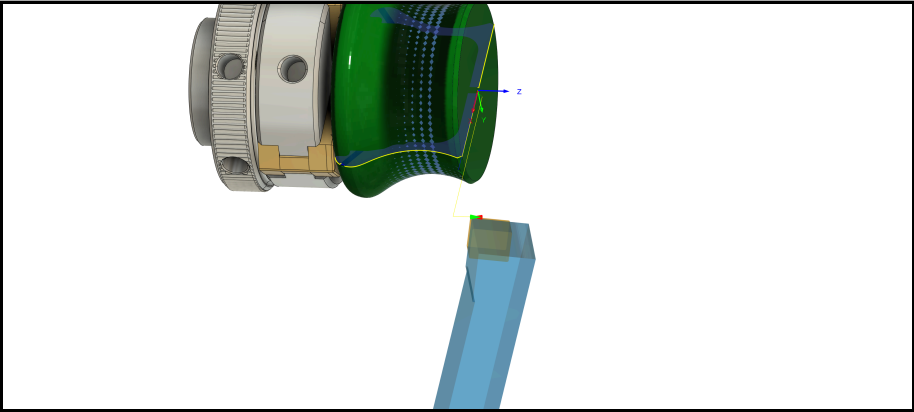# Setup Sheet for Program 1001

JOB DESCRIPTION: Setup2

DOCUMENT PATH: MakeSense Case - Job Setup v5

Setup

WCS: #0

STOCK:
 DX: 51.99mm
 DY: 51.99mm
 DZ: 30.36mm

PART:
 DX: 51.99mm
 DY: 51.99mm
 DZ: 30.06mm

STOCK LOWER IN WCS #0:
 X: -26mm
 Y: -26mm
 Z: -30.06mm

STOCK UPPER IN WCS #0:
 X: 26mm
 Y: 26mm
 Z: 0.3mm

Total

NUMBER OF OPERATIONS: 1
NUMBER OF TOOLS: 1
TOOLS: **T1**
MAXIMUM Z: 5.6mm
MINIMUM Z: 0mm
MAXIMUM FEEDRATE: 60mm/min
MAXIMUM SPINDLE SPEED: 5000rpm
CUTTING DISTANCE: 32.98mm
RAPID DISTANCE: 57.35mm
ESTIMATED CYCLE TIME: 49s

Tools

T1 D1

TYPE: general turning	TOOL ORIENTATION IN TURRET: Radial
INSERT: ISO C 80deg	MINIMUM Z: 0mm
EDGE LENGTH: 9.67mm	MAXIMUM FEED: 60mm/min
NOSE RADIUS: 0.4mm	MAXIMUM SPINDLE SPEED: 5000rpm
CROSS SECTION: T	CUTTING DISTANCE: 32.98mm
TOLERANCE: M	RAPID DISTANCE: 57.35mm
RELIEF: B 5deg	ESTIMATED CYCLE TIME: 34s
COMPENSATION: Tip tangent	
DESCRIPTION: SCLR121H09	
COMMENT: SCLCR121H09	
PRODUCT: JEL-CC09	

HOLDER: ISO L Right

Operations

Operation 1/1

DESCRIPTION: Face1	MAXIMUM Z: 5.6mm	**T1** D1
STRATEGY: Turning Face	MINIMUM Z: 0mm	TYPE: general turning
WCS: #0	MAXIMUM SPINDLE SPEED: 600rpm	INSERT: ISO C 80deg
TOLERANCE: 0.01mm	FEEDRATE PER REV: 0.1mm	EDGE LENGTH: 9.67mm
	CUTTING DISTANCE: 32.98mm	NOSE RADIUS: 0.4mm
	RAPID DISTANCE: 57.35mm	CROSS SECTION: T
	ESTIMATED CYCLE TIME: 34s	TOLERANCE: M
	COOLANT: Off	RELIEF: B 5deg
		COMPENSATION: Tip tangent
		DESCRIPTION: SCLR121H09
		COMMENT: SCLCR121H09
		PRODUCT: JEL-CC09