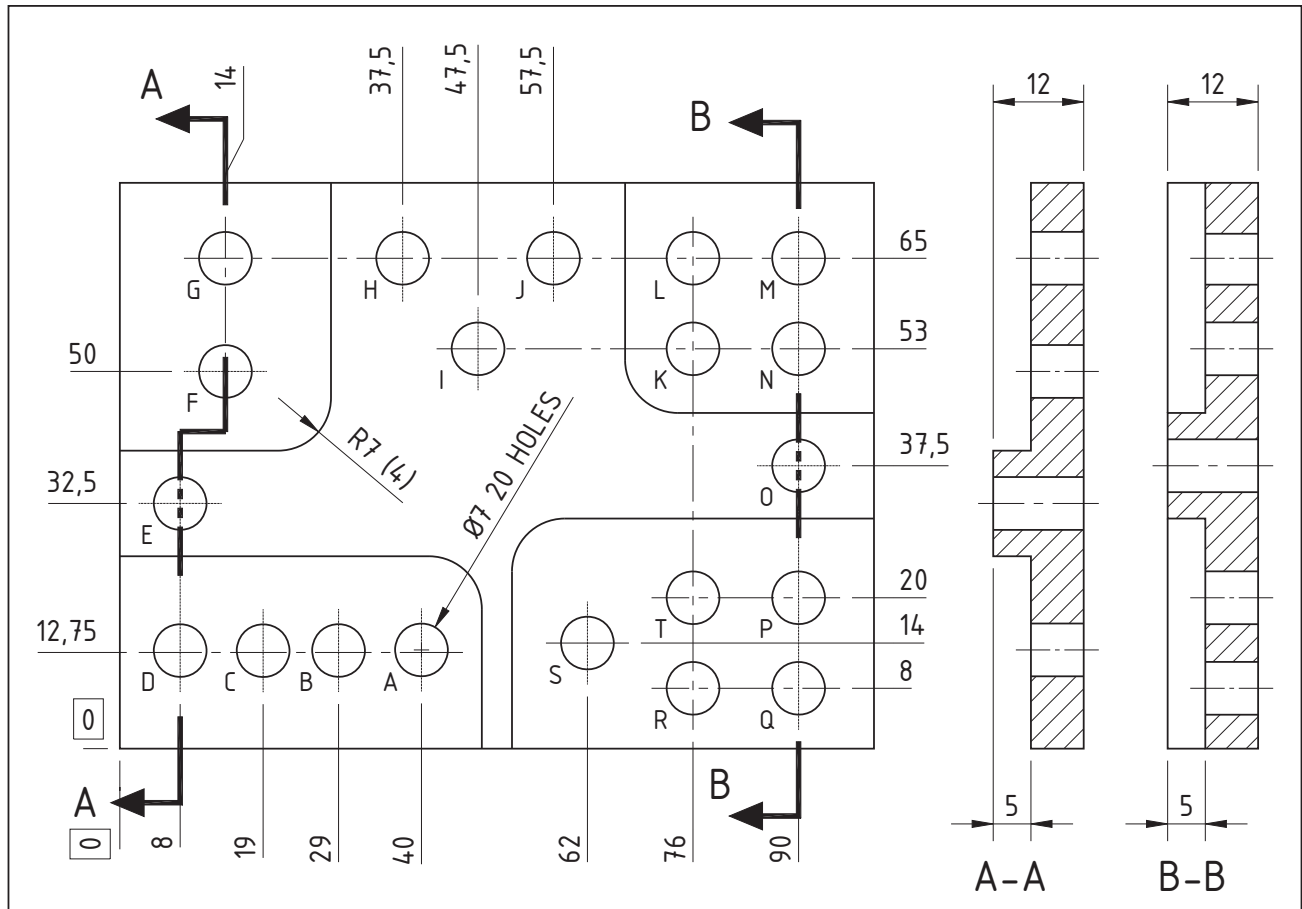


Corner Holes - Same Depth

In the project 33-07, the corners have been machined to the same depth of 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, 26-12.



➡ 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