

**MACHINING REPORT**  
Milling report generated by AnnM on 7/1/2011 1:05 PM.

**Part Name:** Milling Example

**ESPRIT File Path:** C:\Users\annmi\E2011\Documents\... \ReportGeneratorFiles\Milling Example.esp

**NC Program Number:** 1.000  
**Name:** Index Milling  
**Unit:** Metric

**Overall Cycle Time:** 00:12:49

**Material Class:** -  
**Condition:** -

**Comment:** -

OP #	OPERATION	TOOL#	TOOL	SPEED RPM/SPM	FEED (XY/Z)	WORK COORD. ANGLES	NC COMP TIME	CYCLE TIME	COMMENT
31	CONTOUR - BACK FACE	1.000	50mm FM	802.000 128.000	384.980 256.840	G54 (90.000,90.000)	0.000	00:05:25	-
32	CONTOUR - BACK ANGLE	1.000	50mm FM						
33	FACE CORNER	1.000	50mm FM						
37	CORNER POCKET RGH AND FIN	2.000	8mm EM						
38	BACK POCKET RGH AND FIN	2.000	8mm EM						

**TOOL LIST**

**T 1.000 - 50mm FM**  
Comment: tool comment for 50 mm face mill  
Tool Diameter: 50.000  
Holder Diameter: 45.000  
Overall Length: 140.000  
Tool Length: 50.000  
Shank Diameter: 40.000  
Cutting Length: 1.500  
Number Of Inserts: 4.000  
Tool Material: Carbide, Indexable, Coated  
Coolant: Flood  
Spindle Direction: CW  
Length Comp Register: 1.000  
Axis Orientation: Z -

**T 2.000 - 8mm EM**  
Comment: tool comment for 8 mm end mill  
Tool Diameter: 8.000  
Holder Diameter: 33.000  
Overall Length: 140.000  
Tool Length: 74.000  
Shank Diameter: 8.000  
Cutting Length: 10.000  
Number Of Flutes: 2.000  
Tool Material: High Speed Steel, Solid, Uncoated  
Coolant: On Through Spindle  
Spindle Direction: CW  
Length Comp Register: 2.000  
Axis Orientation: Z +

**T 3.000 - 6mm EM**  
Comment: tool comment for 6 mm end mill  
Tool Diameter: 6.000  
Holder Diameter: 25.000  
Overall Length: 80.000  
Tool Length: 40.000  
Tool Material: High Speed Steel, Solid, Uncoated  
Coolant: Off  
Spindle Direction: CW  
Length Comp Register: 3.000  
Axis Orientation: Z +

**OPERATION DETAILS**

**OP 36 : BACK POCKET RGH AND FIN SMM**  
Op Type: -  
Work Coordinate: G54  
Primary Angle: 90.000  
Secondary Angle: 90.000  
Cycle Time: 00:01:10  
Rapid length: 797.200  
Feed Length: 1273.965

**T 2.000 - 8mm EM**  
Tool Style: End Mill  
Orientation: Z -  
Tool Material: High Speed Steel, Solid, Uncoated  
Spindle Direction: CW  
Coolant: On Through Spindle  
Length Comp Register: 2.000

## ESPRIT Report Generator

A machining report is an effective way to increase efficiency and reduce errors on the shop floor with little cost involved.

Machining reports clearly communicate to the shop floor the processes, cutting tools, workpiece data and machine set-up required to produce parts.

The ESPRIT Report Generator automatically generates HTML and PDF reports that include easy-to-read lists of all operations and cutting tools in an ESPRIT document.

The Report Generator option in ESPRIT comes with a set of standard report templates that can be fully customized by the user.

### 5 Preformatted Standard Reports

Standard and detailed reports are available that provide the machining details an operator needs to correctly set up a machine and perform the required machining operations.

5 different formats are available:

- EDM report: Outputs the operation list of all wire EDM operations
- Milling\_Detailed and Turning\_Detailed: Outputs the operation list, tool list, and details on individual operations and tools
- Milling\_Summary and Turning\_Summary: Outputs the operation list only

### Report Options

A full set of report options lets the user choose whether to create HTML reports, PDF reports, or both. The user can also control the folders where reports and templates are stored.

### Graphical Details

When generating the report, ESPRIT takes pictures of the part, the simulation at each stage of the machining process, the tools and, optionally, tool holders. These pictures can then be used anywhere in the report for an easy graphical reference.

### Customized Reports

For manufacturing environments that need more complex, detailed, or differently formatted reports, ESPRIT makes it easy to create your own custom reports.

Report templates are in HTML format, which can be edited in any commonly available text editor or web design software.

The user can control exactly how much or how little machining data is included in each report through an extensive list of ESPRIT keywords and data pulled directly from the operations and cutting tools in the ESPRIT document.

The user can also control the layout and formatting of the report and add custom images such as the company logo.

A 21-page guide to report customizations is available on ESPRITWeb ([www.dpotechnology.com/ew/](http://www.dpotechnology.com/ew/)), the central on-line point for the ESPRIT community. To learn more, download bulletin #4155 "[Customizing the ESPRIT Report Generator](#)" (an ESPRITWeb login is required).

*A custom report can be as simple as listing details about the stock material and the cutting tools*

#### Stock and Tool Report - Milling Example

Date: 7/1/2011 3:38 PM.

Stock Details	
Stock:	Stock: Block Dimensions: 120L x 75W x 80H Touch-Off: -60, -37.5, 0
Material Class:	ALLOY STEELS, CAST - Low Carbon 150-200 HB - ANNEALED, NORMALIZED OR NORMALIZED Condition: AND TEMPERED
NC Program Number:	1.000 Index Mill
Machine:	Metric
Unit:	

Tool Details				
OP #	OPERATION	Tool #	Tool Name	Tool
31	CONTOUR - BACK FACE	1.000	50mm FM	
32	CONTOUR - BACK ANGLE	1.000	50mm FM	
		1.000	50mm FM	
	RGH AND FIN	2.000	8mm EM	
	H AND FIN 6MM	2.000	8mm EM	

*Create as many custom reports as you need and include as much detail as you like*

#### Turning Report - Generic Lathe

Date: 7/1/2011 4:09 PM.

<b>Part Name: Turning Example</b>					
NC Program Number:	1234.0000			Stock Type:	0
Name:	CLASS PART			Diameter:	2.0000
Unit:	Inch			Length(Part/Total):	1.9626/6.0000
Overall Cycle Time:	00:00:59	Machine Name:	Generic Lathe		
Material Class:	ALUMINUM ALLOYS, WROUGHT - 30-80 HB 500kg - COLD DRAWN				
Condition:					

ORDER	OPERATION(OP#)	SPINDLES TURRETS HEAD#	STATIONS TOOL# ORIENT.	TOOL	SPEED RPM/SPM	FEED UNIT PM/PR (XY:Z)	NC COMP	CYCLE TIME	Stock
1	FRONT FACE ROUGH(OP 11)	1.0000 - 1.0000	S 1.0000 T 1.0000 3V	55DEG TURN	2500.0000 1309.0000	25.0000 0.0100	No	00:00:03	
2	OD ROUGH(OP 2)	1.0000 - 1.0000	S 1.0000 T 1.0000 3V	55DEG TURN	2500.0000 1309.0000	25.0000 0.0100	No	00:00:12	
3	ID DRILL(OP 10)	1.0000 - 1.0000	S 3.0000 T 3.0000 -	1IN DRILL	0.0000 0.0000	0.0000 0.0000	-	00:00:03	



DP Technology Corp.  
1150 Avenida Acaso  
Camarillo, CA  
93012 USA  
Tel: + 1 800 627 8479  
Outside the US: + 1 805 388 6000  
Email: [esprit@dpotechnology.com](mailto:esprit@dpotechnology.com)

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