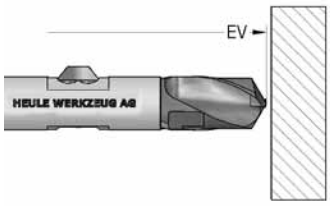
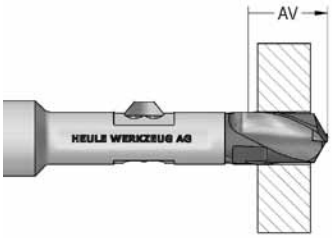
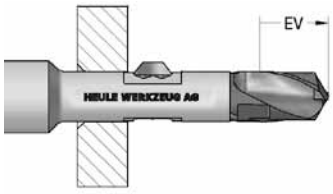
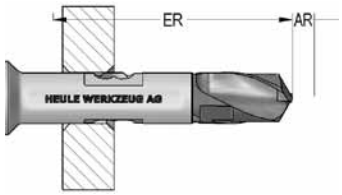
VEX-S Programming Sequence

It is not necessary to change the direction of rotation or stop the spindle

AV: Working feed, forward **AR:** Working feed, backward

EV: Rapid feed, forward **ER:** Rapid feed, backward

	**Step 1:** Rapid Feed the tool to within clearance of the workpiece.
	**Step 2:** With forward Working Feed (WF), feed the tool through the workpiece until the hole is drilled and the drill tip is clear of the bore.
	Step 3: Rapid feed the tool so the SNAP blade is within clearance of the workpiece top surface or burr.
	Step 4: With working feed, cut the top chamfer.Continue feeding until the SNAP blade is completely retracted into the tool body.
	**Step 5:** Use rapid feed to position the SNAP blade on the far side of the part. Position the tool so the SNAP blade is completely extended and clear of the part or burr.
	**Step 6:** With back working feed, cut the back chamfer. When the SNAP blade is completely within the tool and clear of the back surface, the tool can be extracted with rapid feed.