



This first of three related peck drilling exercises will use a 5/16 drill through a material (1020 steel) that is 1.50 thick.

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

- ☐ Start peck drilling cycle at X0.75 Y0.5 Z0.1
- ☐ Calculate the drill point length
- ☐ Use 0.05 breakthrough amount for drill diameter
- ☐ Calculate the final Z-depth
- ☐ Select a reasonable peck depth Q for 1020 mild steel
- ☐ Calculate the number of pecks for one hole

➡ 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 selected Q-value, how many pecks will be done at each hole location? _____
5. Write the fixed cycle block required to peck the hole:
