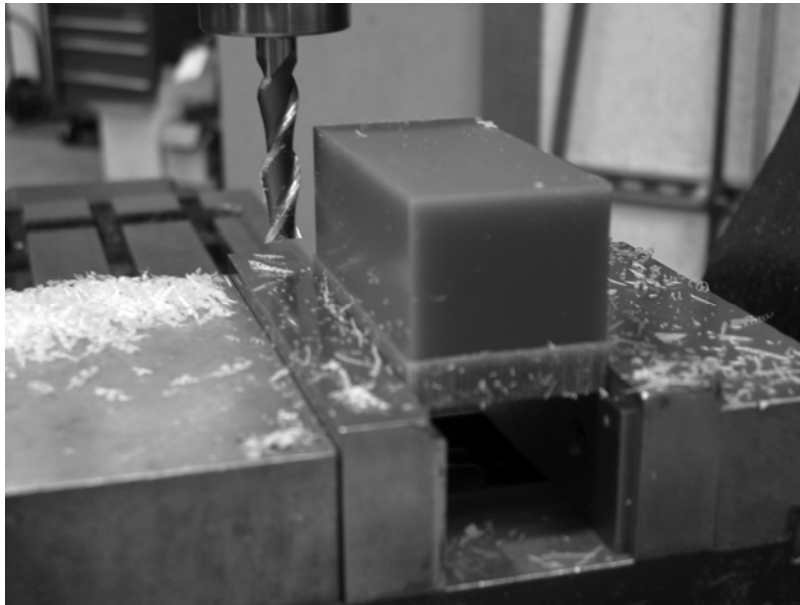
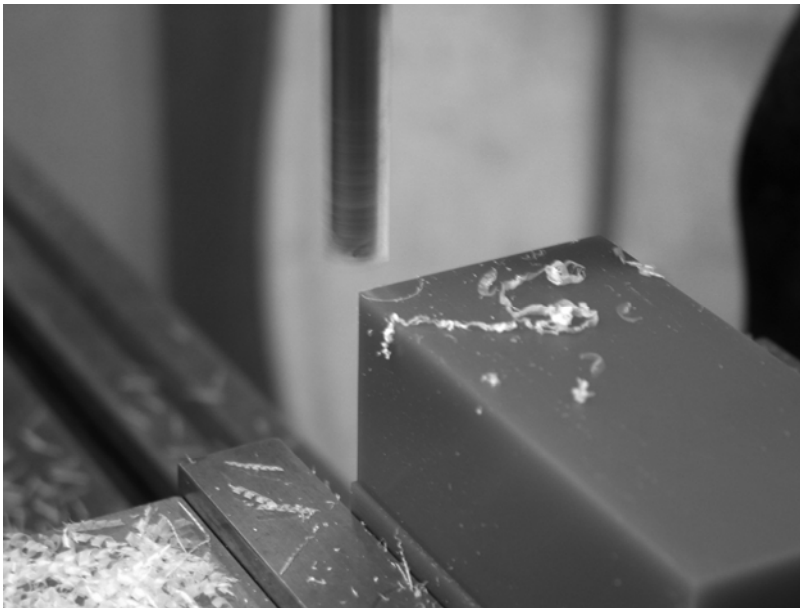


Business Card Holder Machining Procedure

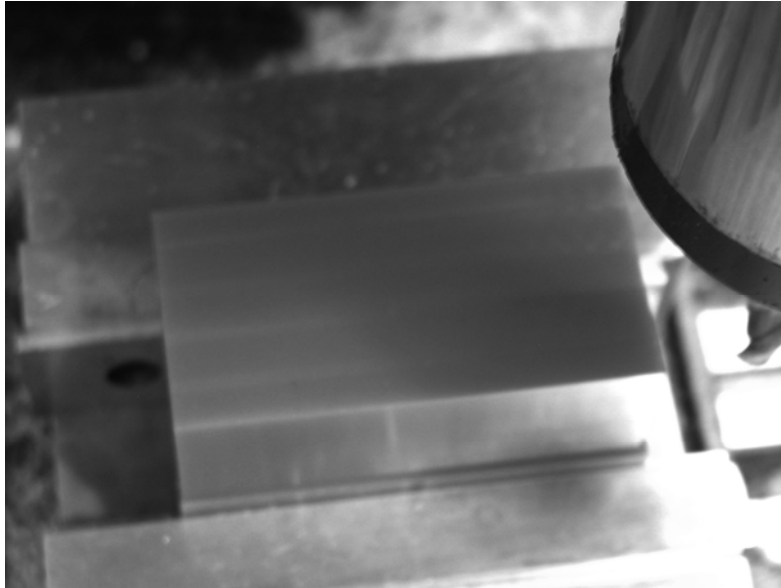
1. Place the work in the vice. Lower the cutter to approximately 1.6 inch from the top. Take a shallow cut to establish the X axis datum (zero the dial or the digital display); then take another shallow cut to establish the Y axis datum (zero the dial or the digital display).
2. Cut the width of the work to 4 inches (remember to compensate for the diameter of the cutter). Then cut the width thickness to 2 inches. The product should then look like the picture below.



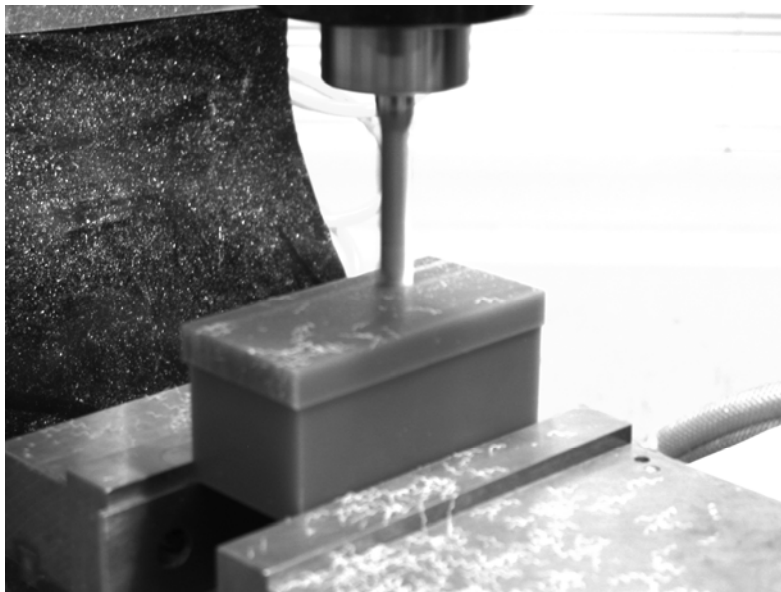
3. Lower the table. Then move the cutter to be above the work. Raise the table to take a slight cut on the top to establish the zero for the Z axis. See the picture below.



4. Face the top of the work by about 0.005 inch.

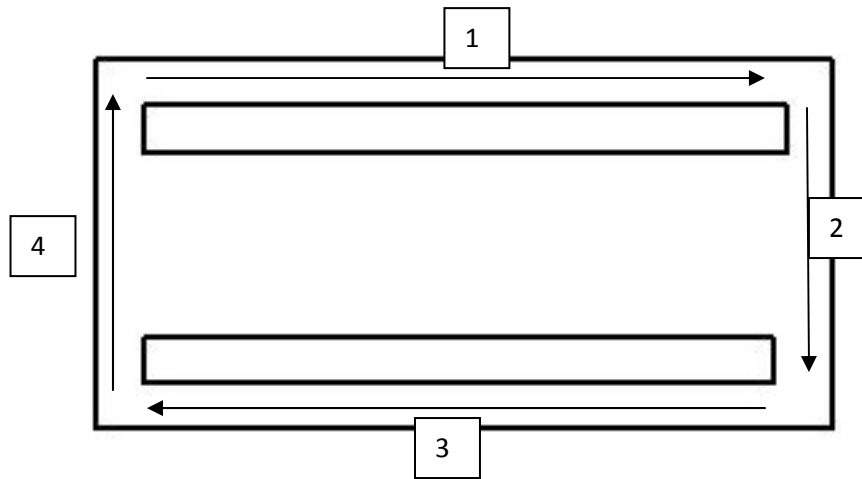


5. Turn the work over. Lock it in the vice. Check the Z axis height by moving the cutter over the top without changing the height of the table. Re-establish the Z-axis zero if necessary.

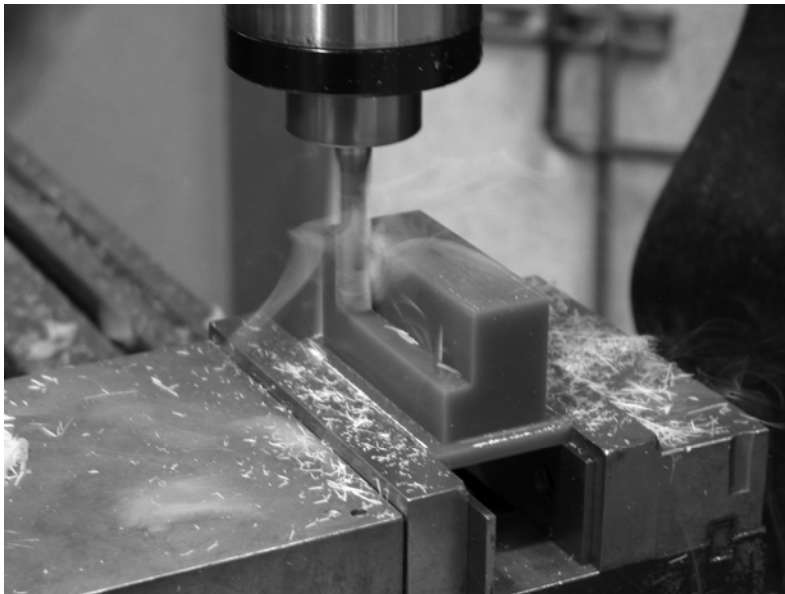


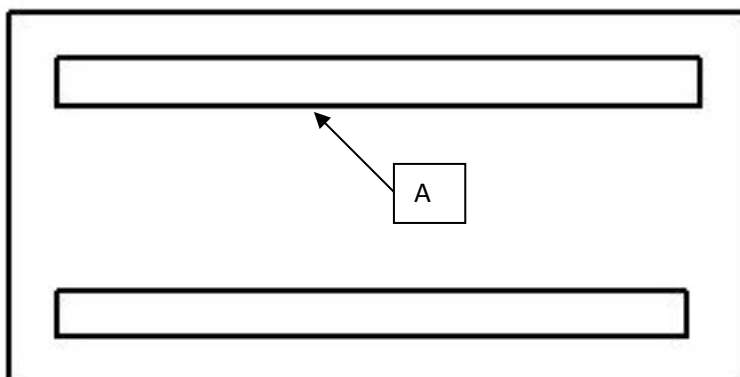
6. Measure the height of the work to establish the amount to face. Then cut the height of the work to 2.0 inches.
7. Lower the table, move the cutter to the face where the X axis datum was established earlier. Raise the table a little and take a cut on that face to re-establish the 0 for X-axis. Do the same for Y-axis datum.

8. Raise the table by 1.75 inch and cut pass 1, then pass2 and so on till all 4 passes are made as shown in the figure below. Depth of cut of each pass is 0.25 inch.



9. Lower the table by 1.0 inch to cut the work to the work to surface A shown below, making sure that tall leg's thickness is 0.25 inch.





10. Raise the table (back to 1.75 inch from the top) to finish cutting the work as shown.

