

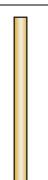
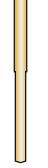
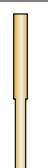
Setup Sheet for Program 1001

JOB DESCRIPTION: Setup1
 DOCUMENT PATH: progetto 2023 v1

Setup	
WCS: #1 STOCK: DX: 244mm DY: 85mm DZ: 120mm PART: DX: 234mm DY: 75mm DZ: 110mm STOCK LOWER IN WCS #1: X: 0mm Y: 0mm Z: -120mm STOCK UPPER IN WCS #1: X: 244mm Y: 85mm Z: 0mm	
Total	
NUMBER OF OPERATIONS: 19 NUMBER OF TOOLS: 14 TOOLS: T1 T2 T3 T4 T5 T6 T20 T21 T22 T23 T24 T25 T32 T33 MAXIMUM FEEDRATE: 3160mm/min MAXIMUM SPINDLE SPEED: 8035rpm CUTTING DISTANCE: 7260.95mm RAPID DISTANCE: 2008mm ESTIMATED CYCLE TIME: 7m:48s	
Tools	
T1 D1 L1 TYPE: face mill DIAMETER: 40mm LENGTH: 48mm FLUTES: 6 DESCRIPTION: CoroMill 490 square VENDOR: Sandvik PRODUCT: 490-040C4-08H	 MAXIMUM FEED: 3160mm/min MAXIMUM SPINDLE SPEED: 2485rpm CUTTING DISTANCE: 4094.01mm RAPID DISTANCE: 130mm ESTIMATED CYCLE TIME: 1m:31s (19.5%)
T2 D2 L2 TYPE: flat end mill DIAMETER: 9.53mm LENGTH: 31.75mm FLUTES: 4 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: 2F342-0953-PD P2BM	 MAXIMUM FEED: 2356mm/min MAXIMUM SPINDLE SPEED: 7990rpm CUTTING DISTANCE: 271.63mm RAPID DISTANCE: 313.54mm ESTIMATED CYCLE TIME: 12s (2.5%)
T3 D3 L3 TYPE: bullnose end mill DIAMETER: 16mm CORNER RADIUS: 0.5mm LENGTH: 42mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: 2F342-1600-050-PD P2BM	 MAXIMUM FEED: 1840mm/min MAXIMUM SPINDLE SPEED: 4300rpm CUTTING DISTANCE: 2158.91mm RAPID DISTANCE: 96.6mm ESTIMATED CYCLE TIME: 1m:16s (16.3%)
T4 D4 L4 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 25mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA 1620	 MAXIMUM FEED: 1500mm/min MAXIMUM SPINDLE SPEED: 7960rpm CUTTING DISTANCE: 132.89mm RAPID DISTANCE: 35.4mm ESTIMATED CYCLE TIME: 6s (1.3%)
T5 D5 L5 TYPE: face mill DIAMETER: 4.6mm TAPER ANGLE: 45° LENGTH: 15mm FLUTES: 3 DESCRIPTION: CoroMill 326 VENDOR: Sandvik PRODUCT: A326R06-M1502006-CH 1025	 MAXIMUM FEED: 1000mm/min MAXIMUM SPINDLE SPEED: 7000rpm CUTTING DISTANCE: 212.35mm RAPID DISTANCE: 71.63mm ESTIMATED CYCLE TIME: 15s (3.2%)
T6 D6 L6 TYPE: flat end mill DIAMETER: 6mm LENGTH: 28.8mm FLUTES: 7 DESCRIPTION: CoroMill dura VENDOR: Sandvik PRODUCT: 1K377-0600-050-XD 1730	 MAXIMUM FEED: 1500mm/min MAXIMUM SPINDLE SPEED: 7960rpm CUTTING DISTANCE: 165.53mm RAPID DISTANCE: 270.39mm ESTIMATED CYCLE TIME: 19s (4.1%)

T20 D20 L20 TYPE: drill DIAMETER: 4.2mm TIP ANGLE: 147° LENGTH: 73.3mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-0420-027A0-PM P1BM	MAXIMUM FEED: 1245.2mm/min MAXIMUM SPINDLE SPEED: 8035rpm CUTTING DISTANCE: 31.24mm RAPID DISTANCE: 261.24mm ESTIMATED CYCLE TIME: 5s (1%)	
T21 D21 L21 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 161mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM	MAXIMUM FEED: 862.3mm/min MAXIMUM SPINDLE SPEED: 3350rpm CUTTING DISTANCE: 32.8mm RAPID DISTANCE: 62.8mm ESTIMATED CYCLE TIME: 3s (0.6%)	
T22 D22 L22 TYPE: face mill DIAMETER: 40mm LENGTH: 112.29mm FLUTES: 6 DESCRIPTION: CoroDrill 880 VENDOR: Sandvik PRODUCT: 880-D4000L40-02	MAXIMUM FEED: 270mm/min MAXIMUM SPINDLE SPEED: 1200rpm CUTTING DISTANCE: 9mm RAPID DISTANCE: 41mm ESTIMATED CYCLE TIME: 2s (0.5%)	
T23 D23 L23 TYPE: face mill DIAMETER: 35mm LENGTH: 134.37mm FLUTES: 6 DESCRIPTION: CoroDrill® 880 VENDOR: Sandvik PRODUCT: 880-D3500L40-03	MAXIMUM FEED: 333.333mm/min MAXIMUM SPINDLE SPEED: 5000rpm CUTTING DISTANCE: 92mm RAPID DISTANCE: 134mm ESTIMATED CYCLE TIME: 18s (3.9%)	
T24 D24 L24 TYPE: drill DIAMETER: 5mm TIP ANGLE: 147° LENGTH: 81.2mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-0500-037A0-PM P1BM	MAXIMUM FEED: 1160mm/min MAXIMUM SPINDLE SPEED: 6750rpm CUTTING DISTANCE: 15.53mm RAPID DISTANCE: 100.03mm ESTIMATED CYCLE TIME: 2s (0.4%)	
T25 D25 L25 TYPE: drill DIAMETER: 4.5mm TIP ANGLE: 147° LENGTH: 73.2mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-0450-027A0-PM P1BM	MAXIMUM FEED: 1165mm/min MAXIMUM SPINDLE SPEED: 7497rpm CUTTING DISTANCE: 13.6mm RAPID DISTANCE: 117.92mm ESTIMATED CYCLE TIME: 2s (0.5%)	
T32 D32 L32 TYPE: thread mill DIAMETER: 4.2mm LENGTH: 70mm FLUTES: 2 DESCRIPTION: CoroTap 300 VENDOR: Sandvik PRODUCT: T300-PM104DA-M5 P1PM	MAXIMUM FEED: 1000mm/min MAXIMUM SPINDLE SPEED: 5000rpm CUTTING DISTANCE: 21.4mm RAPID DISTANCE: 269.2mm ESTIMATED CYCLE TIME: 5s (1%)	
T33 D33 L33 TYPE: thread mill DIAMETER: 5mm LENGTH: 80mm FLUTES: 2 DESCRIPTION: CoroTap 300 VENDOR: Sandvik PRODUCT: T300-PM104DA-M6 P1PM	MAXIMUM FEED: 1000mm/min MAXIMUM SPINDLE SPEED: 5000rpm CUTTING DISTANCE: 10.07mm RAPID DISTANCE: 104.25mm ESTIMATED CYCLE TIME: 2s (0.4%)	

Operations		
Operation 1/19 DESCRIPTION: Sgrossatura 1 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 28mm	MAXIMUM SPINDLE SPEED: 1820rpm MAXIMUM FEEDRATE: 2190mm/min CUTTING DISTANCE: 1257.29mm RAPID DISTANCE: 26mm ESTIMATED CYCLE TIME: 35s (7.5%) COOLANT: Flood	T1 D1 L1 TYPE: face mill DIAMETER: 40mm LENGTH: 48mm FLUTES: 6 DESCRIPTION: CoroMill 490 square VENDOR: Sandvik PRODUCT: 490-040C4-08H
Operation 2/19 DESCRIPTION: Sgrossatura 2 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 28mm	MAXIMUM SPINDLE SPEED: 2485rpm MAXIMUM FEEDRATE: 3160mm/min CUTTING DISTANCE: 947.56mm RAPID DISTANCE: 26mm ESTIMATED CYCLE TIME: 19s (4%) COOLANT: Flood	T1 D1 L1 TYPE: face mill DIAMETER: 40mm LENGTH: 48mm FLUTES: 6 DESCRIPTION: CoroMill 490 square VENDOR: Sandvik PRODUCT: 490-040C4-08H

Operation 3/19 DESCRIPTION: Sgrossatura 3 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEP OVER: 28mm	MAXIMUM SPINDLE SPEED: 2485rpm MAXIMUM FEEDRATE: 3160mm/min CUTTING DISTANCE: 947.72mm RAPID DISTANCE: 26mm ESTIMATED CYCLE TIME: 19s (4%) COOLANT: Flood	T1 D1 L1 TYPE: face mill DIAMETER: 40mm LENGTH: 48mm FLUTES: 6 DESCRIPTION: CoroMill 490 square VENDOR: Sandvik PRODUCT: 490-040C4-08H	
Operation 4/19 DESCRIPTION: Sgrossatura 4 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEP OVER: 28mm	MAXIMUM SPINDLE SPEED: 2470rpm MAXIMUM FEEDRATE: 3125mm/min CUTTING DISTANCE: 470.72mm RAPID DISTANCE: 26mm ESTIMATED CYCLE TIME: 10s (2%) COOLANT: Flood	T1 D1 L1 TYPE: face mill DIAMETER: 40mm LENGTH: 48mm FLUTES: 6 DESCRIPTION: CoroMill 490 square VENDOR: Sandvik PRODUCT: 490-040C4-08H	
Operation 5/19 DESCRIPTION: Sgrossatura 5 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEP OVER: 28mm	MAXIMUM SPINDLE SPEED: 2470rpm MAXIMUM FEEDRATE: 3125mm/min CUTTING DISTANCE: 470.72mm RAPID DISTANCE: 26mm ESTIMATED CYCLE TIME: 10s (2%) COOLANT: Flood	T1 D1 L1 TYPE: face mill DIAMETER: 40mm LENGTH: 48mm FLUTES: 6 DESCRIPTION: CoroMill 490 square VENDOR: Sandvik PRODUCT: 490-040C4-08H	
Operation 6/19 DESCRIPTION: Tasca 1 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEP OVER: 5.71mm	MAXIMUM SPINDLE SPEED: 7990rpm MAXIMUM FEEDRATE: 2356mm/min CUTTING DISTANCE: 271.63mm RAPID DISTANCE: 313.54mm ESTIMATED CYCLE TIME: 12s (2.5%) COOLANT: Flood	T2 D2 L2 TYPE: flat end mill DIAMETER: 9.53mm LENGTH: 31.75mm FLUTES: 4 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: 2F342-0953-PD P2BM	
Operation 7/19 DESCRIPTION: Contornatura 1 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEP DOWN: 11.5mm MAXIMUM STEP OVER: 14.25mm	MAXIMUM SPINDLE SPEED: 4300rpm MAXIMUM FEEDRATE: 1840mm/min CUTTING DISTANCE: 2158.91mm RAPID DISTANCE: 96.6mm ESTIMATED CYCLE TIME: 1m:16s (16.3%) COOLANT: Flood	T3 D3 L3 TYPE: bullnose end mill DIAMETER: 16mm CORNER RADIUS: 0.5mm LENGTH: 42mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: 2F342-1600-050-PD P2BM	
Operation 8/19 DESCRIPTION: Foratura 1 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 8035rpm MAXIMUM FEEDRATE: 1245.2mm/min CUTTING DISTANCE: 31.24mm RAPID DISTANCE: 261.24mm ESTIMATED CYCLE TIME: 5s (1%) COOLANT: Flood	T20 D20 L20 TYPE: drill DIAMETER: 4.2mm TIP ANGLE: 147° LENGTH: 73.3mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-0420-027A0-PM P1BM	
Operation 9/19 DESCRIPTION: Foratura 2 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 3350rpm MAXIMUM FEEDRATE: 862.3mm/min CUTTING DISTANCE: 32.8mm RAPID DISTANCE: 62.8mm ESTIMATED CYCLE TIME: 3s (0.6%) COOLANT: Flood	T21 D21 L21 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 161mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM	
Operation 10/19 DESCRIPTION: Foratura 3 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1200rpm MAXIMUM FEEDRATE: 270mm/min CUTTING DISTANCE: 9mm RAPID DISTANCE: 41mm ESTIMATED CYCLE TIME: 2s (0.5%) COOLANT: Flood	T22 D22 L22 TYPE: face mill DIAMETER: 40mm LENGTH: 112.29mm FLUTES: 6 DESCRIPTION: CoroDrill 880 VENDOR: Sandvik PRODUCT: 880-D4000L40-02	
Operation 11/19 DESCRIPTION: Foratura 4 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 5000rpm MAXIMUM FEEDRATE: 333.333mm/min CUTTING DISTANCE: 92mm RAPID DISTANCE: 134mm ESTIMATED CYCLE TIME: 18s (3.9%) COOLANT: Flood	T23 D23 L23 TYPE: face mill DIAMETER: 35mm LENGTH: 134.37mm FLUTES: 6 DESCRIPTION: CoroDrill® 880 VENDOR: Sandvik PRODUCT: 880-D3500L40-03	
Operation 12/19 DESCRIPTION: Foratura 5 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 6750rpm MAXIMUM FEEDRATE: 1160mm/min CUTTING DISTANCE: 15.53mm RAPID DISTANCE: 100.03mm ESTIMATED CYCLE TIME: 2s (0.4%) COOLANT: Flood	T24 D24 L24 TYPE: drill DIAMETER: 5mm TIP ANGLE: 147° LENGTH: 81.2mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-0500-037A0-PM P1BM	
Operation 13/19 DESCRIPTION: Foratura 6 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 7497rpm MAXIMUM FEEDRATE: 1165mm/min CUTTING DISTANCE: 13.6mm RAPID DISTANCE: 117.92mm ESTIMATED CYCLE TIME: 2s (0.5%) COOLANT: Flood	T25 D25 L25 TYPE: drill DIAMETER: 4.5mm TIP ANGLE: 147° LENGTH: 73.2mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-0450-027A0-PM P1BM	

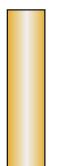
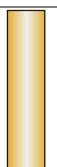
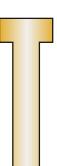
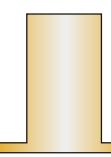
Operation 14/19 DESCRIPTION: Filettatura 1 STRATEGY: Thread WCS: #1 STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 5000rpm MAXIMUM FEEDRATE: 1000mm/min CUTTING DISTANCE: 21.4mm RAPID DISTANCE: 269.2mm ESTIMATED CYCLE TIME: 5s (1%) COOLANT: Flood	T32 D32 L32 TYPE: thread mill DIAMETER: 4.2mm LENGTH: 70mm FLUTES: 2 DESCRIPTION: CoroTap 300 VENDOR: Sandvik PRODUCT: T300-PM104DA-M5 P1PM	
Operation 15/19 DESCRIPTION: Filettatura 2 STRATEGY: Thread WCS: #1 STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 5000rpm MAXIMUM FEEDRATE: 1000mm/min CUTTING DISTANCE: 10.07mm RAPID DISTANCE: 104.25mm ESTIMATED CYCLE TIME: 2s (0.4%) COOLANT: Flood	T33 D33 L33 TYPE: thread mill DIAMETER: 5mm LENGTH: 80mm FLUTES: 2 DESCRIPTION: CoroTap 300 VENDOR: Sandvik PRODUCT: T300-PM104DA-M6 P1PM	
Operation 16/19 DESCRIPTION: Smussatura 1 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 132.89mm RAPID DISTANCE: 35.4mm ESTIMATED CYCLE TIME: 6s (1.3%) COOLANT: Flood	T4 D4 L4 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 25mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA 1620	
Operation 17/19 DESCRIPTION: Smussatura 2 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.5mm MAXIMUM STEPOVER: 4.37mm	MAXIMUM SPINDLE SPEED: 7000rpm MAXIMUM FEEDRATE: 1000mm/min CUTTING DISTANCE: 212.35mm RAPID DISTANCE: 71.63mm ESTIMATED CYCLE TIME: 15s (3.2%) COOLANT: Flood	T5 D5 L5 TYPE: face mill DIAMETER: 4.6mm TAPER ANGLE: 45° LENGTH: 15mm FLUTES: 3 DESCRIPTION: CoroMill 326 VENDOR: Sandvik PRODUCT: A326R06-M1502006-CH 1025	
Operation 18/19 DESCRIPTION: Finitura 1 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 20mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 104.63mm RAPID DISTANCE: 213.99mm ESTIMATED CYCLE TIME: 13s (2.8%) COOLANT: Flood	T6 D6 L6 TYPE: flat end mill DIAMETER: 6mm LENGTH: 28.8mm FLUTES: 7 DESCRIPTION: CoroMill dura VENDOR: Sandvik PRODUCT: 1K377-0600-050-XD 1730	
Operation 19/19 DESCRIPTION: Finitura 2 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 3.6mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 60.9mm RAPID DISTANCE: 56.4mm ESTIMATED CYCLE TIME: 6s (1.3%) COOLANT: Flood	T6 D6 L6 TYPE: flat end mill DIAMETER: 6mm LENGTH: 28.8mm FLUTES: 7 DESCRIPTION: CoroMill dura VENDOR: Sandvik PRODUCT: 1K377-0600-050-XD 1730	

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Setup Sheet for Program 1002

JOB DESCRIPTION: Setup2
 DOCUMENT PATH: progetto 2023 v1

Setup	
WCS: #1 STOCK: DX: 244mm DY: 85mm DZ: 120mm PART: DX: 234mm DY: 75mm DZ: 110mm STOCK LOWER IN WCS #1: X: -244mm Y: 0mm Z: -120mm STOCK UPPER IN WCS #1: X: 0mm Y: 85mm Z: 0mm	
Total	
NUMBER OF OPERATIONS: 54 NUMBER OF TOOLS: 25 TOOLS: T1 T2 T4 T6 T7 T8 T9 T10 T11 T12 T13 T14 T15 T16 T17 T18 T21 T24 T26 T27 T28 T29 T30 T31 T33 MAXIMUM FEEDRATE: 15000mm/min MAXIMUM SPINDLE SPEED: 8053rpm CUTTING DISTANCE: 22037.37mm RAPID DISTANCE: 17529.53mm ESTIMATED CYCLE TIME: 35m:9s	
Tools	
T1 D1 L1 TYPE: face mill DIAMETER: 40mm LENGTH: 48mm FLUTES: 6 DESCRIPTION: CoroMill 490 square VENDOR: Sandvik PRODUCT: 490-040C4-08H	 MAXIMUM FEED: 3110mm/min MAXIMUM SPINDLE SPEED: 2500rpm CUTTING DISTANCE: 2511.83mm RAPID DISTANCE: 78mm ESTIMATED CYCLE TIME: 50s (2.4%)
T2 D2 L2 TYPE: flat end mill DIAMETER: 9.53mm LENGTH: 31.75mm FLUTES: 4 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: 2F342-0953-PD P2BM	 MAXIMUM FEED: 2350mm/min MAXIMUM SPINDLE SPEED: 8053rpm CUTTING DISTANCE: 2393.42mm RAPID DISTANCE: 445.19mm ESTIMATED CYCLE TIME: 1m:45s (5%)
T4 D4 L4 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 25mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA 1620	 MAXIMUM FEED: 15000mm/min MAXIMUM SPINDLE SPEED: 7960rpm CUTTING DISTANCE: 1056.84mm RAPID DISTANCE: 678.9mm ESTIMATED CYCLE TIME: 1m:14s (3.5%)
T6 D6 L6 TYPE: flat end mill DIAMETER: 6mm LENGTH: 28.8mm FLUTES: 7 DESCRIPTION: CoroMill dura VENDOR: Sandvik PRODUCT: 1K377-0600-050-XD 1730	 MAXIMUM FEED: 1500mm/min MAXIMUM SPINDLE SPEED: 7960rpm CUTTING DISTANCE: 188.49mm RAPID DISTANCE: 103.75mm ESTIMATED CYCLE TIME: 14s (0.7%)
T7 D7 L7 TYPE: face mill DIAMETER: 40mm LENGTH: 40mm FLUTES: 6 DESCRIPTION: CoroMill 490 VENDOR: Sandvik PRODUCT: 490-040A32-14M	 MAXIMUM FEED: 1660mm/min MAXIMUM SPINDLE SPEED: 2070rpm CUTTING DISTANCE: 3221.61mm RAPID DISTANCE: 3224.97mm ESTIMATED CYCLE TIME: 3m:9s (9%)
T8 D8 L8 TYPE: flat end mill DIAMETER: 25mm LENGTH: 63mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: 2N342-2500-PD P2BM	 MAXIMUM FEED: 1290mm/min MAXIMUM SPINDLE SPEED: 2600rpm CUTTING DISTANCE: 4945.95mm RAPID DISTANCE: 4827.77mm ESTIMATED CYCLE TIME: 5m:58s (17%)

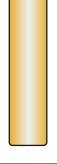
T9 D9 L9 TYPE: bullnose end mill DIAMETER: 12mm CORNER RADIUS: 0.5mm LENGTH: 36mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: 2F342-1200-050-PD P2BM	MAXIMUM FEED: 3216mm/min MAXIMUM SPINDLE SPEED: 6850rpm CUTTING DISTANCE: 1832.13mm RAPID DISTANCE: 614.62mm ESTIMATED CYCLE TIME: 1m:10s (3.3%)	
T10 D10 L10 TYPE: ball end mill DIAMETER: 6mm CORNER RADIUS: 3mm LENGTH: 30mm FLUTES: 2 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: R216.62-06030-A007G 1610	MAXIMUM FEED: 1500mm/min MAXIMUM SPINDLE SPEED: 7960rpm CUTTING DISTANCE: 783.42mm RAPID DISTANCE: 744.32mm ESTIMATED CYCLE TIME: 2m:5s (5.9%)	
T11 D11 L11 TYPE: flat end mill DIAMETER: 12mm LENGTH: 36mm FLUTES: 4 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: 2F342-1200-050-PD P2BM	MAXIMUM FEED: 1780mm/min MAXIMUM SPINDLE SPEED: 6850rpm CUTTING DISTANCE: 70mm RAPID DISTANCE: 219.8mm ESTIMATED CYCLE TIME: 5s (0.3%)	
T12 D12 L12 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 60mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1K334-2000-300-XD 1730	MAXIMUM FEED: 963mm/min MAXIMUM SPINDLE SPEED: 3060rpm CUTTING DISTANCE: 355.1mm RAPID DISTANCE: 119mm ESTIMATED CYCLE TIME: 46s (2.2%)	
T13 D13 L13 TYPE: bullnose end mill DIAMETER: 12mm CORNER RADIUS: 1mm LENGTH: 53mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: R216.24-12050CCK26P 1620	MAXIMUM FEED: 730mm/min MAXIMUM SPINDLE SPEED: 3980rpm CUTTING DISTANCE: 3045.27mm RAPID DISTANCE: 3120.68mm ESTIMATED CYCLE TIME: 7m:14s (20.6%)	
T14 D14 L14 TYPE: flat end mill DIAMETER: 20mm LENGTH: 90mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730	MAXIMUM FEED: 5700mm/min MAXIMUM SPINDLE SPEED: 3870rpm CUTTING DISTANCE: 425.61mm RAPID DISTANCE: 504.48mm ESTIMATED CYCLE TIME: 16s (0.8%)	
T15 D15 L15 TYPE: bullnose end mill DIAMETER: 3mm CORNER RADIUS: 0.2mm LENGTH: 17.4mm FLUTES: 5 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1K365-0300-020-XC 1730	MAXIMUM FEED: 796mm/min MAXIMUM SPINDLE SPEED: 7960rpm CUTTING DISTANCE: 308.74mm RAPID DISTANCE: 251.92mm ESTIMATED CYCLE TIME: 41s (2%)	
T16 D16 L16 TYPE: slot mill DIAMETER: 21.7mm LENGTH: 22.3mm FLUTES: 3 DESCRIPTION: CoroMill 327 VENDOR: Sandvik PRODUCT: 327-16B24SC-12 ; 327R12-22 16000-GM 1025	MAXIMUM FEED: 1500mm/min MAXIMUM SPINDLE SPEED: 2200rpm CUTTING DISTANCE: 205.17mm RAPID DISTANCE: 114.6mm ESTIMATED CYCLE TIME: 10s (0.5%)	
T17 D17 L17 TYPE: slot mill DIAMETER: 9.7mm LENGTH: 23.23mm FLUTES: 3 DESCRIPTION: CoroMill 327 VENDOR: Sandvik PRODUCT: 327-12B21EC-06 ; 327R06-10 10000-GM 1025	MAXIMUM FEED: 2000mm/min MAXIMUM SPINDLE SPEED: 6565rpm CUTTING DISTANCE: 91.85mm RAPID DISTANCE: 209mm ESTIMATED CYCLE TIME: 6s (0.3%)	
T18 D18 L18 TYPE: dovetail mill DIAMETER: 11.7mm TAPER ANGLE: 45° LENGTH: 23.23mm FLUTES: 3 DESCRIPTION: T0404 VENDOR: Sandvik PRODUCT: 327R06-12 12045-CH 1025 ; 327-12B21EC-06	MAXIMUM FEED: 1000mm/min MAXIMUM SPINDLE SPEED: 5440rpm CUTTING DISTANCE: 77.55mm RAPID DISTANCE: 223.55mm ESTIMATED CYCLE TIME: 8s (0.4%)	

T21 D21 L21 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 161mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM	MAXIMUM FEED: 1000mm/min MAXIMUM SPINDLE SPEED: 3350rpm CUTTING DISTANCE: 94.06mm RAPID DISTANCE: 369.06mm ESTIMATED CYCLE TIME: 11s (0.5%)	
T24 D24 L24 TYPE: drill DIAMETER: 5mm TIP ANGLE: 147° LENGTH: 81.2mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-0500-037A0-PM P1BM	MAXIMUM FEED: 1000mm/min MAXIMUM SPINDLE SPEED: 6750rpm CUTTING DISTANCE: 147.99mm RAPID DISTANCE: 408.16mm ESTIMATED CYCLE TIME: 14s (0.7%)	
T26 D26 L26 TYPE: drill DIAMETER: 3mm TIP ANGLE: 140° LENGTH: 64.45mm FLUTES: 2 DESCRIPTION: CoroDrill 862-GM VENDOR: Sandvik PRODUCT: 862.1-3000-270A0-GM X2BL	MAXIMUM FEED: 240mm/min MAXIMUM SPINDLE SPEED: 4850rpm CUTTING DISTANCE: 13.5mm RAPID DISTANCE: 43.5mm ESTIMATED CYCLE TIME: 4s (0.2%)	
T27 D27 L27 TYPE: drill DIAMETER: 18mm TIP ANGLE: 147° LENGTH: 120.2mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-1800-050A1-PM P1BM	MAXIMUM FEED: 1000mm/min MAXIMUM SPINDLE SPEED: 2192rpm CUTTING DISTANCE: 16mm RAPID DISTANCE: 108mm ESTIMATED CYCLE TIME: 2s (0.1%)	
T28 D28 L28 TYPE: drill DIAMETER: 16mm TIP ANGLE: 147° LENGTH: 112.5mm FLUTES: 2 DESCRIPTION: CoroDrill® 860-PM VENDOR: Sandvik PRODUCT: 860.1-1600-044A1-PM P1BM	MAXIMUM FEED: 1000mm/min MAXIMUM SPINDLE SPEED: 2467rpm CUTTING DISTANCE: 35mm RAPID DISTANCE: 147mm ESTIMATED CYCLE TIME: 4s (0.2%)	
T29 D29 L29 TYPE: drill DIAMETER: 20mm TIP ANGLE: 147° LENGTH: 127.9mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-2000-055A1-PM P1BM	MAXIMUM FEED: 1000mm/min MAXIMUM SPINDLE SPEED: 1974rpm CUTTING DISTANCE: 62.14mm RAPID DISTANCE: 154.14mm ESTIMATED CYCLE TIME: 6s (0.3%)	
T30 D30 L30 TYPE: drill DIAMETER: 14mm TIP ANGLE: 147° LENGTH: 134mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-1400-115A1-PM P1BM	MAXIMUM FEED: 1285mm/min MAXIMUM SPINDLE SPEED: 3900rpm CUTTING DISTANCE: 25.96mm RAPID DISTANCE: 288.04mm ESTIMATED CYCLE TIME: 5s (0.2%)	
T31 D31 L31 TYPE: face mill DIAMETER: 45mm LENGTH: 126.23mm FLUTES: 6 DESCRIPTION: corodrill 880 VENDOR: Sandvik PRODUCT: 880-D4500L40-02	MAXIMUM FEED: 245mm/min MAXIMUM SPINDLE SPEED: 1060rpm CUTTING DISTANCE: 14mm RAPID DISTANCE: 62mm ESTIMATED CYCLE TIME: 4s (0.2%)	
T33 D33 L33 TYPE: thread mill DIAMETER: 5mm LENGTH: 80mm FLUTES: 2 DESCRIPTION: CoroTap 300 VENDOR: Sandvik PRODUCT: T300-PM104DA-M6 P1PM	MAXIMUM FEED: 1000mm/min MAXIMUM SPINDLE SPEED: 5000rpm CUTTING DISTANCE: 115.76mm RAPID DISTANCE: 469.07mm ESTIMATED CYCLE TIME: 13s (0.6%)	

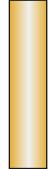
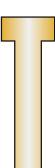
Operations

Operation 1/54 DESCRIPTION: Sgrossatura 6 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 28mm	MAXIMUM SPINDLE SPEED: 2500rpm MAXIMUM FEEDRATE: 3110mm/min CUTTING DISTANCE: 1257.29mm RAPID DISTANCE: 26mm ESTIMATED CYCLE TIME: 25s (1.2%) COOLANT: Flood	T1 D1 L1 TYPE: face mill DIAMETER: 40mm LENGTH: 48mm FLUTES: 6 DESCRIPTION: CoroMill 490 square VENDOR: Sandvik PRODUCT: 490-040C4-08H
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Operation 2/54 DESCRIPTION: Sgrossatura 7 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 28mm	MAXIMUM SPINDLE SPEED: 2470rpm MAXIMUM FEEDRATE: 3080mm/min CUTTING DISTANCE: 627.33mm RAPID DISTANCE: 26mm ESTIMATED CYCLE TIME: 13s (0.6%) COOLANT: Flood	T1 D1 L1 TYPE: face mill DIAMETER: 40mm LENGTH: 48mm FLUTES: 6 DESCRIPTION: CoroMill 490 square VENDOR: Sandvik PRODUCT: 490-040C4-08H	
Operation 3/54 DESCRIPTION: Sgrossatura 8 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 28mm	MAXIMUM SPINDLE SPEED: 2470rpm MAXIMUM FEEDRATE: 3080mm/min CUTTING DISTANCE: 627.21mm RAPID DISTANCE: 26mm ESTIMATED CYCLE TIME: 13s (0.6%) COOLANT: Flood	T1 D1 L1 TYPE: face mill DIAMETER: 40mm LENGTH: 48mm FLUTES: 6 DESCRIPTION: CoroMill 490 square VENDOR: Sandvik PRODUCT: 490-040C4-08H	
Operation 4/54 DESCRIPTION: Sgrossatura 9 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8.25mm MAXIMUM STEPOVER: 24mm	MAXIMUM SPINDLE SPEED: 2070rpm MAXIMUM FEEDRATE: 1660mm/min CUTTING DISTANCE: 2120.74mm RAPID DISTANCE: 2131.28mm ESTIMATED CYCLE TIME: 2m:1s (5.7%) COOLANT: Flood	T7 D7 L7 TYPE: face mill DIAMETER: 40mm LENGTH: 40mm FLUTES: 6 DESCRIPTION: CoroMill 490 VENDOR: Sandvik PRODUCT: 490-040A32-14M	
Operation 5/54 DESCRIPTION: Spallamento 1 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 24mm	MAXIMUM SPINDLE SPEED: 1591rpm MAXIMUM FEEDRATE: 1275mm/min CUTTING DISTANCE: 1100.87mm RAPID DISTANCE: 1093.69mm ESTIMATED CYCLE TIME: 1m:8s (3.2%) COOLANT: Flood	T7 D7 L7 TYPE: face mill DIAMETER: 40mm LENGTH: 40mm FLUTES: 6 DESCRIPTION: CoroMill 490 VENDOR: Sandvik PRODUCT: 490-040A32-14M	
Operation 6/54 DESCRIPTION: Spallamento 2 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 11.67mm MAXIMUM STEPOVER: 15mm	MAXIMUM SPINDLE SPEED: 2600rpm MAXIMUM FEEDRATE: 1265mm/min CUTTING DISTANCE: 3400.15mm RAPID DISTANCE: 3973.16mm ESTIMATED CYCLE TIME: 4m:28s (12.7%) COOLANT: Flood	T8 D8 L8 TYPE: flat end mill DIAMETER: 25mm LENGTH: 63mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: 2N342-2500-PD P2BM	
Operation 7/54 DESCRIPTION: Spallamento 3 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 10.5mm MAXIMUM STEPOVER: 15mm	MAXIMUM SPINDLE SPEED: 2320rpm MAXIMUM FEEDRATE: 1290mm/min CUTTING DISTANCE: 1545.8mm RAPID DISTANCE: 854.6mm ESTIMATED CYCLE TIME: 1m:30s (4.3%) COOLANT: Flood	T8 D8 L8 TYPE: flat end mill DIAMETER: 25mm LENGTH: 63mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: 2N342-2500-PD P2BM	
Operation 8/54 DESCRIPTION: Foratura 7 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 4850rpm MAXIMUM FEEDRATE: 240mm/min CUTTING DISTANCE: 13.5mm RAPID DISTANCE: 43.5mm ESTIMATED CYCLE TIME: 4s (0.2%) COOLANT: Flood	T26 D26 L26 TYPE: drill DIAMETER: 3mm TIP ANGLE: 140° LENGTH: 64.45mm FLUTES: 2 DESCRIPTION: CoroDrill 862-GM VENDOR: Sandvik PRODUCT: 862.1-3000-270A0-GM X2BL	
Operation 9/54 DESCRIPTION: Foratura 8 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 6750rpm MAXIMUM FEEDRATE: 1000mm/min CUTTING DISTANCE: 20.5mm RAPID DISTANCE: 51mm ESTIMATED CYCLE TIME: 2s (0.1%) COOLANT: Flood	T24 D24 L24 TYPE: drill DIAMETER: 5mm TIP ANGLE: 147° LENGTH: 81.2mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-0500-037A0-PM P1BM	
Operation 10/54 DESCRIPTION: Foratura 9 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 6750rpm MAXIMUM FEEDRATE: 1000mm/min CUTTING DISTANCE: 127.49mm RAPID DISTANCE: 357.16mm ESTIMATED CYCLE TIME: 12s (0.6%) COOLANT: Flood	T24 D24 L24 TYPE: drill DIAMETER: 5mm TIP ANGLE: 147° LENGTH: 81.2mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-0500-037A0-PM P1BM	
Operation 11/54 DESCRIPTION: Spallamento 4 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 7.2mm	MAXIMUM SPINDLE SPEED: 6025rpm MAXIMUM FEEDRATE: 2175mm/min CUTTING DISTANCE: 189.68mm RAPID DISTANCE: 218.47mm ESTIMATED CYCLE TIME: 11s (0.5%) COOLANT: Flood	T9 D9 L9 TYPE: bullnose end mill DIAMETER: 12mm CORNER RADIUS: 0.5mm LENGTH: 36mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: 2F342-1200-050-PD P2BM	
Operation 12/54 DESCRIPTION: Spallamento 5 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 17.5mm MAXIMUM STEPOVER: 7.2mm	MAXIMUM SPINDLE SPEED: 6025rpm MAXIMUM FEEDRATE: 2175mm/min CUTTING DISTANCE: 872mm RAPID DISTANCE: 220.95mm ESTIMATED CYCLE TIME: 29s (1.4%) COOLANT: Flood	T9 D9 L9 TYPE: bullnose end mill DIAMETER: 12mm CORNER RADIUS: 0.5mm LENGTH: 36mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: 2F342-1200-050-PD P2BM	

Operation 13/54 DESCRIPTION: Spallamento 6 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEP OVER: 7.2mm	MAXIMUM SPINDLE SPEED: 5385rpm MAXIMUM FEEDRATE: 1680mm/min CUTTING DISTANCE: 253.75mm RAPID DISTANCE: 37.3mm ESTIMATED CYCLE TIME: 11s (0.5%) COOLANT: Flood	T9 D9 L9 TYPE: bullnose end mill DIAMETER: 12mm CORNER RADIUS: 0.5mm LENGTH: 36mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: 2F342-1200-050-PD P2BM	
Operation 14/54 DESCRIPTION: Spallamento 7 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEP OVER: 7.2mm	MAXIMUM SPINDLE SPEED: 5385rpm MAXIMUM FEEDRATE: 1680mm/min CUTTING DISTANCE: 256.13mm RAPID DISTANCE: 37.3mm ESTIMATED CYCLE TIME: 11s (0.5%) COOLANT: Flood	T9 D9 L9 TYPE: bullnose end mill DIAMETER: 12mm CORNER RADIUS: 0.5mm LENGTH: 36mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: 2F342-1200-050-PD P2BM	
Operation 15/54 DESCRIPTION: Spallamento 8 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEP OVER: 7.2mm	MAXIMUM SPINDLE SPEED: 6850rpm MAXIMUM FEEDRATE: 3216mm/min CUTTING DISTANCE: 135.46mm RAPID DISTANCE: 50.3mm ESTIMATED CYCLE TIME: 4s (0.2%) COOLANT: Flood	T9 D9 L9 TYPE: bullnose end mill DIAMETER: 12mm CORNER RADIUS: 0.5mm LENGTH: 36mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: 2F342-1200-050-PD P2BM	
Operation 16/54 DESCRIPTION: Spallamento 9 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEP OVER: 7.2mm	MAXIMUM SPINDLE SPEED: 6850rpm MAXIMUM FEEDRATE: 3216mm/min CUTTING DISTANCE: 125.1mm RAPID DISTANCE: 50.3mm ESTIMATED CYCLE TIME: 4s (0.2%) COOLANT: Flood	T9 D9 L9 TYPE: bullnose end mill DIAMETER: 12mm CORNER RADIUS: 0.5mm LENGTH: 36mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: 2F342-1200-050-PD P2BM	
Operation 17/54 DESCRIPTION: Spallamento 10 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEP OVER: 5.71mm	MAXIMUM SPINDLE SPEED: 6500rpm MAXIMUM FEEDRATE: 1700mm/min CUTTING DISTANCE: 596.28mm RAPID DISTANCE: 36.5mm ESTIMATED CYCLE TIME: 22s (1%) COOLANT: Flood	T2 D2 L2 TYPE: flat end mill DIAMETER: 9.53mm LENGTH: 31.75mm FLUTES: 4 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: 2F342-0953-PD P2BM	
Operation 18/54 DESCRIPTION: Spallamento 11 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEP OVER: 5.71mm	MAXIMUM SPINDLE SPEED: 6500rpm MAXIMUM FEEDRATE: 1700mm/min CUTTING DISTANCE: 596.33mm RAPID DISTANCE: 36.5mm ESTIMATED CYCLE TIME: 22s (1%) COOLANT: Flood	T2 D2 L2 TYPE: flat end mill DIAMETER: 9.53mm LENGTH: 31.75mm FLUTES: 4 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: 2F342-0953-PD P2BM	
Operation 19/54 DESCRIPTION: Finitura retro STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 7mm MAXIMUM STEP OVER: 1.2mm	MAXIMUM SPINDLE SPEED: 7430rpm MAXIMUM FEEDRATE: 1200mm/min CUTTING DISTANCE: 366.56mm RAPID DISTANCE: 357.42mm ESTIMATED CYCLE TIME: 32s (1.5%) COOLANT: Flood	T10 D10 L10 TYPE: ball end mill DIAMETER: 6mm CORNER RADIUS: 3mm LENGTH: 30mm FLUTES: 2 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: R216.62-06030-AO07G_1610	
Operation 20/54 DESCRIPTION: Tasca 2 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEP OVER: 7.2mm	MAXIMUM SPINDLE SPEED: 6850rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 70mm RAPID DISTANCE: 219.8mm ESTIMATED CYCLE TIME: 5s (0.3%) COOLANT: Flood	T11 D11 L11 TYPE: flat end mill DIAMETER: 12mm LENGTH: 36mm FLUTES: 4 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: 2F342-1200-050-PD P2BM	
Operation 21/54 DESCRIPTION: Spallamento 12 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEP OVER: 12mm	MAXIMUM SPINDLE SPEED: 3060rpm MAXIMUM FEEDRATE: 963mm/min CUTTING DISTANCE: 355.1mm RAPID DISTANCE: 119mm ESTIMATED CYCLE TIME: 46s (2.2%) COOLANT: Flood	T12 D12 L12 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 60mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1K334-2000-300-XD 1730	
Operation 22/54 DESCRIPTION: Spallamento 13 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 13mm MAXIMUM STEP OVER: 7.2mm	MAXIMUM SPINDLE SPEED: 3980rpm MAXIMUM FEEDRATE: 500mm/min CUTTING DISTANCE: 2133.41mm RAPID DISTANCE: 1922.98mm ESTIMATED CYCLE TIME: 5m:36s (15.9%) COOLANT: Flood	T13 D13 L13 TYPE: bullnose end mill DIAMETER: 12mm CORNER RADIUS: 1mm LENGTH: 53mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: R216.24-12050CCK26P_1620	

Operation 23/54 DESCRIPTION: Foratura 10 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 2192rpm MAXIMUM FEEDRATE: 1000mm/min CUTTING DISTANCE: 16mm RAPID DISTANCE: 108mm ESTIMATED CYCLE TIME: 2s (0.1%) COOLANT: Flood	T27 D27 L27 TYPE: drill DIAMETER: 18mm TIP ANGLE: 147° LENGTH: 120.2mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-1800-050A1-PM P1BM	
Operation 24/54 DESCRIPTION: Foratura 11 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 3350rpm MAXIMUM FEEDRATE: 1000mm/min CUTTING DISTANCE: 24.06mm RAPID DISTANCE: 256.06mm ESTIMATED CYCLE TIME: 5s (0.2%) COOLANT: Flood	T21 D21 L21 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 161mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM	
Operation 25/54 DESCRIPTION: Foratura 12 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 2467rpm MAXIMUM FEEDRATE: 1000mm/min CUTTING DISTANCE: 35mm RAPID DISTANCE: 147mm ESTIMATED CYCLE TIME: 4s (0.2%) COOLANT: Flood	T28 D28 L28 TYPE: drill DIAMETER: 16mm TIP ANGLE: 147° LENGTH: 112.5mm FLUTES: 2 DESCRIPTION: CoroDrill® 860-PM VENDOR: Sandvik PRODUCT: 860.1-1600-044A1-PM P1BM	
Operation 26/54 DESCRIPTION: Foratura 13 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 3350rpm MAXIMUM FEEDRATE: 865mm/min CUTTING DISTANCE: 70mm RAPID DISTANCE: 113mm ESTIMATED CYCLE TIME: 6s (0.3%) COOLANT: Flood	T21 D21 L21 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 161mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM	
Operation 27/54 DESCRIPTION: Tasca 3 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.71mm	MAXIMUM SPINDLE SPEED: 6820rpm MAXIMUM FEEDRATE: 1770mm/min CUTTING DISTANCE: 295.98mm RAPID DISTANCE: 93mm ESTIMATED CYCLE TIME: 21s (1%) COOLANT: Flood	T2 D2 L2 TYPE: flat end mill DIAMETER: 9.53mm LENGTH: 31.75mm FLUTES: 4 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: 2F342-0953-PD P2BM	
Operation 28/54 DESCRIPTION: Foratura 14 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1974rpm MAXIMUM FEEDRATE: 1000mm/min CUTTING DISTANCE: 62.14mm RAPID DISTANCE: 154.14mm ESTIMATED CYCLE TIME: 6s (0.3%) COOLANT: Flood	T29 D29 L29 TYPE: drill DIAMETER: 20mm TIP ANGLE: 147° LENGTH: 127.9mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-2000-055A1-PM P1BM	
Operation 29/54 DESCRIPTION: Foratura 15 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 3900rpm MAXIMUM FEEDRATE: 1285mm/min CUTTING DISTANCE: 25.96mm RAPID DISTANCE: 288.04mm ESTIMATED CYCLE TIME: 5s (0.2%) COOLANT: Flood	T30 D30 L30 TYPE: drill DIAMETER: 14mm TIP ANGLE: 147° LENGTH: 134mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-1400-115A1-PM P1BM	
Operation 30/54 DESCRIPTION: Foratura 16 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1060rpm MAXIMUM FEEDRATE: 245mm/min CUTTING DISTANCE: 14mm RAPID DISTANCE: 62mm ESTIMATED CYCLE TIME: 4s (0.2%) COOLANT: Flood	T31 D31 L31 TYPE: face mill DIAMETER: 45mm LENGTH: 126.23mm FLUTES: 6 DESCRIPTION: corodrill 880 VENDOR: Sandvik PRODUCT: 880-D4500L40-02	
Operation 31/54 DESCRIPTION: Spallamento 14 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 7.2mm	MAXIMUM SPINDLE SPEED: 3600rpm MAXIMUM FEEDRATE: 730mm/min CUTTING DISTANCE: 911.86mm RAPID DISTANCE: 1197.7mm ESTIMATED CYCLE TIME: 1m:38s (4.6%) COOLANT: Flood	T13 D13 L13 TYPE: bullnose end mill DIAMETER: 12mm CORNER RADIUS: 1mm LENGTH: 53mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: R216.24-12050CCK26P 1620	
Operation 32/54 DESCRIPTION: Spallamento 15 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 9.05mm	MAXIMUM SPINDLE SPEED: 6720rpm MAXIMUM FEEDRATE: 2350mm/min CUTTING DISTANCE: 130.43mm RAPID DISTANCE: 48.55mm ESTIMATED CYCLE TIME: 5s (0.3%) COOLANT: Flood	T2 D2 L2 TYPE: flat end mill DIAMETER: 9.53mm LENGTH: 31.75mm FLUTES: 4 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: 2F342-0953-PD P2BM	

Operation 33/54 DESCRIPTION: Spallamento 16 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 9.05mm	MAXIMUM SPINDLE SPEED: 6720rpm MAXIMUM FEEDRATE: 2350mm/min CUTTING DISTANCE: 130.43mm RAPID DISTANCE: 48.55mm ESTIMATED CYCLE TIME: 5s (0.3%) COOLANT: Flood	T2 D2 L2 TYPE: flat end mill DIAMETER: 9.53mm LENGTH: 31.75mm FLUTES: 4 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: 2F342-0953-PD P2BM	
Operation 34/54 DESCRIPTION: Finitura frontale STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 7mm MAXIMUM STEPOVER: 1.2mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 318mm/min CUTTING DISTANCE: 234mm RAPID DISTANCE: 258mm ESTIMATED CYCLE TIME: 1m:21s (3.9%) COOLANT: Flood	T10 D10 L10 TYPE: ball end mill DIAMETER: 6mm CORNER RADIUS: 3mm LENGTH: 30mm FLUTES: 2 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: R216.62-06030-AO07G 1610	
Operation 35/54 DESCRIPTION: Tasca 4 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 123.05mm MAXIMUM STEPOVER: 5.71mm	MAXIMUM SPINDLE SPEED: 6850rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 223.06mm RAPID DISTANCE: 123.05mm ESTIMATED CYCLE TIME: 16s (0.8%) COOLANT: Flood	T2 D2 L2 TYPE: flat end mill DIAMETER: 9.53mm LENGTH: 31.75mm FLUTES: 4 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: 2F342-0953-PD P2BM	
Operation 36/54 DESCRIPTION: Finitura 5 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 5.71mm	MAXIMUM SPINDLE SPEED: 8053rpm MAXIMUM FEEDRATE: 2340mm/min CUTTING DISTANCE: 420.9mm RAPID DISTANCE: 59.05mm ESTIMATED CYCLE TIME: 14s (0.6%) COOLANT: Flood	T2 D2 L2 TYPE: flat end mill DIAMETER: 9.53mm LENGTH: 31.75mm FLUTES: 4 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: 2F342-0953-PD P2BM	
Operation 37/54 DESCRIPTION: Spallamento 17 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 44.5mm MAXIMUM STEPOVER: 19mm	MAXIMUM SPINDLE SPEED: 3870rpm MAXIMUM FEEDRATE: 5700mm/min CUTTING DISTANCE: 425.61mm RAPID DISTANCE: 504.48mm ESTIMATED CYCLE TIME: 16s (0.8%) COOLANT: Flood	T14 D14 L14 TYPE: flat end mill DIAMETER: 20mm LENGTH: 90mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730	
Operation 38/54 DESCRIPTION: Finitura 6 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 127.54mm MAXIMUM STEPOVER: 2.47mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 796mm/min CUTTING DISTANCE: 154.37mm RAPID DISTANCE: 127.54mm ESTIMATED CYCLE TIME: 21s (1%) COOLANT: Flood	T15 D15 L15 TYPE: bullnose end mill DIAMETER: 3mm CORNER RADIUS: 0.2mm LENGTH: 17.4mm FLUTES: 5 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1K365-0300-020-XC 1730	
Operation 39/54 DESCRIPTION: Finitura 7 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 124.39mm MAXIMUM STEPOVER: 2.47mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 796mm/min CUTTING DISTANCE: 154.37mm RAPID DISTANCE: 124.39mm ESTIMATED CYCLE TIME: 21s (1%) COOLANT: Flood	T15 D15 L15 TYPE: bullnose end mill DIAMETER: 3mm CORNER RADIUS: 0.2mm LENGTH: 17.4mm FLUTES: 5 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1K365-0300-020-XC 1730	
Operation 40/54 DESCRIPTION: Filettatura3 STRATEGY: Thread WCS: #1 STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 5000rpm MAXIMUM FEEDRATE: 1000mm/min CUTTING DISTANCE: 115.76mm RAPID DISTANCE: 469.07mm ESTIMATED CYCLE TIME: 13s (0.6%) COOLANT: Flood	T33 D33 L33 TYPE: thread mill DIAMETER: 5mm LENGTH: 80mm FLUTES: 2 DESCRIPTION: CoroTap 300 VENDOR: Sandvik PRODUCT: T300-PM104DA-M6 P1PM	
Operation 41/54 DESCRIPTION: Alesatura 1 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 1.6mm MAXIMUM STEPOVER: 20.62mm	MAXIMUM SPINDLE SPEED: 2200rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 205.17mm RAPID DISTANCE: 114.6mm ESTIMATED CYCLE TIME: 10s (0.5%) COOLANT: Flood	T16 D16 L16 TYPE: slot mill DIAMETER: 21.7mm LENGTH: 22.3mm FLUTES: 3 DESCRIPTION: CoroMill 327 VENDOR: Sandvik PRODUCT: 327-16B24SC-12 ; 327R12-22 16000-GM 1025	
Operation 42/54 DESCRIPTION: Contornatura 2D23 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 5.7mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 197.51mm RAPID DISTANCE: 73.4mm ESTIMATED CYCLE TIME: 13s (0.6%) COOLANT: Flood	T4 D4 L4 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 25mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA 1620	
Operation 43/54 DESCRIPTION: Smussatura 3 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 5.7mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 161.6mm RAPID DISTANCE: 38.4mm ESTIMATED CYCLE TIME: 1s (0.1%) COOLANT: Flood	T4 D4 L4 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 25mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA 1620	

Operation 44/54 DESCRIPTION: Smussatura 4 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 140.18mm RAPID DISTANCE: 48.4mm ESTIMATED CYCLE TIME: 8s (0.4%) COOLANT: Flood	T4 D4 L4 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 25mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA 1620	
Operation 45/54 DESCRIPTION: Smussatura 5 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 149.93mm RAPID DISTANCE: 130.4mm ESTIMATED CYCLE TIME: 16s (0.8%) COOLANT: Flood	T4 D4 L4 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 25mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA 1620	
Operation 46/54 DESCRIPTION: Smussatura 6 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 105.06mm RAPID DISTANCE: 60.4mm ESTIMATED CYCLE TIME: 8s (0.4%) COOLANT: Flood	T4 D4 L4 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 25mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA 1620	
Operation 47/54 DESCRIPTION: Smussatura 7 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 98.78mm RAPID DISTANCE: 60.4mm ESTIMATED CYCLE TIME: 8s (0.4%) COOLANT: Flood	T4 D4 L4 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 25mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA 1620	
Operation 48/54 DESCRIPTION: Alesatura 2 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 1mm MAXIMUM STEPOVER: 9.21mm	MAXIMUM SPINDLE SPEED: 6565rpm MAXIMUM FEEDRATE: 2000mm/min CUTTING DISTANCE: 91.85mm RAPID DISTANCE: 209mm ESTIMATED CYCLE TIME: 6s (0.3%) COOLANT: Flood	T17 D17 L17 TYPE: slot mill DIAMETER: 9.7mm LENGTH: 23.23mm FLUTES: 3 DESCRIPTION: CoroMill 327 VENDOR: Sandvik PRODUCT: 327-12B21EC-06 ; 327R06-10 10000-GM 1025	
Operation 49/54 DESCRIPTION: Smussatura interna STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 11.12mm	MAXIMUM SPINDLE SPEED: 5440rpm MAXIMUM FEEDRATE: 1000mm/min CUTTING DISTANCE: 77.55mm RAPID DISTANCE: 223.55mm ESTIMATED CYCLE TIME: 8s (0.4%) COOLANT: Flood	T18 D18 L18 TYPE: dovetail mill DIAMETER: 11.7mm TAPER ANGLE: 45° LENGTH: 23.23mm FLUTES: 3 DESCRIPTION: T0404 VENDOR: Sandvik PRODUCT: 327R06-12 12045-CH 1025 ; 327-12B21EC-06	
Operation 50/54 DESCRIPTION: Finitura 8 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 1.2mm	MAXIMUM SPINDLE SPEED: 7000rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 101.49mm RAPID DISTANCE: 52.5mm ESTIMATED CYCLE TIME: 7s (0.3%) COOLANT: Flood	T10 D10 L10 TYPE: ball end mill DIAMETER: 6mm CORNER RADIUS: 3mm LENGTH: 30mm FLUTES: 2 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: R216.62-06030-AO07G 1610	
Operation 51/54 DESCRIPTION: Finitura 9 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 1.2mm	MAXIMUM SPINDLE SPEED: 7000rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 81.36mm RAPID DISTANCE: 76.4mm ESTIMATED CYCLE TIME: 5s (0.2%) COOLANT: Flood	T10 D10 L10 TYPE: ball end mill DIAMETER: 6mm CORNER RADIUS: 3mm LENGTH: 30mm FLUTES: 2 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: R216.62-06030-AO07G 1610	
Operation 52/54 DESCRIPTION: Finitura 10 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 94.22mm RAPID DISTANCE: 51.85mm ESTIMATED CYCLE TIME: 7s (0.3%) COOLANT: Flood	T6 D6 L6 TYPE: flat end mill DIAMETER: 6mm LENGTH: 28.8mm FLUTES: 7 DESCRIPTION: CoroMill dura VENDOR: Sandvik PRODUCT: 1K377-0600-050-XD 1730	
Operation 53/54 DESCRIPTION: Finitura 11 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 94.27mm RAPID DISTANCE: 51.9mm ESTIMATED CYCLE TIME: 7s (0.3%) COOLANT: Flood	T6 D6 L6 TYPE: flat end mill DIAMETER: 6mm LENGTH: 28.8mm FLUTES: 7 DESCRIPTION: CoroMill dura VENDOR: Sandvik PRODUCT: 1K377-0600-050-XD 1730	

Operation 54/54

DESCRIPTION: Smussatura 9

STRATEGY: Contour 2D

WCS: #1

TOLERANCE: 0.01mm

STOCK TO LEAVE: 0mm

MAXIMUM STEPOVER: 5.7mm

MAXIMUM SPINDLE SPEED: 7960rpm

MAXIMUM FEEDRATE: 1500mm/min

CUTTING DISTANCE: 203.78mm

RAPID DISTANCE: 267.5mm

ESTIMATED CYCLE TIME: 19s (0.9%)

COOLANT: Flood

T4 D4 L4

TYPE: chamfer mill

DIAMETER: 6mm

TAPER ANGLE: 45°

LENGTH: 25mm

FLUTES: 4

DESCRIPTION: CoroMill Dura

VENDOR: Sandvik

PRODUCT: [1C050-0100-045-XA 1620](#)



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