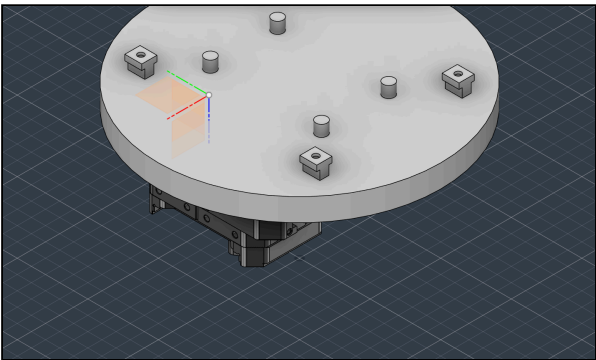







Setup Sheet for Program 1001

JOB DESCRIPTION: Setup1
DOCUMENT PATH: FINITO v1

Setup	
<p>WCS: #1</p> <p>STOCK:</p> <p>DX: 160mm</p> <p>DY: 320mm</p> <p>DZ: 35mm</p> <p>PART:</p> <p>DX: 150mm</p> <p>DY: 309.87mm</p> <p>DZ: 25mm</p> <p>STOCK LOWER IN WCS #1:</p> <p>X: -160mm</p> <p>Y: 0mm</p> <p>Z: -35mm</p> <p>STOCK UPPER IN WCS #1:</p> <p>X: 0mm</p> <p>Y: 320mm</p> <p>Z: 0mm</p>	

Total
<p>NUMBER OF OPERATIONS: 15</p> <p>NUMBER OF TOOLS: 11</p> <p>TOOLS: T1 T2 T3 T4 T5 T10 T11 T12 T13 T14 T17</p> <p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -17.5mm</p> <p>MAXIMUM FEEDRATE: 2270mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8000rpm</p> <p>CUTTING DISTANCE: 22751.04mm</p> <p>RAPID DISTANCE: 10617.6mm</p> <p>ESTIMATED CYCLE TIME: 31m:8s</p>

Tools		
<p>T1 D1 L1</p> <p>TYPE: face mill</p> <p>DIAMETER: 38.1mm</p> <p>CORNER RADIUS: 1.6mm</p> <p>LENGTH: 76.2mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: 1_ Fresa per sfacciatura sgrossatura</p> <p>VENDOR: sandvik</p> <p>PRODUCT: A490-038C5-08H con inserto 490R-08T316M-PH 4330</p>	<p>MINIMUM Z: -4.6mm</p> <p>MAXIMUM FEED: 2214mm/min</p> <p>MAXIMUM SPINDLE SPEED: 2160rpm</p> <p>CUTTING DISTANCE: 1865.63mm</p> <p>RAPID DISTANCE: 183.94mm</p> <p>ESTIMATED CYCLE TIME: 55s (2.9%)</p>	
<p>T2 D2 L2</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 6mm</p> <p>LENGTH: 57mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: finitura_contorno</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 2N342-0600-PC 1730</p>	<p>MINIMUM Z: -17.5mm</p> <p>MAXIMUM FEED: 1074mm/min</p> <p>MAXIMUM SPINDLE SPEED: 7160rpm</p> <p>CUTTING DISTANCE: 961.08mm</p> <p>RAPID DISTANCE: 231.19mm</p> <p>ESTIMATED CYCLE TIME: 1m:2s (3.3%)</p>	
<p>T3 D3 L3</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 38.1mm</p> <p>LENGTH: 85.34mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: contornatura_sgrossatura</p> <p>VENDOR: sandvik</p> <p>PRODUCT: RA390-038M32-17H con inserto R390-17_04 08M-PM 4330</p>	<p>MINIMUM Z: -17.5mm</p> <p>MAXIMUM FEED: 1360.72mm/min</p> <p>MAXIMUM SPINDLE SPEED: 2330rpm</p> <p>CUTTING DISTANCE: 3060.66mm</p> <p>RAPID DISTANCE: 1766.41mm</p> <p>ESTIMATED CYCLE TIME: 2m:37s (8.4%)</p>	
<p>T4 D4 L4</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 0.2mm</p> <p>LENGTH: 45mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Sgrossatura tasche 1</p> <p>PRODUCT: 1K325-0800-XB 1730</p>	<p>MINIMUM Z: -15.8mm</p> <p>MAXIMUM FEED: 2170mm/min</p> <p>MAXIMUM SPINDLE SPEED: 2170rpm</p> <p>CUTTING DISTANCE: 3992.66mm</p> <p>RAPID DISTANCE: 1712.62mm</p> <p>ESTIMATED CYCLE TIME: 3m:44s (12%)</p>	
<p>T5 D5 L5</p> <p>TYPE: drill</p> <p>DIAMETER: 10mm</p> <p>TIP ANGLE: 145°</p> <p>LENGTH: 50mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: Punta per preforare tasche grandi</p> <p>VENDOR: mistubishi</p> <p>PRODUCT: MPS1-1000-PC</p>	<p>MINIMUM Z: -16mm</p> <p>MAXIMUM FEED: 420.12mm/min</p> <p>MAXIMUM SPINDLE SPEED: 3501rpm</p> <p>CUTTING DISTANCE: 160mm</p> <p>RAPID DISTANCE: 850.77mm</p> <p>ESTIMATED CYCLE TIME: 33s (1.8%)</p>	
<p>T10 D10 L10</p> <p>TYPE: face mill</p> <p>DIAMETER: 63mm</p> <p>CORNER RADIUS: 1.5mm</p> <p>LENGTH: 85mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: 11_facciatura_finitura</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: ASX445R634S32 con inserto SOET12T308PEER-JL grado VP15TF</p>	<p>MINIMUM Z: -5mm</p> <p>MAXIMUM FEED: 481mm/min</p> <p>MAXIMUM SPINDLE SPEED: 1203rpm</p> <p>CUTTING DISTANCE: 1594.75mm</p> <p>RAPID DISTANCE: 187.7mm</p> <p>ESTIMATED CYCLE TIME: 3m:22s (10.8%)</p>	

T11 D11 L11 TYPE: drill DIAMETER: 5mm TIP ANGLE: 140° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Punta per Preforo tasca piccola PRODUCT: MMS0500X3DB	MINIMUM Z: -16mm MAXIMUM FEED: 456mm/min MAXIMUM SPINDLE SPEED: 3800rpm CUTTING DISTANCE: 32mm RAPID DISTANCE: 297mm ESTIMATED CYCLE TIME: 8s (0.4%)	
T12 D12 L12 TYPE: flat end mill DIAMETER: 4mm LENGTH: 40mm FLUTES: 5 DESCRIPTION: Fresa per sgrossatura (tasca piccola) e per finitura totale tasche PRODUCT: AK334-0400-050-XC 1730	MINIMUM Z: -16mm MAXIMUM FEED: 2270mm/min MAXIMUM SPINDLE SPEED: 7190rpm CUTTING DISTANCE: 6696.03mm RAPID DISTANCE: 3703.53mm ESTIMATED CYCLE TIME: 10m:33s (33.9%)	
T13 D13 L13 TYPE: flat end mill DIAMETER: 32mm LENGTH: 100mm FLUTES: 4 DESCRIPTION: fresa per elicoidale VENDOR: mitsubishi PRODUCT: AQXR324SA32S con inserto QOMT1651R-M2 con grado MP6130	MINIMUM Z: -16.5mm MAXIMUM FEED: 250mm/min MAXIMUM SPINDLE SPEED: 1393rpm CUTTING DISTANCE: 670.76mm RAPID DISTANCE: 295.97mm ESTIMATED CYCLE TIME: 2m:45s (8.8%)	
T14 D14 L14 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 1mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: 54_finitura_fondo_tondo VENDOR: mitsubishi PRODUCT: MPMHVRBD0800R100	MINIMUM Z: -16mm MAXIMUM FEED: 1999.2mm/min MAXIMUM SPINDLE SPEED: 6000rpm CUTTING DISTANCE: 1642.96mm RAPID DISTANCE: 956.73mm ESTIMATED CYCLE TIME: 1m:20s (4.3%)	
T17 D17 L17 TYPE: ball end mill DIAMETER: 8mm CORNER RADIUS: 4mm LENGTH: 20mm FLUTES: 4 DESCRIPTION: nervatura tonda VENDOR: mitsubishi PRODUCT: fresa a punta tonda VQ4SVBR04000	MINIMUM Z: -16.44mm MAXIMUM FEED: 1900mm/min MAXIMUM SPINDLE SPEED: 8000rpm CUTTING DISTANCE: 2074.5mm RAPID DISTANCE: 431.73mm ESTIMATED CYCLE TIME: 1m:11s (3.8%)	

Operations

Operation 1/15 DESCRIPTION: 10_sfacciatura_sgrossatura STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 31mm	MAXIMUM Z: 15mm MINIMUM Z: -4.6mm MAXIMUM SPINDLE SPEED: 2160rpm MAXIMUM FEEDRATE: 2214mm/min CUTTING DISTANCE: 1865.63mm RAPID DISTANCE: 183.94mm ESTIMATED CYCLE TIME: 55s (2.9%) COOLANT: Flood	T1 D1 L1 TYPE: face mill DIAMETER: 38.1mm CORNER RADIUS: 1.6mm LENGTH: 76.2mm FLUTES: 5 DESCRIPTION: 1_Fresa per sfacciatura sgrossatura VENDOR: sandvik PRODUCT: A490-038C5-08H con inserto 490R-08T316M-PH 4330	
Operation 2/15 DESCRIPTION: 20_sfacciatura_finitura STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 45mm	MAXIMUM Z: 15mm MINIMUM Z: -5mm MAXIMUM SPINDLE SPEED: 1203rpm MAXIMUM FEEDRATE: 481mm/min CUTTING DISTANCE: 1594.75mm RAPID DISTANCE: 187.7mm ESTIMATED CYCLE TIME: 3m:22s (10.8%) COOLANT: Flood	T10 D10 L10 TYPE: face mill DIAMETER: 63mm CORNER RADIUS: 1.5mm LENGTH: 85mm FLUTES: 4 DESCRIPTION: 11_facciatura_finitura VENDOR: mitsubishi PRODUCT: ASX445R634S32 con inserto SOET12T308PEER-JL grado VP15TF	
Operation 3/15 DESCRIPTION: 30_contornatura_sgrossatura STRATEGY: Adaptive 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.5mm/0mm MAXIMUM STEPDOWN: 11.77mm OPTIMAL LOAD: 25mm LOAD DEVIATION: 2.5mm	MAXIMUM Z: 15mm MINIMUM Z: -17.5mm MAXIMUM SPINDLE SPEED: 2330rpm MAXIMUM FEEDRATE: 1360.72mm/min CUTTING DISTANCE: 3060.66mm RAPID DISTANCE: 1766.41mm ESTIMATED CYCLE TIME: 2m:37s (8.4%) COOLANT: Flood	T3 D3 L3 TYPE: flat end mill DIAMETER: 38.1mm LENGTH: 85.34mm FLUTES: 4 DESCRIPTION: contornatura_sgrossatura VENDOR: sandvik PRODUCT: RA390-038M32-17H con inserto R390-17 04 08M-PM 4330	
Operation 4/15 DESCRIPTION: 40_Contornatura_finitura STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM Z: 15mm MINIMUM Z: -17.5mm MAXIMUM SPINDLE SPEED: 7160rpm MAXIMUM FEEDRATE: 1074mm/min CUTTING DISTANCE: 961.08mm RAPID DISTANCE: 231.19mm ESTIMATED CYCLE TIME: 1m:2s (3.3%) COOLANT: Flood	T2 D2 L2 TYPE: flat end mill DIAMETER: 6mm LENGTH: 57mm FLUTES: 5 DESCRIPTION: finitura_contorno VENDOR: sandvik PRODUCT: 2N342-0600-PC 1730	
Operation 5/15 DESCRIPTION: 50_preforatura_Tasche_grandi STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM Z: 15mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 3501rpm MAXIMUM FEEDRATE: 420.12mm/min CUTTING DISTANCE: 160mm RAPID DISTANCE: 850.77mm ESTIMATED CYCLE TIME: 33s (1.8%) COOLANT: Flood	T5 D5 L5 TYPE: drill DIAMETER: 10mm TIP ANGLE: 145° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Punte per preforare tasche grandi VENDOR: mistubishi PRODUCT: MPS1-1000-PC	

<p>Operation 6/15</p> <p>DESCRIPTION: 60_Preforatura_tasche_piccole</p> <p>STRATEGY: Drilling</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 3800rpm</p> <p>MAXIMUM FEEDRATE: 456mm/min</p> <p>CUTTING DISTANCE: 32mm</p> <p>RAPID DISTANCE: 297mm</p> <p>ESTIMATED CYCLE TIME: 8s (0.4%)</p> <p>COOLANT: Flood</p>	<p>T11 D11 L11</p> <p>TYPE: drill</p> <p>DIAMETER: 5mm</p> <p>TIP ANGLE: 140°</p> <p>LENGTH: 50mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: Punta per Preforo tasca piccola</p> <p>PRODUCT: MMS0500X3DB</p>	
<p>Operation 7/15</p> <p>DESCRIPTION: 70_tasche_grandi_interne_sgrossatura</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.2mm</p> <p>MAXIMUM STEPDOWN: 6mm</p> <p>MAXIMUM STEPOVER: 4.8mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -15.8mm</p> <p>MAXIMUM SPINDLE SPEED: 2170rpm</p> <p>MAXIMUM FEEDRATE: 2170mm/min</p> <p>CUTTING DISTANCE: 2619.72mm</p> <p>RAPID DISTANCE: 1111.95mm</p> <p>ESTIMATED CYCLE TIME: 1m:39s (5.3%)</p> <p>COOLANT: Flood</p>	<p>T4 D4 L4</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 0.2mm</p> <p>LENGTH: 45mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Sgrossatura tasche 1</p> <p>PRODUCT: 1K325-0800-XB 1730</p>	
<p>Operation 8/15</p> <p>DESCRIPTION: 80_tasche_esterne_sgrossatura</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0mm/0.2mm</p> <p>MAXIMUM STEPDOWN: 6mm</p> <p>MAXIMUM STEPOVER: 4.8mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -15.8mm</p> <p>MAXIMUM SPINDLE SPEED: 2170rpm</p> <p>MAXIMUM FEEDRATE: 2170mm/min</p> <p>CUTTING DISTANCE: 1372.93mm</p> <p>RAPID DISTANCE: 600.68mm</p> <p>ESTIMATED CYCLE TIME: 2m:4s (6.7%)</p> <p>COOLANT: Flood</p>	<p>T4 D4 L4</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 0.2mm</p> <p>LENGTH: 45mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Sgrossatura tasche 1</p> <p>PRODUCT: 1K325-0800-XB 1730</p>	
<p>Operation 9/15</p> <p>DESCRIPTION: 90_tasca_piccola_sgrossatura</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.2mm</p> <p>MAXIMUM STEPDOWN: 6mm</p> <p>MAXIMUM STEPOVER: 2.4mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -15.8mm</p> <p>MAXIMUM SPINDLE SPEED: 4540rpm</p> <p>MAXIMUM FEEDRATE: 2270mm/min</p> <p>CUTTING DISTANCE: 293.29mm</p> <p>RAPID DISTANCE: 320.2mm</p> <p>ESTIMATED CYCLE TIME: 12s (0.6%)</p> <p>COOLANT: Flood</p>	<p>T12 D12 L12</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa per sgrossatura (tasca piccola) e per finitura totale tasche</p> <p>PRODUCT: 1K334-0400-050-XC 1730</p>	
<p>Operation 10/15</p> <p>DESCRIPTION: 100_tasche_laterali_finitura</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 6mm</p> <p>MAXIMUM STEPOVER: 3.8mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -15.8mm</p> <p>MAXIMUM SPINDLE SPEED: 4510rpm</p> <p>MAXIMUM FEEDRATE: 369.82mm/min</p> <p>CUTTING DISTANCE: 2460mm</p> <p>RAPID DISTANCE: 1288.94mm</p> <p>ESTIMATED CYCLE TIME: 7m:0s (22.5%)</p> <p>COOLANT: Flood</p>	<p>T12 D12 L12</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa per sgrossatura (tasca piccola) e per finitura totale tasche</p> <p>PRODUCT: 1K334-0400-050-XC 1730</p>	
<p>Operation 11/15</p> <p>DESCRIPTION: 110_tasche_fondo_finitura</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPOVER: 2.4mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 7190rpm</p> <p>MAXIMUM FEEDRATE: 2106.67mm/min</p> <p>CUTTING DISTANCE: 3942.74mm</p> <p>RAPID DISTANCE: 2094.39mm</p> <p>ESTIMATED CYCLE TIME: 3m:22s (10.8%)</p> <p>COOLANT: Flood</p>	<p>T12 D12 L12</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa per sgrossatura (tasca piccola) e per finitura totale tasche</p> <p>PRODUCT: 1K334-0400-050-XC 1730</p>	
<p>Operation 12/15</p> <p>DESCRIPTION: 120_tasche_laterali_con_smusso_finitura</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPOVER: 5.7mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 6000rpm</p> <p>MAXIMUM FEEDRATE: 1999.2mm/min</p> <p>CUTTING DISTANCE: 369.38mm</p> <p>RAPID DISTANCE: 536.63mm</p> <p>ESTIMATED CYCLE TIME: 36s (1.9%)</p> <p>COOLANT: Flood</p>	<p>T14 D14 L14</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: 54_finitura_fondo_tondo</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: MPMHVRBD0800R100</p>	
<p>Operation 13/15</p> <p>DESCRIPTION: 130_Fresatura_elicoidale_foro_centrale_sgrossatura</p> <p>STRATEGY: Bore</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0.2mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16.5mm</p> <p>MAXIMUM SPINDLE SPEED: 1393rpm</p> <p>MAXIMUM FEEDRATE: 250mm/min</p> <p>CUTTING DISTANCE: 670.76mm</p> <p>RAPID DISTANCE: 295.97mm</p> <p>ESTIMATED CYCLE TIME: 2m:45s (8.8%)</p> <p>COOLANT: Flood</p>	<p>T13 D13 L13</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 32mm</p> <p>LENGTH: 100mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: fresa per elicoidale</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: AQXR324SA32S con inserto QOMT1651R-M2 con grado MP6130</p>	
<p>Operation 14/15</p> <p>DESCRIPTION: 140_nervature_tonde_sgrossatura</p> <p>STRATEGY: Parallel</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0.2mm</p> <p>MAXIMUM STEPOVER: 0.2mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -12.3mm</p> <p>MAXIMUM SPINDLE SPEED: 6000rpm</p> <p>MAXIMUM FEEDRATE: 1999.2mm/min</p> <p>CUTTING DISTANCE: 1273.58mm</p> <p>RAPID DISTANCE: 420.1mm</p> <p>ESTIMATED CYCLE TIME: 44s (2.4%)</p> <p>COOLANT: Flood</p>	<p>T14 D14 L14</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: 54_finitura_fondo_tondo</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: MPMHVRBD0800R100</p>	
<p>Operation 15/15</p> <p>DESCRIPTION: 150_nervature_tonde_finitura</p> <p>STRATEGY: Parallel</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPOVER: 0.1mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16.44mm</p> <p>MAXIMUM SPINDLE SPEED: 8000rpm</p> <p>MAXIMUM FEEDRATE: 1900mm/min</p> <p>CUTTING DISTANCE: 2074.5mm</p> <p>RAPID DISTANCE: 431.73mm</p> <p>ESTIMATED CYCLE TIME: 1m:11s (3.8%)</p> <p>COOLANT: Flood</p>	<p>T17 D17 L17</p> <p>TYPE: ball end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 4mm</p> <p>LENGTH: 20mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: nervatura tonda</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: fresa a punta tonda VQ4SVBR04000</p>	

Setup Sheet for Program 1002

JOB DESCRIPTION: Setup2
DOCUMENT PATH: FINITO v1

Setup

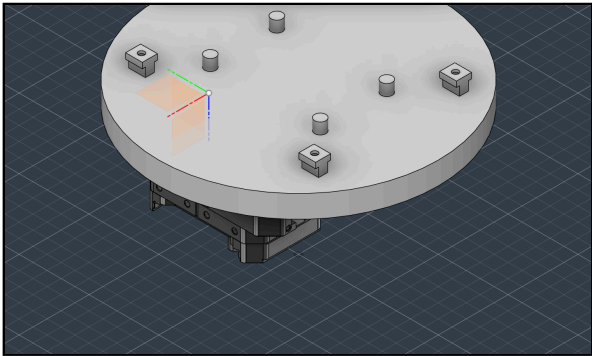
WCS: #1

STOCK:
DX: 160mm
DY: 320mm
DZ: 35mm

PART:
DX: 150mm
DY: 309.87mm
DZ: 25mm

STOCK LOWER IN WCS #1:
X: 0mm
Y: 0mm
Z: 0mm

STOCK UPPER IN WCS #1:
X: 160mm
Y: 320mm
Z: 35mm



Total

NUMBER OF OPERATIONS: 17

NUMBER OF TOOLS: 13

TOOLS: T1 T2 T3 T4 T5 T7 T8 T10 T11 T12 T13 T14 T17

MAXIMUM Z: 51mm

MINIMUM Z: 5mm

MAXIMUM FEEDRATE: 2270mm/min

MAXIMUM SPINDLE SPEED: 8000rpm

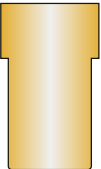
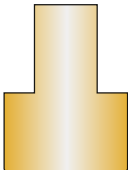

CUTTING DISTANCE: 23974.55mm

RAPID DISTANCE: 13561.49mm

ESTIMATED CYCLE TIME: 38m:42s

Tools		
<div><div><div>T1 D1 L1</div><div>TYPE: face mill</div><div>DIAMETER: 38.1mm</div><div>CORNER RADIUS: 1.6mm</div><div>LENGTH: 76.2mm</div><div>FLUTES: 5</div><div>DESCRIPTION: 1_Fresa per sfacciatura sgrossatura</div><div>VENDOR: sandvik</div><div>PRODUCT: A490-038C5-08H con inserto 490R-08T316M-PH 4330</div></div><div><div>MINIMUM Z: 30.4mm</div><div>MAXIMUM FEED: 2214mm/min</div><div>MAXIMUM SPINDLE SPEED: 2160rpm</div><div>CUTTING DISTANCE: 1865.63mm</div><div>RAPID DISTANCE: 329.22mm</div><div>ESTIMATED CYCLE TIME: 56s (2.4%)</div></div><div></div></div>		
<div><div><div>T2 D2 L2</div><div>TYPE: flat end mill</div><div>DIAMETER: 6mm</div><div>LENGTH: 57mm</div><div>FLUTES: 5</div><div>DESCRIPTION: finitura_contorno</div><div>VENDOR: sandvik</div><div>PRODUCT: 2N342-0600-PC 1730</div></div><div><div>MINIMUM Z: 17.2mm</div><div>MAXIMUM FEED: 1074mm/min</div><div>MAXIMUM SPINDLE SPEED: 7160rpm</div><div>CUTTING DISTANCE: 961.68mm</div><div>RAPID DISTANCE: 230.96mm</div><div>ESTIMATED CYCLE TIME: 1 m:2s (2.7%)</div></div><div></div></div>		
<div><div><div>T3 D3 L3</div><div>TYPE: flat end mill</div><div>DIAMETER: 38.1mm</div><div>LENGTH: 85.34mm</div><div>FLUTES: 4</div><div>DESCRIPTION: contornatura_sgrossatura</div><div>VENDOR: sandvik</div><div>PRODUCT: RA390-038M32-17H con inserto R390-17 04 08M-PM 4330</div></div><div><div>MINIMUM Z: 17.2mm</div><div>MAXIMUM FEED: 1360.72mm/min</div><div>MAXIMUM SPINDLE SPEED: 2330rpm</div><div>CUTTING DISTANCE: 3837.73mm</div><div>RAPID DISTANCE: 384.86mm</div><div>ESTIMATED CYCLE TIME: 2m:56s (7.6%)</div></div><div></div></div>		
<div><div><div>T4 D4 L4</div><div>TYPE: bullnose end mill</div><div>DIAMETER: 8mm</div><div>CORNER RADIUS: 0.2mm</div><div>LENGTH: 45mm</div><div>FLUTES: 5</div><div>DESCRIPTION: Sgrossatura tasche 1</div><div>PRODUCT: 1K325-0800-XB 1730</div></div><div><div>MINIMUM Z: 19.2mm</div><div>MAXIMUM FEED: 2170mm/min</div><div>MAXIMUM SPINDLE SPEED: 2170rpm</div><div>CUTTING DISTANCE: 3820.5mm</div><div>RAPID DISTANCE: 1929.75mm</div><div>ESTIMATED CYCLE TIME: 3m:28s (9%)</div></div><div></div></div>		
<div><div><div>T5 D5 L5</div><div>TYPE: drill</div><div>DIAMETER: 10mm</div><div>TIP ANGLE: 145°</div><div>LENGTH: 50mm</div><div>FLUTES: 2</div><div>DESCRIPTION: Punta per preforare tasche grandi</div><div>VENDOR: mistubishi</div><div>PRODUCT: MPS1-1000-PC</div></div><div><div>MINIMUM Z: 19mm</div><div>MAXIMUM FEED: 420.12mm/min</div><div>MAXIMUM SPINDLE SPEED: 3501rpm</div><div>CUTTING DISTANCE: 160mm</div><div>RAPID DISTANCE: 850.77mm</div><div>ESTIMATED CYCLE TIME: 33s (1.4%)</div></div><div></div></div>		
<div><div><div>T7 D7 L7</div><div>TYPE: boring bar</div><div>DIAMETER: 40mm</div><div>LENGTH: 48mm</div><div>FLUTES: 1</div><div>DESCRIPTION: Alesa per foro centrale H8</div><div>PRODUCT: 825-825-45TC09-C345TC09-C3</div></div><div><div>MINIMUM Z: 5mm</div><div>MAXIMUM FEED: 146.85mm/min</div><div>MAXIMUM SPINDLE SPEED: 979rpm</div><div>CUTTING DISTANCE: 60mm</div><div>RAPID DISTANCE: 325mm</div><div>ESTIMATED CYCLE TIME: 28s (1.2%)</div></div><div></div></div>		

T8 D8 L8 TYPE: drill DIAMETER: 2.5mm TIP ANGLE: 140° LENGTH: 40mm FLUTES: 2 DESCRIPTION: Punta per fori piccoli PRODUCT: 862 1-2500-225A0-GM X2BL	MINIMUM Z: 14mm MAXIMUM FEED: 112.28mm/min MAXIMUM SPINDLE SPEED: 4010rpm CUTTING DISTANCE: 600mm RAPID DISTANCE: 3606.99mm ESTIMATED CYCLE TIME: 6m:4s (15.7%)	
T10 D10 L10 TYPE: face mill DIAMETER: 63mm CORNER RADIUS: 1.5mm LENGTH: 85mm FLUTES: 4 DESCRIPTION: 11_facciatura_finitura VENDOR: mitsubishi PRODUCT: ASX445R634S32 con inserto SOET12T308PEER-JL grado VP15TF	MINIMUM Z: 30mm MAXIMUM FEED: 481mm/min MAXIMUM SPINDLE SPEED: 1203rpm CUTTING DISTANCE: 1594.75mm RAPID DISTANCE: 187.7mm ESTIMATED CYCLE TIME: 3m:22s (8.7%)	
T11 D11 L11 TYPE: drill DIAMETER: 5mm TIP ANGLE: 140° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Punta per Preforo tasca piccola PRODUCT: MMS0500X3DB	MINIMUM Z: 19mm MAXIMUM FEED: 456mm/min MAXIMUM SPINDLE SPEED: 3800rpm CUTTING DISTANCE: 32mm RAPID DISTANCE: 297mm ESTIMATED CYCLE TIME: 8s (0.3%)	
T12 D12 L12 TYPE: flat end mill DIAMETER: 4mm LENGTH: 40mm FLUTES: 5 DESCRIPTION: Fresa per sgrossatura (tasca piccola) e per finitura totale tasche PRODUCT: 1K334-0400-050-XC 1730	MINIMUM Z: 19mm MAXIMUM FEED: 2270mm/min MAXIMUM SPINDLE SPEED: 7190rpm CUTTING DISTANCE: 6695.56mm RAPID DISTANCE: 3648.36mm ESTIMATED CYCLE TIME: 10m:33s (27.3%)	
T13 D13 L13 TYPE: flat end mill DIAMETER: 32mm LENGTH: 100mm FLUTES: 4 DESCRIPTION: fresa per elicoidale VENDOR: mitsubishi PRODUCT: AQXR324SA32S con inserto QOMT1651R-M2 con grado MP6130	MINIMUM Z: 16mm MAXIMUM FEED: 250mm/min MAXIMUM SPINDLE SPEED: 1393rpm CUTTING DISTANCE: 797.84mm RAPID DISTANCE: 305.41mm ESTIMATED CYCLE TIME: 3m:15s (8.4%)	
T14 D14 L14 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 1mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: 54_finitura_fondo_tondo VENDOR: mitsubishi PRODUCT: MPMHVRBD0800R100	MINIMUM Z: 19mm MAXIMUM FEED: 1999.2mm/min MAXIMUM SPINDLE SPEED: 6000rpm CUTTING DISTANCE: 1474.37mm RAPID DISTANCE: 1033.74mm ESTIMATED CYCLE TIME: 1m:16s (3.3%)	
T17 D17 L17 TYPE: ball end mill DIAMETER: 8mm CORNER RADIUS: 4mm LENGTH: 20mm FLUTES: 4 DESCRIPTION: nervatura tonda VENDOR: mitsubishi PRODUCT: fresa a punta tonda VQ4SVBR04000	MINIMUM Z: 18.56mm MAXIMUM FEED: 1900mm/min MAXIMUM SPINDLE SPEED: 8000rpm CUTTING DISTANCE: 2074.5mm RAPID DISTANCE: 431.73mm ESTIMATED CYCLE TIME: 1m:11s (3.1%)	

Operations			
Operation 1/17 DESCRIPTION: 160_Sfacciatura Sgrossatura (2) STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 31mm	MAXIMUM Z: 50mm MINIMUM Z: 30.4mm MAXIMUM SPINDLE SPEED: 2160rpm MAXIMUM FEEDRATE: 2214mm/min CUTTING DISTANCE: 1865.63mm RAPID DISTANCE: 329.22mm ESTIMATED CYCLE TIME: 56s (2.4%) COOLANT: Flood	T1 D1 L1 TYPE: face mill DIAMETER: 38.1mm CORNER RADIUS: 1.6mm LENGTH: 76.2mm FLUTES: 5 DESCRIPTION: 1_Fresa per sfacciatura sgrossatura VENDOR: sandvik PRODUCT: A490-038C5-08H con inserto 490R-08T316M-PH 4330	
Operation 2/17 DESCRIPTION: 170_sfacciatura_finitura STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 45mm	MAXIMUM Z: 50mm MINIMUM Z: 30mm MAXIMUM SPINDLE SPEED: 1203rpm MAXIMUM FEEDRATE: 481mm/min CUTTING DISTANCE: 1594.75mm RAPID DISTANCE: 187.7mm ESTIMATED CYCLE TIME: 3m:22s (8.7%) COOLANT: Flood	T10 D10 L10 TYPE: face mill DIAMETER: 63mm CORNER RADIUS: 1.5mm LENGTH: 85mm FLUTES: 4 DESCRIPTION: 11_facciatura_finitura VENDOR: mitsubishi PRODUCT: ASX445R634S32 con inserto SOET12T308PEER-JL grado VP15TF	
Operation 3/17 DESCRIPTION: 180_contornatura_sgrossatura STRATEGY: Adaptive 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.5mm/0mm MAXIMUM STEPDOWN: 11.77mm OPTIMAL LOAD: 25mm LOAD DEVIATION: 2.5mm	MAXIMUM Z: 50mm MINIMUM Z: 17.2mm MAXIMUM SPINDLE SPEED: 2330rpm MAXIMUM FEEDRATE: 1360.72mm/min CUTTING DISTANCE: 3837.73mm RAPID DISTANCE: 384.86mm ESTIMATED CYCLE TIME: 2m:56s (7.6%) COOLANT: Flood	T3 D3 L3 TYPE: flat end mill DIAMETER: 38.1mm LENGTH: 85.34mm FLUTES: 4 DESCRIPTION: contornatura_sgrossatura VENDOR: sandvik PRODUCT: RA390-038M32-17H con inserto R390-17 04 08M-PM 4330	

Operation 4/17 DESCRIPTION: 190_contornatura_finitura STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM Z: 50mm MINIMUM Z: 17.2mm MAXIMUM SPINDLE SPEED: 7160rpm MAXIMUM FEEDRATE: 1074mm/min CUTTING DISTANCE: 961.68mm RAPID DISTANCE: 230.96mm ESTIMATED CYCLE TIME: 1m:2s (2.7%) COOLANT: Flood	T2 D2 L2 TYPE: flat end mill DIAMETER: 6mm LENGTH: 57mm FLUTES: 5 DESCRIPTION: finitura_contorno VENDOR: sandvik PRODUCT: 2N342-0600-PC 1730	
Operation 5/17 DESCRIPTION: 200_preFORATURA_Tasche_grandi STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM Z: 50mm MINIMUM Z: 19mm MAXIMUM SPINDLE SPEED: 3501rpm MAXIMUM FEEDRATE: 420.12mm/min CUTTING DISTANCE: 160mm RAPID DISTANCE: 850.77mm ESTIMATED CYCLE TIME: 33s (1.4%) COOLANT: Flood	T5 D5 L5 TYPE: drill DIAMETER: 10mm TIP ANGLE: 145° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Punta per preforare tasche grandi VENDOR: mistubishi PRODUCT: MPS1-1000-PC	
Operation 6/17 DESCRIPTION: 210_Preforatura_tasche_piccole STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM Z: 50mm MINIMUM Z: 19mm MAXIMUM SPINDLE SPEED: 3800rpm MAXIMUM FEEDRATE: 456mm/min CUTTING DISTANCE: 32mm RAPID DISTANCE: 297mm ESTIMATED CYCLE TIME: 8s (0.3%) COOLANT: Flood	T11 D11 L11 TYPE: drill DIAMETER: 5mm TIP ANGLE: 140° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Punta per Preforo tasca piccola PRODUCT: MMS0500X3DB	
Operation 7/17 DESCRIPTION: 220_tasche_grandi_interne_sgrossatura STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.2mm MAXIMUM STEPDOWN: 6mm MAXIMUM STEPOVER: 4.8mm	MAXIMUM Z: 50mm MINIMUM Z: 19.2mm MAXIMUM SPINDLE SPEED: 2170rpm MAXIMUM FEEDRATE: 2170mm/min CUTTING DISTANCE: 2447.72mm RAPID DISTANCE: 1149.63mm ESTIMATED CYCLE TIME: 1m:21s (3.5%) COOLANT: Flood	T4 D4 L4 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.2mm LENGTH: 45mm FLUTES: 5 DESCRIPTION: Sgrossatura tasche 1 PRODUCT: 1K325-0800-XB 1730	
Operation 8/17 DESCRIPTION: 230_tasche_esterne_sgrossatura STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm/0.2mm MAXIMUM STEPDOWN: 6mm MAXIMUM STEPOVER: 4.8mm	MAXIMUM Z: 50mm MINIMUM Z: 19.2mm MAXIMUM SPINDLE SPEED: 2170rpm MAXIMUM FEEDRATE: 2170mm/min CUTTING DISTANCE: 1372.78mm RAPID DISTANCE: 780.11mm ESTIMATED CYCLE TIME: 2m:7s (5.5%) COOLANT: Flood	T4 D4 L4 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.2mm LENGTH: 45mm FLUTES: 5 DESCRIPTION: Sgrossatura tasche 1 PRODUCT: 1K325-0800-XB 1730	
Operation 9/17 DESCRIPTION: 240_tasca_piccola_sgrossatura STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.2mm MAXIMUM STEPDOWN: 6mm MAXIMUM STEPOVER: 2.4mm	MAXIMUM Z: 50mm MINIMUM Z: 19.2mm MAXIMUM SPINDLE SPEED: 4540rpm MAXIMUM FEEDRATE: 2270mm/min CUTTING DISTANCE: 292.25mm RAPID DISTANCE: 314.65mm ESTIMATED CYCLE TIME: 12s (0.5%) COOLANT: Flood	T12 D12 L12 TYPE: flat end mill DIAMETER: 4mm LENGTH: 40mm FLUTES: 5 DESCRIPTION: Fresa per sgrossatura (tasca piccola) e per finitura totale tasche PRODUCT: 1K334-0400-050-XC 1730	
Operation 10/17 DESCRIPTION: 250_tasche_laterali_finitura STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 6mm MAXIMUM STEPOVER: 3.8mm	MAXIMUM Z: 50mm MINIMUM Z: 19.2mm MAXIMUM SPINDLE SPEED: 4510rpm MAXIMUM FEEDRATE: 369.82mm/min CUTTING DISTANCE: 2460mm RAPID DISTANCE: 1296.5mm ESTIMATED CYCLE TIME: 7m:0s (18.1%) COOLANT: Flood	T12 D12 L12 TYPE: flat end mill DIAMETER: 4mm LENGTH: 40mm FLUTES: 5 DESCRIPTION: Fresa per sgrossatura (tasca piccola) e per finitura totale tasche PRODUCT: 1K334-0400-050-XC 1730	
Operation 11/17 DESCRIPTION: 260_tasche_fondo_finitura STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 2.4mm	MAXIMUM Z: 50mm MINIMUM Z: 19mm MAXIMUM SPINDLE SPEED: 7190rpm MAXIMUM FEEDRATE: 2106.67mm/min CUTTING DISTANCE: 3943.31mm RAPID DISTANCE: 2037.21mm ESTIMATED CYCLE TIME: 3m:21s (8.7%) COOLANT: Flood	T12 D12 L12 TYPE: flat end mill DIAMETER: 4mm LENGTH: 40mm FLUTES: 5 DESCRIPTION: Fresa per sgrossatura (tasca piccola) e per finitura totale tasche PRODUCT: 1K334-0400-050-XC 1730	
Operation 12/17 DESCRIPTION: 270_tasche_laterali_con_smusso_finitura STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM Z: 50mm MINIMUM Z: 19mm MAXIMUM SPINDLE SPEED: 6000rpm MAXIMUM FEEDRATE: 1999.2mm/min CUTTING DISTANCE: 369.38mm RAPID DISTANCE: 612.42mm ESTIMATED CYCLE TIME: 37s (1.6%) COOLANT: Flood	T14 D14 L14 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 1mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: 54_finitura_fondo_tondo VENDOR: mitsubishi PRODUCT: MPMHVRBD0800R100	
Operation 13/17 DESCRIPTION: 280_Fresatura_elicoidale_foro_centrale_sgrossatura (2) STRATEGY: Bore WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.2mm	MAXIMUM Z: 50mm MINIMUM Z: 16mm MAXIMUM SPINDLE SPEED: 1393rpm MAXIMUM FEEDRATE: 250mm/min CUTTING DISTANCE: 797.84mm RAPID DISTANCE: 305.41mm ESTIMATED CYCLE TIME: 3m:15s (8.4%) COOLANT: Flood	T13 D13 L13 TYPE: flat end mill DIAMETER: 32mm LENGTH: 100mm FLUTES: 4 DESCRIPTION: fresa per elicoidale VENDOR: mitsubishi PRODUCT: AQXR324SA32S con inserto QOMT1651R-M2 con grado MP6130	

Operation 14/17 DESCRIPTION: 290_Barenatura STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM Z: 50mm MINIMUM Z: 5mm MAXIMUM SPINDLE SPEED: 979rpm MAXIMUM FEEDRATE: 146.85mm/min CUTTING DISTANCE: 60mm RAPID DISTANCE: 325mm ESTIMATED CYCLE TIME: 28s (1.2%) COOLANT: Flood	T7 D7 L7 TYPE: boring bar DIAMETER: 40mm LENGTH: 48mm FLUTES: 1 DESCRIPTION: Alesa per foro centrale H8 PRODUCT: 825-825-45TC09-C345TC09-C3	
Operation 15/17 DESCRIPTION: 300_foratura_fori_piccoli STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM Z: 51mm MINIMUM Z: 14mm MAXIMUM SPINDLE SPEED: 4010rpm MAXIMUM FEEDRATE: 112.28mm/min CUTTING DISTANCE: 600mm RAPID DISTANCE: 3606.99mm ESTIMATED CYCLE TIME: 6m:4s (15.7%) COOLANT: Flood	T8 D8 L8 TYPE: drill DIAMETER: 2.5mm TIP ANGLE: 140° LENGTH: 40mm FLUTES: 2 DESCRIPTION: Punta per fori piccoli PRODUCT: 862-1-2500-225A0-GM X2BL	
Operation 16/17 DESCRIPTION: 310_nervature_tonde_sgrossatura STRATEGY: Parallel WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.2mm	MAXIMUM Z: 50mm MINIMUM Z: 22.72mm MAXIMUM SPINDLE SPEED: 6000rpm MAXIMUM FEEDRATE: 1999.2mm/min CUTTING DISTANCE: 1104.98mm RAPID DISTANCE: 421.32mm ESTIMATED CYCLE TIME: 39s (1.7%) COOLANT: Flood	T14 D14 L14 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 1mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: 54_finitura_fondo_tondo VENDOR: mitsubishi PRODUCT: MPMHVRBD0800R100	
Operation 17/17 DESCRIPTION: 320_nervature_tonde_finitura STRATEGY: Parallel WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.1mm	MAXIMUM Z: 50mm MINIMUM Z: 18.56mm MAXIMUM SPINDLE SPEED: 8000rpm MAXIMUM FEEDRATE: 1900mm/min CUTTING DISTANCE: 2074.5mm RAPID DISTANCE: 431.73mm ESTIMATED CYCLE TIME: 1m:11s (3.1%) COOLANT: Flood	T17 D17 L17 TYPE: ball end mill DIAMETER: 8mm CORNER RADIUS: 4mm LENGTH: 20mm FLUTES: 4 DESCRIPTION: nervatura tonda VENDOR: mitsubishi PRODUCT: fresa a punta tonda VQ4SVBR04000	