

Block	Tool / mm	Tool / Inch	tolerance / mm	Tolerance / Inch	step / mm	Step / Inch	rpm	Cut Direction	feed	Special Notes
1	6.350	0.250	0.01	0.0004	0.8	0.031	7000	Y	1250	no pre pencil
2	6.350	0.250	0.01	0.0004	0.25	0.010	7000	Y	1250	no pre pencil
3	6.350	0.250	0.01	0.0004	0.16	0.006	7000	Y	1250	with pre pencil
4	6.350	0.250	0.12	0.0047	0.16	0.006	7000	Y	1250	with pre pencil
5	6.350	0.250	0.001	0.0000	0.16	0.006	7000	Y	1250	pre / post pencil
6	6.350	0.250	0.01	0.0004	0.16	0.006	7000	X	1250	pre / post pencil
7	6.350	0.250	0.01	0.0004	0.16	0.006	7000	Scallop	1250	with pre pencil
8	6.350	0.250	0.01	0.0004	0.15	0.006	7000	Z finish	1250	with pre pencil
9	9.525	0.375	0.01	0.0004	0.15	0.006	7000	Y	1250	with pre pencil
10	8.000	0.315	0.01	0.0004	0.15	0.006	7000	y	1250	semi with 6.35
11	3.175	0.125	0.005	0.0002	0.1	0.004	8000	y	600	Semi with 6.35
12	8.000	0.315	0.002	0.0001	0.1	0.004	7000	mix		pencil and slope
13	6.350	0.250	0.003	0.0001	0.1	0.004	7000	mix	800	Pencil and slope
15	6.350	0.250	0.003	0.0001	0.1	0.004	7000	mix	600	With dremel buffer

