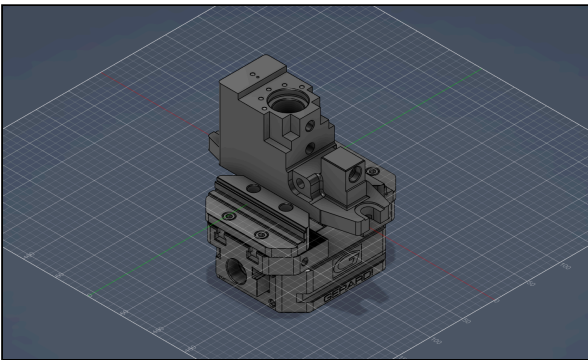






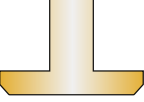

# Setup Sheet for Program 1001


JOB DESCRIPTION: Setup1

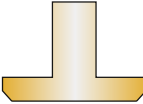
DOCUMENT PATH: Modello Fusion Gruppo 2 v1

Setup	
<b>WCS: #1</b> <b>Stock:</b> DX: 244mm DY: 85mm DZ: 120mm <b>PART:</b> DX: 234mm DY: 75mm DZ: 110mm <b>Stock Lower in WCS #1:</b> X: -244mm Y: 0mm Z: -120mm <b>Stock Upper in WCS #1:</b> X: 0mm Y: 85mm Z: 0mm	






Total
<b>NUMBER OF OPERATIONS:</b> 17 <b>NUMBER OF TOOLS:</b> 14 <b>TOOLS:</b> T3 T4 T5 T11 T19 T31 T36 T37 T39 T44 T48 T51 T52 T53 <b>MAXIMUM Z:</b> 25mm <b>MINIMUM Z:</b> -70.59mm <b>MAXIMUM FEEDRATE:</b> 5000mm/min <b>MAXIMUM SPINDLE SPEED:</b> 8034rpm <b>CUTTING DISTANCE:</b> 6424.36mm <b>RAPID DISTANCE:</b> 2652.93mm <b>ESTIMATED CYCLE TIME:</b> 9m:56s

Tools		
<b>T3 D3 L3</b> TYPE: face mill DIAMETER: 60mm CORNER RADIUS: 0.3mm TAPER ANGLE: 35° LENGTH: 60mm FLUTES: 5 VENDOR: Sandvik PRODUCT: R365-063C6-S15M	<b>MINIMUM Z:</b> -4.4mm <b>MAXIMUM FEED:</b> 1633.991mm/min <b>MAXIMUM SPINDLE SPEED:</b> 1167rpm <b>CUTTING DISTANCE:</b> 1024.29mm <b>RAPID DISTANCE:</b> 0.4mm <b>ESTIMATED CYCLE TIME:</b> 38s (6.3%)	
<b>T4 D4 L4</b> TYPE: flat end mill DIAMETER: 16mm LENGTH: 42mm FLUTES: 5 DESCRIPTION: Tascbe VENDOR: Sandvik PRODUCT: 2N342-1600-PD	<b>MINIMUM Z:</b> -26mm <b>MAXIMUM FEED:</b> 986.736mm/min <b>MAXIMUM SPINDLE SPEED:</b> 4934rpm <b>CUTTING DISTANCE:</b> 790.09mm <b>RAPID DISTANCE:</b> 969.64mm <b>ESTIMATED CYCLE TIME:</b> 1m:16s (12.7%)	
<b>T5 D5 L5</b> TYPE: flat end mill DIAMETER: 25mm LENGTH: 63mm FLUTES: 5 DESCRIPTION: Contornatura sotto VENDOR: Sandvik PRODUCT: 2N342-2500-PD	<b>MINIMUM Z:</b> -55mm <b>MAXIMUM FEED:</b> 1738.354mm/min <b>MAXIMUM SPINDLE SPEED:</b> 3132rpm <b>CUTTING DISTANCE:</b> 2771.85mm <b>RAPID DISTANCE:</b> 66.5mm <b>ESTIMATED CYCLE TIME:</b> 2m:26s (24.5%)	
<b>T11 D11 L11</b> TYPE: drill DIAMETER: 34mm TIP ANGLE: 176° LENGTH: 130.37mm FLUTES: 2 DESCRIPTION: Pre foro 35 (H15 tolleranza) VENDOR: Sandvik PRODUCT: 880-D3400L40-03	<b>MINIMUM Z:</b> -70.59mm <b>MAXIMUM FEED:</b> 596.831mm/min <b>MAXIMUM SPINDLE SPEED:</b> 2387rpm <b>CUTTING DISTANCE:</b> 75.59mm <b>RAPID DISTANCE:</b> 115.59mm <b>ESTIMATED CYCLE TIME:</b> 9s (1.5%)	
<b>T19 D19 L19</b> TYPE: face mill DIAMETER: 63mm CORNER RADIUS: 1mm TAPER ANGLE: 42° LENGTH: 50mm FLUTES: 5 DESCRIPTION: Finitura superiore S2 VENDOR: Sandvik PRODUCT: 745-063Q22-21H	<b>MINIMUM Z:</b> -5mm <b>MAXIMUM FEED:</b> 852.616mm/min <b>MAXIMUM SPINDLE SPEED:</b> 1137rpm <b>CUTTING DISTANCE:</b> 676.13mm <b>RAPID DISTANCE:</b> 27.4mm <b>ESTIMATED CYCLE TIME:</b> 48s (8%)	
<b>T31 D31 L31</b> TYPE: flat end mill DIAMETER: 8mm LENGTH: 25.4mm FLUTES: 5 DESCRIPTION: tasche superiori 1 VENDOR: Sandvik PRODUCT: 2N342-0800-PD	<b>MINIMUM Z:</b> -25mm <b>MAXIMUM FEED:</b> 2954.314mm/min <b>MAXIMUM SPINDLE SPEED:</b> 7878rpm <b>CUTTING DISTANCE:</b> 319.53mm <b>RAPID DISTANCE:</b> 171.2mm <b>ESTIMATED CYCLE TIME:</b> 15s (2.6%)	

<b>T36 D36 L36</b> TYPE: right hand tap DIAMETER: 4.2mm LENGTH: 30mm FLUTES: 3 DESCRIPTION: Maschio filetti M5 S1 VENDOR: Sandvik PRODUCT: T300-PM104DA-M5	MINIMUM Z: -20mm MAXIMUM FEED: 1624mm/min MAXIMUM SPINDLE SPEED: 2030rpm CUTTING DISTANCE: 60mm RAPID DISTANCE: 180mm ESTIMATED CYCLE TIME: 4s (0.7%)	
<b>T37 D37 L37</b> TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	MINIMUM Z: -32.25mm MAXIMUM FEED: 5000mm/min MAXIMUM SPINDLE SPEED: 5836rpm CUTTING DISTANCE: 287.37mm RAPID DISTANCE: 120.45mm ESTIMATED CYCLE TIME: 13s (2.1%)	
<b>T39 D39 L39</b> TYPE: flat end mill DIAMETER: 12.7mm LENGTH: 37.1mm FLUTES: 5 DESCRIPTION: Spallamento fori VENDOR: Sandvik PRODUCT: 2N342-1270-PD	MINIMUM Z: -10mm MAXIMUM FEED: 864.7mm/min MAXIMUM SPINDLE SPEED: 7519rpm CUTTING DISTANCE: 110.02mm RAPID DISTANCE: 33.73mm ESTIMATED CYCLE TIME: 10s (1.6%)	
<b>T44 D44 L44</b> TYPE: right hand tap DIAMETER: 5mm LENGTH: 50mm FLUTES: 3 DESCRIPTION: Filettatura foro M6x1 S2 VENDOR: Sandvik PRODUCT: T300-PM104DA-M6	MINIMUM Z: -42mm MAXIMUM FEED: 1440mm/min MAXIMUM SPINDLE SPEED: 1440rpm CUTTING DISTANCE: 29.5mm RAPID DISTANCE: 64.5mm ESTIMATED CYCLE TIME: 2s (0.3%)	
<b>T48 D48 L48</b> TYPE: drill DIAMETER: 5mm TIP ANGLE: 147° LENGTH: 52mm FLUTES: 2 DESCRIPTION: Fori superiori 5mm VENDOR: Sandvik PRODUCT: 860.1-0500-037A1-PM	MINIMUM Z: -42mm MAXIMUM FEED: 2759.365mm/min MAXIMUM SPINDLE SPEED: 8021rpm CUTTING DISTANCE: 39mm RAPID DISTANCE: 47mm ESTIMATED CYCLE TIME: 1s (0.2%)	
<b>T51 D51 L51</b> TYPE: drill DIAMETER: 4.2mm TIP ANGLE: 147° LENGTH: 30mm FLUTES: 2 DESCRIPTION: Prefori 4.2mm VENDOR: Sandvik PRODUCT: 860.1-0420-018A0-PM	MINIMUM Z: -20.62mm MAXIMUM FEED: 2490.396mm/min MAXIMUM SPINDLE SPEED: 8034rpm CUTTING DISTANCE: 31.24mm RAPID DISTANCE: 231.24mm ESTIMATED CYCLE TIME: 4s (0.6%)	
<b>T52 D52 L52</b> TYPE: flat end mill DIAMETER: 10mm LENGTH: 36mm FLUTES: 4 DESCRIPTION: Tasca circolare S1 VENDOR: Sandvik PRODUCT: 1K344-1000-XD	MINIMUM Z: -32mm MAXIMUM FEED: 925.9mm/min MAXIMUM SPINDLE SPEED: 5730rpm CUTTING DISTANCE: 162.81mm RAPID DISTANCE: 574.35mm ESTIMATED CYCLE TIME: 17s (2.9%)	
<b>T53 D53 L53</b> TYPE: drill DIAMETER: 4.5mm TIP ANGLE: 147° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Foro 4.5mm S1 profondo VENDOR: Sandvik PRODUCT: 860.1-0450-037A1-PM	MINIMUM Z: -50.92mm MAXIMUM FEED: 1238.933mm/min MAXIMUM SPINDLE SPEED: 7993rpm CUTTING DISTANCE: 46.92mm RAPID DISTANCE: 50.92mm ESTIMATED CYCLE TIME: 3s (0.5%)	

Operations		
Operation 1/17 DESCRIPTION: spianatura inferiore (sgrossatura) STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 41.58mm	<b>T3 D3 L3</b> TYPE: face mill DIAMETER: 60mm CORNER RADIUS: 0.3mm TAPER ANGLE: 35° LENGTH: 60mm FLUTES: 5 VENDOR: Sandvik PRODUCT: R365-063C6-S15M	
Operation 2/17 DESCRIPTION: spianatura inferiore (finitura) STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 42.7mm	<b>T19 D19 L19</b> TYPE: face mill DIAMETER: 63mm CORNER RADIUS: 1mm TAPER ANGLE: 42° LENGTH: 50mm FLUTES: 5 DESCRIPTION: Finitura superiore S2 VENDOR: Sandvik PRODUCT: 745-063Q22-21H	

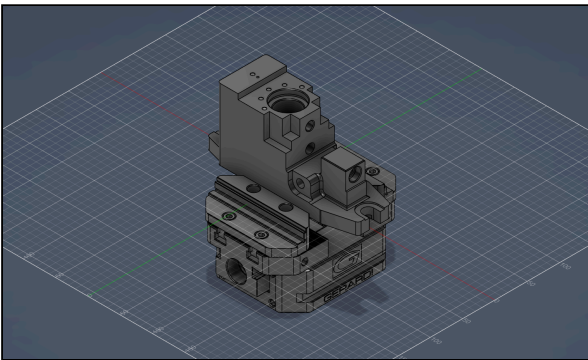
<b>Operation 3/17</b> <b>DESCRIPTION:</b> contornatura inferiore <b>STRATEGY:</b> Contour 2D <b>WCS:</b> #1 <b>TOLERANCE:</b> 0mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPDOWN:</b> 15mm <b>MAXIMUM STEPOVER:</b> 23.75mm	<b>MAXIMUM Z:</b> 8mm <b>MINIMUM Z:</b> -55mm <b>MAXIMUM SPINDLE SPEED:</b> 3132rpm <b>MAXIMUM FEEDRATE:</b> 1738.354mm/min <b>CUTTING DISTANCE:</b> 2771.85mm <b>RAPID DISTANCE:</b> 66.5mm <b>ESTIMATED CYCLE TIME:</b> 2m:26s (24.5%) <b>COOLANT:</b> Flood	<b>T5 D5 L5</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 25mm <b>LENGTH:</b> 63mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Contornatura sotto <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 2N342-2500-PD	
<b>Operation 4/17</b> <b>DESCRIPTION:</b> rifinitura contorno inferiore <b>STRATEGY:</b> Contour 2D <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPDOWN:</b> 15mm <b>MAXIMUM STEPOVER:</b> 7.6mm	<b>MAXIMUM Z:</b> 15mm <b>MINIMUM Z:</b> -25mm <b>MAXIMUM SPINDLE SPEED:</b> 7878rpm <b>MAXIMUM FEEDRATE:</b> 2954.314mm/min <b>CUTTING DISTANCE:</b> 319.53mm <b>RAPID DISTANCE:</b> 171.2mm <b>ESTIMATED CYCLE TIME:</b> 15s (2.6%) <b>COOLANT:</b> Flood	<b>T31 D31 L31</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 8mm <b>LENGTH:</b> 25.4mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> tasche superiori 1 <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 2N342-0800-PD	
<b>Operation 5/17</b> <b>DESCRIPTION:</b> tasche inferiori 16mm <b>STRATEGY:</b> Slot <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>MAXIMUM STEPOVER:</b> 8mm	<b>MAXIMUM Z:</b> 10mm <b>MINIMUM Z:</b> -10mm <b>MAXIMUM SPINDLE SPEED:</b> 4934rpm <b>MAXIMUM FEEDRATE:</b> 986.736mm/min <b>CUTTING DISTANCE:</b> 209.31mm <b>RAPID DISTANCE:</b> 356.18mm <b>ESTIMATED CYCLE TIME:</b> 21s (3.6%) <b>COOLANT:</b> Flood	<b>T4 D4 L4</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 16mm <b>LENGTH:</b> 42mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Tasche <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 2N342-1600-PD	
<b>Operation 6/17</b> <b>DESCRIPTION:</b> tasche inferiori 17mm <b>STRATEGY:</b> Pocket 2D <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.1mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPOVER:</b> 9.6mm	<b>MAXIMUM Z:</b> 15mm <b>MINIMUM Z:</b> -26mm <b>MAXIMUM SPINDLE SPEED:</b> 4934rpm <b>MAXIMUM FEEDRATE:</b> 986.736mm/min <b>CUTTING DISTANCE:</b> 580.78mm <b>RAPID DISTANCE:</b> 613.45mm <b>ESTIMATED CYCLE TIME:</b> 54s (9.1%) <b>COOLANT:</b> Flood	<b>T4 D4 L4</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 16mm <b>LENGTH:</b> 42mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Tasche <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 2N342-1600-PD	
<b>Operation 7/17</b> <b>DESCRIPTION:</b> preforo 34x65 <b>STRATEGY:</b> Drilling <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm	<b>MAXIMUM Z:</b> 25mm <b>MINIMUM Z:</b> -70.59mm <b>MAXIMUM SPINDLE SPEED:</b> 2387rpm <b>MAXIMUM FEEDRATE:</b> 596.831mm/min <b>CUTTING DISTANCE:</b> 75.59mm <b>RAPID DISTANCE:</b> 115.59mm <b>ESTIMATED CYCLE TIME:</b> 9s (1.5%) <b>COOLANT:</b> Air through tool	<b>T11 D11 L11</b> <b>TYPE:</b> drill <b>DIAMETER:</b> 34mm <b>TIP ANGLE:</b> 176° <b>LENGTH:</b> 130.37mm <b>FLUTES:</b> 2 <b>DESCRIPTION:</b> Pre foro 35 (H15 tolleranza) <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 880-D3400L40-03	
<b>Operation 8/17</b> <b>DESCRIPTION:</b> spallamento 40mm <b>STRATEGY:</b> Contour 2D <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPOVER:</b> 12.06mm	<b>MAXIMUM Z:</b> 15mm <b>MINIMUM Z:</b> -10mm <b>MAXIMUM SPINDLE SPEED:</b> 7519rpm <b>MAXIMUM FEEDRATE:</b> 864.7mm/min <b>CUTTING DISTANCE:</b> 110.02mm <b>RAPID DISTANCE:</b> 33.73mm <b>ESTIMATED CYCLE TIME:</b> 10s (1.6%) <b>COOLANT:</b> Flood	<b>T39 D39 L39</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 12.7mm <b>LENGTH:</b> 37.1mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Spallamento fori <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 2N342-1270-PD	
<b>Operation 9/17</b> <b>DESCRIPTION:</b> foro 4.2x10 <b>STRATEGY:</b> Drilling <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm	<b>MAXIMUM Z:</b> 5mm <b>MINIMUM Z:</b> -20.62mm <b>MAXIMUM SPINDLE SPEED:</b> 8034rpm <b>MAXIMUM FEEDRATE:</b> 2490.396mm/min <b>CUTTING DISTANCE:</b> 31.24mm <b>RAPID DISTANCE:</b> 231.24mm <b>ESTIMATED CYCLE TIME:</b> 4s (0.6%) <b>COOLANT:</b> Flood	<b>T51 D51 L51</b> <b>TYPE:</b> drill <b>DIAMETER:</b> 4.2mm <b>TIP ANGLE:</b> 147° <b>LENGTH:</b> 30mm <b>FLUTES:</b> 2 <b>DESCRIPTION:</b> Prefori 4.2mm <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 860.1-0420-018A0-PM	
<b>Operation 10/17</b> <b>DESCRIPTION:</b> filetto 4.2x10 <b>STRATEGY:</b> Drilling <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm	<b>MAXIMUM Z:</b> 0mm <b>MINIMUM Z:</b> -20mm <b>MAXIMUM SPINDLE SPEED:</b> 2030rpm <b>MAXIMUM FEEDRATE:</b> 1624mm/min <b>CUTTING DISTANCE:</b> 60mm <b>RAPID DISTANCE:</b> 180mm <b>ESTIMATED CYCLE TIME:</b> 4s (0.7%) <b>COOLANT:</b> Flood	<b>T36 D36 L36</b> <b>TYPE:</b> right hand tap <b>DIAMETER:</b> 4.2mm <b>LENGTH:</b> 30mm <b>FLUTES:</b> 3 <b>DESCRIPTION:</b> Maschio filetti M5 S1 <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> T300-PM104DA-M5	
<b>Operation 11/17</b> <b>DESCRIPTION:</b> tasca circolare 12x27 <b>STRATEGY:</b> Circular <b>WCS:</b> #1 <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPDOWN:</b> 1.93mm	<b>MAXIMUM Z:</b> 5mm <b>MINIMUM Z:</b> -32mm <b>MAXIMUM SPINDLE SPEED:</b> 5730rpm <b>MAXIMUM FEEDRATE:</b> 925.9mm/min <b>CUTTING DISTANCE:</b> 162.81mm <b>RAPID DISTANCE:</b> 574.35mm <b>ESTIMATED CYCLE TIME:</b> 17s (2.9%) <b>COOLANT:</b> Flood	<b>T52 D52 L52</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 10mm <b>LENGTH:</b> 36mm <b>FLUTES:</b> 4 <b>DESCRIPTION:</b> Tasca circolare S1 <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 1K344-1000-XD	
<b>Operation 12/17</b> <b>DESCRIPTION:</b> foro 4.5x18 <b>STRATEGY:</b> Drilling <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm	<b>MAXIMUM Z:</b> -2mm <b>MINIMUM Z:</b> -50.92mm <b>MAXIMUM SPINDLE SPEED:</b> 7993rpm <b>MAXIMUM FEEDRATE:</b> 1238.933mm/min <b>CUTTING DISTANCE:</b> 46.92mm <b>RAPID DISTANCE:</b> 50.92mm <b>ESTIMATED CYCLE TIME:</b> 3s (0.5%) <b>COOLANT:</b> Flood	<b>T53 D53 L53</b> <b>TYPE:</b> drill <b>DIAMETER:</b> 4.5mm <b>TIP ANGLE:</b> 147° <b>LENGTH:</b> 50mm <b>FLUTES:</b> 2 <b>DESCRIPTION:</b> Foro 4.5mm S1 profondo <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 860.1-0450-037A1-PM	

Operation 13/17 DESCRIPTION: foro 5x10 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM Z: 1mm MINIMUM Z: -42mm MAXIMUM SPINDLE SPEED: 8021rpm MAXIMUM FEEDRATE: 2759.365mm/min CUTTING DISTANCE: 39mm RAPID DISTANCE: 47mm ESTIMATED CYCLE TIME: 1s (0.2%) COOLANT: Flood	<b>T48 D48 L48</b> TYPE: drill DIAMETER: 5mm TIP ANGLE: 147° LENGTH: 52mm FLUTES: 2 DESCRIPTION: Fori superiori 5mm VENDOR: Sandvik PRODUCT: 860.1-0500-037A1-PM	
Operation 14/17 DESCRIPTION: filetto 5x10 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM Z: 5mm MINIMUM Z: -42mm MAXIMUM SPINDLE SPEED: 1440rpm MAXIMUM FEEDRATE: 1440mm/min CUTTING DISTANCE: 29.5mm RAPID DISTANCE: 64.5mm ESTIMATED CYCLE TIME: 2s (0.3%) COOLANT: Flood	<b>T44 D44 L44</b> TYPE: right hand tap DIAMETER: 5mm LENGTH: 50mm FLUTES: 3 DESCRIPTION: Filettatura foro M6x1 S2 VENDOR: Sandvik PRODUCT: T300-PM104DA-M6	
Operation 15/17 DESCRIPTION: smusso maggiore S1 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM Z: 15mm MINIMUM Z: -6mm MAXIMUM SPINDLE SPEED: 5836rpm MAXIMUM FEEDRATE: 1960.789mm/min CUTTING DISTANCE: 137.89mm RAPID DISTANCE: 30.4mm ESTIMATED CYCLE TIME: 6s (1%) COOLANT: Flood	<b>T37 D37 L37</b> TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	
Operation 16/17 DESCRIPTION: smusso minore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM Z: 15mm MINIMUM Z: -11mm MAXIMUM SPINDLE SPEED: 3550rpm MAXIMUM FEEDRATE: 5000mm/min CUTTING DISTANCE: 127.18mm RAPID DISTANCE: 35.4mm ESTIMATED CYCLE TIME: 5s (0.8%) COOLANT: Flood	<b>T37 D37 L37</b> TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	
Operation 17/17 DESCRIPTION: smusso foro 5x10 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM Z: -2mm MINIMUM Z: -32.25mm MAXIMUM SPINDLE SPEED: 5836rpm MAXIMUM FEEDRATE: 1960.789mm/min CUTTING DISTANCE: 22.3mm RAPID DISTANCE: 54.65mm ESTIMATED CYCLE TIME: 2s (0.3%) COOLANT: Flood	<b>T37 D37 L37</b> TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	

# Setup Sheet for Program 1002

JOB DESCRIPTION: Setup2

DOCUMENT PATH: Modello Fusion Gruppo 2 v1


Setup	
<b>WCS: #1</b> <b>Stock:</b> DX: 244mm DY: 85mm DZ: 120mm <b>PART:</b> DX: 234mm DY: 75mm DZ: 110mm <b>Stock Lower in WCS #1:</b> X: 0mm Y: 0mm Z: -120mm <b>Stock Upper in WCS #1:</b> X: 244mm Y: 85mm Z: 0mm	


Total
<b>NUMBER OF OPERATIONS:</b> 60 <b>NUMBER OF TOOLS:</b> 25 <b>TOOLS:</b> T3 T4 T5 T11 T15 T16 T19 T20 T22 T23 T24 T25 T26 T27 T28 T32 T37 T39 T41 T42 T44 T46 T47 T48 T50 <b>MAXIMUM FEEDRATE:</b> 2992.988mm/min <b>MAXIMUM SPINDLE SPEED:</b> 8021rpm <b>CUTTING DISTANCE:</b> 17172.9mm <b>RAPID DISTANCE:</b> 4867.4mm <b>ESTIMATED CYCLE TIME:</b> 27m:5s

Tools		
<b>T3 D3 L3</b> TYPE: face mill DIAMETER: 60mm CORNER RADIUS: 0.3mm TAPER ANGLE: 35° LENGTH: 60mm FLUTES: 5 VENDOR: Sandvik PRODUCT: R365-063C6-S15M	MAXIMUM FEED: 1250mm/min MAXIMUM SPINDLE SPEED: 1080rpm CUTTING DISTANCE: 1027.79mm RAPID DISTANCE: 3.9mm ESTIMATED CYCLE TIME: 50s (3.1%)	
<b>T4 D4 L4</b> TYPE: flat end mill DIAMETER: 16mm LENGTH: 42mm FLUTES: 5 DESCRIPTION: Tasche VENDOR: Sandvik PRODUCT: 2N342-1600-PD	MAXIMUM FEED: 1014.359mm/min MAXIMUM SPINDLE SPEED: 5073rpm CUTTING DISTANCE: 2463.85mm RAPID DISTANCE: 156.1mm ESTIMATED CYCLE TIME: 2m:40s (9.9%)	
<b>T5 D5 L5</b> TYPE: flat end mill DIAMETER: 25mm LENGTH: 63mm FLUTES: 5 DESCRIPTION: Contornatura sotto VENDOR: Sandvik PRODUCT: 2N342-2500-PD	MAXIMUM FEED: 1738.354mm/min MAXIMUM SPINDLE SPEED: 3132rpm CUTTING DISTANCE: 849.38mm RAPID DISTANCE: 278.5mm ESTIMATED CYCLE TIME: 52s (3.2%)	
<b>T11 D11 L11</b> TYPE: drill DIAMETER: 34mm TIP ANGLE: 176° LENGTH: 130.37mm FLUTES: 2 DESCRIPTION: Pre foro 35 (H15 tolleranza) VENDOR: Sandvik PRODUCT: 880-D3400L40-03	MAXIMUM FEED: 596.831mm/min MAXIMUM SPINDLE SPEED: 2387rpm CUTTING DISTANCE: 61mm RAPID DISTANCE: 77mm ESTIMATED CYCLE TIME: 7s (0.4%)	
<b>T15 D15 L15</b> TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P	MAXIMUM FEED: 1017.955mm/min MAXIMUM SPINDLE SPEED: 2610rpm CUTTING DISTANCE: 3353.24mm RAPID DISTANCE: 437.87mm ESTIMATED CYCLE TIME: 3m:51s (14.2%)	
<b>T16 D16 L16</b> TYPE: boring bar DIAMETER: 35mm LENGTH: 99mm FLUTES: 1 DESCRIPTION: barenatura 35 mm VENDOR: Sandvik PRODUCT: 825-45TC09-C3	MAXIMUM FEED: 333.333mm/min MAXIMUM SPINDLE SPEED: 1400rpm CUTTING DISTANCE: 97mm RAPID DISTANCE: 103mm ESTIMATED CYCLE TIME: 19s (1.2%)	





<b>T19 D19 L19</b> TYPE: face mill DIAMETER: 63mm CORNER RADIUS: 1mm TAPER ANGLE: 42° LENGTH: 50mm FLUTES: 5 DESCRIPTION: Finitura superiore S2 VENDOR: Sandvik PRODUCT: 745-063Q22-21H	MAXIMUM FEED: 1650mm/min MAXIMUM SPINDLE SPEED: 1500rpm CUTTING DISTANCE: 160.95mm RAPID DISTANCE: 17.4mm ESTIMATED CYCLE TIME: 6s (0.4%)	
<b>T20 D20 L20</b> TYPE: flat end mill DIAMETER: 12mm LENGTH: 36mm FLUTES: 5 DESCRIPTION: Tasca piccola S2 in basso VENDOR: Sandvik PRODUCT: 2N342-1200-PD	MAXIMUM FEED: 798.954mm/min MAXIMUM SPINDLE SPEED: 6658rpm CUTTING DISTANCE: 141mm RAPID DISTANCE: 20.6mm ESTIMATED CYCLE TIME: 13s (0.8%)	
<b>T22 D22 L22</b> TYPE: drill DIAMETER: 3mm TIP ANGLE: 140° LENGTH: 33mm FLUTES: 2 DESCRIPTION: Fori sup 3x8 mm VENDOR: Sandvik PRODUCT: 862.1-3000-270A0-GM	MAXIMUM FEED: 530.516mm/min MAXIMUM SPINDLE SPEED: 5305rpm CUTTING DISTANCE: 13mm RAPID DISTANCE: 23mm ESTIMATED CYCLE TIME: 2s (0.1%)	
<b>T23 D23 L23</b> TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 55mm FLUTES: 2 DESCRIPTION: Foratura laterale 12mm VENDOR: Sandvik PRODUCT: 860.1-1200-037A1-PM	MAXIMUM FEED: 2472.074mm/min MAXIMUM SPINDLE SPEED: 4536rpm CUTTING DISTANCE: 104.12mm RAPID DISTANCE: 182.12mm ESTIMATED CYCLE TIME: 5s (0.3%)	
<b>T24 D24 L24</b> TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 90mm FLUTES: 5 DESCRIPTION: Contornatura blocco sup S2 VENDOR: Sandvik PRODUCT: 1K365-2000-300-XD	MAXIMUM FEED: 1803.934mm/min MAXIMUM SPINDLE SPEED: 4631rpm CUTTING DISTANCE: 3430.68mm RAPID DISTANCE: 710.25mm ESTIMATED CYCLE TIME: 3m:4s (11.3%)	
<b>T25 D25 L25</b> TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 60mm FLUTES: 5 VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD	MAXIMUM FEED: 1509.983mm/min MAXIMUM SPINDLE SPEED: 4027rpm CUTTING DISTANCE: 1663.2mm RAPID DISTANCE: 226.5mm ESTIMATED CYCLE TIME: 1m:34s (5.8%)	
<b>T26 D26 L26</b> TYPE: drill DIAMETER: 14mm TIP ANGLE: 147° LENGTH: 134mm FLUTES: 2 DESCRIPTION: Foro da 14mm VENDOR: Sandvik PRODUCT: 860.1-1400-115A1-PM	MAXIMUM FEED: 1627.2mm/min MAXIMUM SPINDLE SPEED: 2865rpm CUTTING DISTANCE: 25.03mm RAPID DISTANCE: 173.03mm ESTIMATED CYCLE TIME: 3s (0.2%)	
<b>T27 D27 L27</b> TYPE: drill DIAMETER: 20mm TIP ANGLE: 147° LENGTH: 105mm FLUTES: 2 DESCRIPTION: Foro da 20x70 VENDOR: Sandvik PRODUCT: 860.1-2000-077A1-PM	MAXIMUM FEED: 1648.845mm/min MAXIMUM SPINDLE SPEED: 2355rpm CUTTING DISTANCE: 62.6mm RAPID DISTANCE: 80.6mm ESTIMATED CYCLE TIME: 3s (0.2%)	
<b>T28 D28 L28</b> TYPE: drill DIAMETER: 16mm TIP ANGLE: 147° LENGTH: 90mm FLUTES: 2 DESCRIPTION: Foro da 14mm VENDOR: Sandvik PRODUCT: 860.1-1600-044A1-PM	MAXIMUM FEED: 1401.2mm/min MAXIMUM SPINDLE SPEED: 2467rpm CUTTING DISTANCE: 47.37mm RAPID DISTANCE: 73.37mm ESTIMATED CYCLE TIME: 3s (0.2%)	
<b>T32 D32 L32</b> TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	MAXIMUM FEED: 2992.988mm/min MAXIMUM SPINDLE SPEED: 7918rpm CUTTING DISTANCE: 1275.29mm RAPID DISTANCE: 751.02mm ESTIMATED CYCLE TIME: 1m:25s (5.2%)	




<b>T37 D37 L37</b> TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	MAXIMUM FEED: 1960.789mm/min MAXIMUM SPINDLE SPEED: 5836rpm CUTTING DISTANCE: 761.85mm RAPID DISTANCE: 335.28mm ESTIMATED CYCLE TIME: 41s (2.5%)	
<b>T39 D39 L39</b> TYPE: flat end mill DIAMETER: 12.7mm LENGTH: 37.1mm FLUTES: 5 DESCRIPTION: Spallamento fori VENDOR: Sandvik PRODUCT: 2N342-1270-PD	MAXIMUM FEED: 864.7mm/min MAXIMUM SPINDLE SPEED: 7519rpm CUTTING DISTANCE: 181.81mm RAPID DISTANCE: 152.19mm ESTIMATED CYCLE TIME: 20s (1.2%)	
<b>T41 D41 L41</b> TYPE: slot mill DIAMETER: 9.7mm CORNER RADIUS: 0.2mm LENGTH: 41.5mm FLUTES: 3 DESCRIPTION: Slot S2 VENDOR: Sandvik PRODUCT: 327R06-10 15002-GM	MAXIMUM FEED: 758.529mm/min MAXIMUM SPINDLE SPEED: 7548rpm CUTTING DISTANCE: 444.17mm RAPID DISTANCE: 128.77mm ESTIMATED CYCLE TIME: 37s (2.3%)	
<b>T42 D42 L42</b> TYPE: slot mill DIAMETER: 10mm LENGTH: 40mm FLUTES: 7 DESCRIPTION: Prova 2 S2 contour	MAXIMUM FEED: 1000mm/min MAXIMUM SPINDLE SPEED: 5000rpm CUTTING DISTANCE: 79.4mm RAPID DISTANCE: 56.9mm ESTIMATED CYCLE TIME: 5s (0.3%)	
<b>T44 D44 L44</b> TYPE: right hand tap DIAMETER: 5mm LENGTH: 50mm FLUTES: 3 DESCRIPTION: Filettatura foro M6x1 S2 VENDOR: Sandvik PRODUCT: T300-PM104DA-M6	MAXIMUM FEED: 1440mm/min MAXIMUM SPINDLE SPEED: 1440rpm CUTTING DISTANCE: 286.98mm RAPID DISTANCE: 160.56mm ESTIMATED CYCLE TIME: 14s (0.9%)	
<b>T46 D46 L46</b> TYPE: drill DIAMETER: 18mm TIP ANGLE: 147° LENGTH: 80mm FLUTES: 2 DESCRIPTION: allargatura foro corpo centrale VENDOR: Sandvik PRODUCT: 860.1-1800-050A1-PM	MAXIMUM FEED: 1359.537mm/min MAXIMUM SPINDLE SPEED: 2193rpm CUTTING DISTANCE: 14.67mm RAPID DISTANCE: 36.67mm ESTIMATED CYCLE TIME: 1s (0.1%)	
<b>T47 D47 L47</b> TYPE: bullnose end mill DIAMETER: 14mm CORNER RADIUS: 3mm LENGTH: 70mm FLUTES: 4 DESCRIPTION: Contour sm con raggi S2 VENDOR: Sandvik PRODUCT: R216.24-14050GAK26P	MAXIMUM FEED: 682.093mm/min MAXIMUM SPINDLE SPEED: 2274rpm CUTTING DISTANCE: 156.73mm RAPID DISTANCE: 63.6mm ESTIMATED CYCLE TIME: 19s (1.2%)	
<b>T48 D48 L48</b> TYPE: drill DIAMETER: 5mm TIP ANGLE: 147° LENGTH: 52mm FLUTES: 2 DESCRIPTION: Fori superiori 5mm VENDOR: Sandvik PRODUCT: 860.1-0500-037A1-PM	MAXIMUM FEED: 2759.365mm/min MAXIMUM SPINDLE SPEED: 8021rpm CUTTING DISTANCE: 147.93mm RAPID DISTANCE: 427.52mm ESTIMATED CYCLE TIME: 8s (0.5%)	
<b>T50 D50 L50</b> TYPE: bullnose end mill DIAMETER: 3.17mm CORNER RADIUS: 0.79mm LENGTH: 22mm FLUTES: 4 DESCRIPTION: tasche superiori 34 VENDOR: Sandvik PRODUCT: RA216.24-0830BAK02G	MAXIMUM FEED: 417.061mm/min MAXIMUM SPINDLE SPEED: 8020rpm CUTTING DISTANCE: 323.88mm RAPID DISTANCE: 191.66mm ESTIMATED CYCLE TIME: 51s (3.2%)	



Operations		
Operation 1/60 DESCRIPTION: spianatura superiore(sgrossatura) STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 41.58mm	MAXIMUM SPINDLE SPEED: 1080rpm MAXIMUM FEEDRATE: 1250mm/min CUTTING DISTANCE: 1027.79mm RAPID DISTANCE: 3.9mm ESTIMATED CYCLE TIME: 50s (3.1%) COOLANT: Flood	<b>T3 D3 L3</b> TYPE: face mill DIAMETER: 60mm CORNER RADIUS: 0.3mm TAPER ANGLE: 35° LENGTH: 60mm FLUTES: 5 VENDOR: Sandvik PRODUCT: R365-063C6-S15M
		



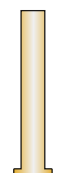
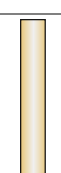
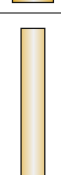
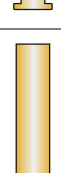
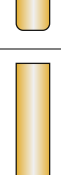




Operation 2/60 <b>DESCRIPTION:</b> spianatura superiore(finitura) <b>STRATEGY:</b> Facing <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>MAXIMUM STEPOVER:</b> 42.7mm	<b>MAXIMUM SPINDLE SPEED:</b> 1500rpm <b>MAXIMUM FEEDRATE:</b> 1650mm/min <b>CUTTING DISTANCE:</b> 160.95mm <b>RAPID DISTANCE:</b> 17.4mm <b>ESTIMATED CYCLE TIME:</b> 6s (0.4%) <b>COOLANT:</b> Flood	<b>T19 D19 L19</b> <b>TYPE:</b> face mill <b>DIAMETER:</b> 63mm <b>CORNER RADIUS:</b> 1mm <b>TAPER ANGLE:</b> 42° <b>LENGTH:</b> 50mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Finitura superiore S2 <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 745-063Q22-21H	
Operation 3/60 <b>DESCRIPTION:</b> spianatura superiore 2 <b>STRATEGY:</b> Facing <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>MAXIMUM STEPOVER:</b> 11.2mm	<b>MAXIMUM SPINDLE SPEED:</b> 4934rpm <b>MAXIMUM FEEDRATE:</b> 986.736mm/min <b>CUTTING DISTANCE:</b> 1929.3mm <b>RAPID DISTANCE:</b> 22.5mm <b>ESTIMATED CYCLE TIME:</b> 1m:58s (7.3%) <b>COOLANT:</b> Flood	<b>T4 D4 L4</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 16mm <b>LENGTH:</b> 42mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Tasche <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 2N342-1600-PD	
Operation 4/60 <b>DESCRIPTION:</b> spallamento posteriore <b>STRATEGY:</b> Facing <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>MAXIMUM STEPDOWN:</b> 27mm <b>MAXIMUM STEPOVER:</b> 13.3mm	<b>MAXIMUM SPINDLE SPEED:</b> 2610rpm <b>MAXIMUM FEEDRATE:</b> 1017.955mm/min <b>CUTTING DISTANCE:</b> 1494.77mm <b>RAPID DISTANCE:</b> 303.42mm <b>ESTIMATED CYCLE TIME:</b> 1m:55s (7.1%) <b>COOLANT:</b> Flood	<b>T15 D15 L15</b> <b>TYPE:</b> bullnose end mill <b>DIAMETER:</b> 25mm <b>CORNER RADIUS:</b> 3mm <b>LENGTH:</b> 98mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Spallamento posteriore <b>VENDOR:</b> SANDVIK <b>PRODUCT:</b> R216.25-25050GCK54P	
Operation 5/60 <b>DESCRIPTION:</b> spallamento posteriore piccolo <b>STRATEGY:</b> Pocket 2D <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.1mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPOVER:</b> 7.2mm	<b>MAXIMUM SPINDLE SPEED:</b> 5305rpm <b>MAXIMUM FEEDRATE:</b> 636.354mm/min <b>CUTTING DISTANCE:</b> 72mm <b>RAPID DISTANCE:</b> 7.8mm <b>ESTIMATED CYCLE TIME:</b> 8s (0.5%) <b>COOLANT:</b> Flood	<b>T20 D20 L20</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 12mm <b>LENGTH:</b> 36mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Tasca piccola S2 in basso <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 2N342-1200-PD	
Operation 6/60 <b>DESCRIPTION:</b> spianatura superiore 3 <b>STRATEGY:</b> Facing <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>MAXIMUM STEPDOWN:</b> 27mm <b>MAXIMUM STEPOVER:</b> 13.3mm	<b>MAXIMUM SPINDLE SPEED:</b> 2610rpm <b>MAXIMUM FEEDRATE:</b> 1017.955mm/min <b>CUTTING DISTANCE:</b> 1858.47mm <b>RAPID DISTANCE:</b> 134.44mm <b>ESTIMATED CYCLE TIME:</b> 1m:56s (7.1%) <b>COOLANT:</b> Flood	<b>T15 D15 L15</b> <b>TYPE:</b> bullnose end mill <b>DIAMETER:</b> 25mm <b>CORNER RADIUS:</b> 3mm <b>LENGTH:</b> 98mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Spallamento posteriore <b>VENDOR:</b> SANDVIK <b>PRODUCT:</b> R216.25-25050GCK54P	
Operation 7/60 <b>DESCRIPTION:</b> contornatura 1 <b>STRATEGY:</b> Contour 2D <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPOVER:</b> 23.75mm	<b>MAXIMUM SPINDLE SPEED:</b> 3132rpm <b>MAXIMUM FEEDRATE:</b> 1738.354mm/min <b>CUTTING DISTANCE:</b> 320.81mm <b>RAPID DISTANCE:</b> 20mm <b>ESTIMATED CYCLE TIME:</b> 13s (0.8%) <b>COOLANT:</b> Flood	<b>T5 D5 L5</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 25mm <b>LENGTH:</b> 63mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Contornatura sotto <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 2N342-2500-PD	
Operation 8/60 <b>DESCRIPTION:</b> contornatura 2 <b>STRATEGY:</b> Contour 2D <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPDOWN:</b> 11.5mm <b>MAXIMUM STEPOVER:</b> 13.3mm	<b>MAXIMUM SPINDLE SPEED:</b> 4631rpm <b>MAXIMUM FEEDRATE:</b> 1803.934mm/min <b>CUTTING DISTANCE:</b> 2855.04mm <b>RAPID DISTANCE:</b> 253.25mm <b>ESTIMATED CYCLE TIME:</b> 2m:11s (8.1%) <b>COOLANT:</b> Flood	<b>T24 D24 L24</b> <b>TYPE:</b> bullnose end mill <b>DIAMETER:</b> 20mm <b>CORNER RADIUS:</b> 3mm <b>LENGTH:</b> 90mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Contornatura blocco sup S2 <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 1K365-2000-300-XD	
Operation 9/60 <b>DESCRIPTION:</b> rifinitura contornatura 2 <b>STRATEGY:</b> Contour 2D <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPDOWN:</b> 40.5mm <b>MAXIMUM STEPOVER:</b> 13.3mm	<b>MAXIMUM SPINDLE SPEED:</b> 4631rpm <b>MAXIMUM FEEDRATE:</b> 1803.934mm/min <b>CUTTING DISTANCE:</b> 575.65mm <b>RAPID DISTANCE:</b> 457mm <b>ESTIMATED CYCLE TIME:</b> 53s (3.3%) <b>COOLANT:</b> Flood	<b>T24 D24 L24</b> <b>TYPE:</b> bullnose end mill <b>DIAMETER:</b> 20mm <b>CORNER RADIUS:</b> 3mm <b>LENGTH:</b> 90mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Contornatura blocco sup S2 <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 1K365-2000-300-XD	
Operation 10/60 <b>DESCRIPTION:</b> spianatura 2.1 <b>STRATEGY:</b> Facing <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>MAXIMUM STEPDOWN:</b> 22mm <b>MAXIMUM STEPOVER:</b> 9.8mm	<b>MAXIMUM SPINDLE SPEED:</b> 4027rpm <b>MAXIMUM FEEDRATE:</b> 1509.983mm/min <b>CUTTING DISTANCE:</b> 240.54mm <b>RAPID DISTANCE:</b> 45mm <b>ESTIMATED CYCLE TIME:</b> 14s (0.8%) <b>COOLANT:</b> Flood	<b>T25 D25 L25</b> <b>TYPE:</b> bullnose end mill <b>DIAMETER:</b> 20mm <b>CORNER RADIUS:</b> 3mm <b>LENGTH:</b> 60mm <b>FLUTES:</b> 5 <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 1K335-2000-300-XD	
Operation 11/60 <b>DESCRIPTION:</b> contornatura 3 <b>STRATEGY:</b> Contour 2D <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPDOWN:</b> 15mm <b>MAXIMUM STEPOVER:</b> 13.3mm	<b>MAXIMUM SPINDLE SPEED:</b> 4027rpm <b>MAXIMUM FEEDRATE:</b> 1509.983mm/min <b>CUTTING DISTANCE:</b> 1037.69mm <b>RAPID DISTANCE:</b> 87.5mm <b>ESTIMATED CYCLE TIME:</b> 53s (3.3%) <b>COOLANT:</b> Flood	<b>T25 D25 L25</b> <b>TYPE:</b> bullnose end mill <b>DIAMETER:</b> 20mm <b>CORNER RADIUS:</b> 3mm <b>LENGTH:</b> 60mm <b>FLUTES:</b> 5 <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 1K335-2000-300-XD	
Operation 12/60 <b>DESCRIPTION:</b> tasche superiori 1.1 <b>STRATEGY:</b> Contour 2D <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm/0.5mm <b>MAXIMUM STEPDOWN:</b> 11.5mm <b>MAXIMUM STEPOVER:</b> 7.6mm	<b>MAXIMUM SPINDLE SPEED:</b> 7918rpm <b>MAXIMUM FEEDRATE:</b> 2992.988mm/min <b>CUTTING DISTANCE:</b> 203.97mm <b>RAPID DISTANCE:</b> 84.48mm <b>ESTIMATED CYCLE TIME:</b> 12s (0.7%) <b>COOLANT:</b> Flood	<b>T32 D32 L32</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 8mm <b>LENGTH:</b> 36.3mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> tasche superiori rifinitura <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 1K365-0800-XD	







Operation 13/60 DESCRIPTION: tasche superiori 1.2 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm/0.1mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 92.01mm RAPID DISTANCE: 47.1mm ESTIMATED CYCLE TIME: 7s (0.4%) COOLANT: Flood	<b>T32 D32 L32</b> TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 14/60 DESCRIPTION: tasche superiori 1.3 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm/0.5mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 63.33mm RAPID DISTANCE: 35.7mm ESTIMATED CYCLE TIME: 4s (0.3%) COOLANT: Flood	<b>T32 D32 L32</b> TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 15/60 DESCRIPTION: tasche superiori 1.4 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm/0.1mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 80.73mm RAPID DISTANCE: 36.1mm ESTIMATED CYCLE TIME: 5s (0.3%) COOLANT: Flood	<b>T32 D32 L32</b> TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 16/60 DESCRIPTION: tasche superiori 2 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 175.7mm RAPID DISTANCE: 119.65mm ESTIMATED CYCLE TIME: 11s (0.7%) COOLANT: Flood	<b>T32 D32 L32</b> TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 17/60 DESCRIPTION: tasche superiori 3.1 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 11.5mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 132.76mm RAPID DISTANCE: 102.29mm ESTIMATED CYCLE TIME: 11s (0.7%) COOLANT: Flood	<b>T32 D32 L32</b> TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 18/60 DESCRIPTION: tasche superiori 3.2 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm/0.1mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 60.21mm RAPID DISTANCE: 47.1mm ESTIMATED CYCLE TIME: 6s (0.4%) COOLANT: Flood	<b>T32 D32 L32</b> TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 19/60 DESCRIPTION: tasche superiori 3.3 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm/0.1mm MAXIMUM STEPDOWN: 11.5mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 172.57mm RAPID DISTANCE: 113.8mm ESTIMATED CYCLE TIME: 12s (0.7%) COOLANT: Flood	<b>T32 D32 L32</b> TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 20/60 DESCRIPTION: tasche superiori 3.4 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm/0.1mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 57.92mm RAPID DISTANCE: 36.1mm ESTIMATED CYCLE TIME: 4s (0.3%) COOLANT: Flood	<b>T32 D32 L32</b> TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 21/60 DESCRIPTION: tasche superiori 3.5 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm/0.1mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 69.11mm RAPID DISTANCE: 36.1mm ESTIMATED CYCLE TIME: 4s (0.3%) COOLANT: Flood	<b>T32 D32 L32</b> TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 22/60 DESCRIPTION: tasche superiori 4 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 166.98mm RAPID DISTANCE: 92.59mm ESTIMATED CYCLE TIME: 10s (0.6%) COOLANT: Flood	<b>T32 D32 L32</b> TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 23/60 DESCRIPTION: tasche superiori 5 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 1.51mm	MAXIMUM SPINDLE SPEED: 8020rpm MAXIMUM FEEDRATE: 417.061mm/min CUTTING DISTANCE: 167.6mm RAPID DISTANCE: 96.27mm ESTIMATED CYCLE TIME: 26s (1.6%) COOLANT: Flood	<b>T50 D50 L50</b> TYPE: bullnose end mill DIAMETER: 3.17mm CORNER RADIUS: 0.79mm LENGTH: 22mm FLUTES: 4 DESCRIPTION: tasche superiori 34 VENDOR: Sandvik PRODUCT: RA216.24-0830BAK02G	

Operation 24/60 <b>DESCRIPTION:</b> tasche superiori 6 <b>STRATEGY:</b> Contour 2D <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPOVER:</b> 1.51mm	<b>MAXIMUM SPINDLE SPEED:</b> 8020rpm <b>MAXIMUM FEEDRATE:</b> 417.061mm/min <b>CUTTING DISTANCE:</b> 156.27mm <b>RAPID DISTANCE:</b> 95.38mm <b>ESTIMATED CYCLE TIME:</b> 25s (1.5%) <b>COOLANT:</b> Flood	<b>T50 D50 L50</b> <b>TYPE:</b> bullnose end mill <b>DIAMETER:</b> 3.17mm <b>CORNER RADIUS:</b> 0.79mm <b>LENGTH:</b> 22mm <b>FLUTES:</b> 4 <b>DESCRIPTION:</b> tasche superiori 34 <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> RA216.24-0830BAK02G	
Operation 25/60 <b>DESCRIPTION:</b> contornatura 2.2 <b>STRATEGY:</b> Facing <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>MAXIMUM STEPOVER:</b> 17.5mm	<b>MAXIMUM SPINDLE SPEED:</b> 3132rpm <b>MAXIMUM FEEDRATE:</b> 1738.354mm/min <b>CUTTING DISTANCE:</b> 135.61mm <b>RAPID DISTANCE:</b> 57.5mm <b>ESTIMATED CYCLE TIME:</b> 11s (0.7%) <b>COOLANT:</b> Flood	<b>T5 D5 L5</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 25mm <b>LENGTH:</b> 63mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Contornatura sotto <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 2N342-2500-PD	
Operation 26/60 <b>DESCRIPTION:</b> contornatura 4 <b>STRATEGY:</b> Contour 2D <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPDOWN:</b> 25mm <b>MAXIMUM STEPOVER:</b> 23.75mm	<b>MAXIMUM SPINDLE SPEED:</b> 3132rpm <b>MAXIMUM FEEDRATE:</b> 1738.354mm/min <b>CUTTING DISTANCE:</b> 392.96mm <b>RAPID DISTANCE:</b> 201mm <b>ESTIMATED CYCLE TIME:</b> 27s (1.7%) <b>COOLANT:</b> Flood	<b>T5 D5 L5</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 25mm <b>LENGTH:</b> 63mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Contornatura sotto <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 2N342-2500-PD	
Operation 27/60 <b>DESCRIPTION:</b> spallamento anteriore piccolo <b>STRATEGY:</b> Pocket 2D <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.1mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPOVER:</b> 7.2mm	<b>MAXIMUM SPINDLE SPEED:</b> 6658rpm <b>MAXIMUM FEEDRATE:</b> 798.954mm/min <b>CUTTING DISTANCE:</b> 69mm <b>RAPID DISTANCE:</b> 12.8mm <b>ESTIMATED CYCLE TIME:</b> 6s (0.4%) <b>COOLANT:</b> Flood	<b>T20 D20 L20</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 12mm <b>LENGTH:</b> 36mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Tasca piccola S2 in basso <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 2N342-1200-PD	
Operation 28/60 <b>DESCRIPTION:</b> spallamento faccia foro anteriore <b>STRATEGY:</b> Contour 2D <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPOVER:</b> 15.2mm	<b>MAXIMUM SPINDLE SPEED:</b> 5073rpm <b>MAXIMUM FEEDRATE:</b> 1014.359mm/min <b>CUTTING DISTANCE:</b> 70.65mm <b>RAPID DISTANCE:</b> 33.4mm <b>ESTIMATED CYCLE TIME:</b> 8s (0.5%) <b>COOLANT:</b> Flood	<b>T4 D4 L4</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 16mm <b>LENGTH:</b> 42mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Tasche <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 2N342-1600-PD	
Operation 29/60 <b>DESCRIPTION:</b> contornatura corpo anteriore <b>STRATEGY:</b> Contour 2D <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPOVER:</b> 13.3mm	<b>MAXIMUM SPINDLE SPEED:</b> 4027rpm <b>MAXIMUM FEEDRATE:</b> 1509.983mm/min <b>CUTTING DISTANCE:</b> 180.98mm <b>RAPID DISTANCE:</b> 35mm <b>ESTIMATED CYCLE TIME:</b> 11s (0.7%) <b>COOLANT:</b> Flood	<b>T25 D25 L25</b> <b>TYPE:</b> bullnose end mill <b>DIAMETER:</b> 20mm <b>CORNER RADIUS:</b> 3mm <b>LENGTH:</b> 60mm <b>FLUTES:</b> 5 <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 1K335-2000-300-XD	
Operation 30/60 <b>DESCRIPTION:</b> rifinitura corpo anteriore <b>STRATEGY:</b> Contour 2D <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPOVER:</b> 13.3mm	<b>MAXIMUM SPINDLE SPEED:</b> 4027rpm <b>MAXIMUM FEEDRATE:</b> 1509.983mm/min <b>CUTTING DISTANCE:</b> 203.98mm <b>RAPID DISTANCE:</b> 59mm <b>ESTIMATED CYCLE TIME:</b> 16s (1%) <b>COOLANT:</b> Flood	<b>T25 D25 L25</b> <b>TYPE:</b> bullnose end mill <b>DIAMETER:</b> 20mm <b>CORNER RADIUS:</b> 3mm <b>LENGTH:</b> 60mm <b>FLUTES:</b> 5 <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 1K335-2000-300-XD	
Operation 31/60 <b>DESCRIPTION:</b> tasche laterali con foro 1 <b>STRATEGY:</b> Pocket 2D <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.1mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPOVER:</b> 9.6mm	<b>MAXIMUM SPINDLE SPEED:</b> 4934rpm <b>MAXIMUM FEEDRATE:</b> 986.736mm/min <b>CUTTING DISTANCE:</b> 174.82mm <b>RAPID DISTANCE:</b> 34.9mm <b>ESTIMATED CYCLE TIME:</b> 13s (0.8%) <b>COOLANT:</b> Flood	<b>T4 D4 L4</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 16mm <b>LENGTH:</b> 42mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Tasche <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 2N342-1600-PD	
Operation 32/60 <b>DESCRIPTION:</b> tasche laterali con foro 2 <b>STRATEGY:</b> Pocket 2D <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPOVER:</b> 9.6mm	<b>MAXIMUM SPINDLE SPEED:</b> 4934rpm <b>MAXIMUM FEEDRATE:</b> 986.736mm/min <b>CUTTING DISTANCE:</b> 171.32mm <b>RAPID DISTANCE:</b> 39.9mm <b>ESTIMATED CYCLE TIME:</b> 12s (0.7%) <b>COOLANT:</b> Flood	<b>T4 D4 L4</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 16mm <b>LENGTH:</b> 42mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Tasche <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 2N342-1600-PD	
Operation 33/60 <b>DESCRIPTION:</b> fori sup 5mm <b>STRATEGY:</b> Drilling <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm	<b>MAXIMUM SPINDLE SPEED:</b> 8021rpm <b>MAXIMUM FEEDRATE:</b> 2759.365mm/min <b>CUTTING DISTANCE:</b> 147.93mm <b>RAPID DISTANCE:</b> 427.52mm <b>ESTIMATED CYCLE TIME:</b> 8s (0.5%) <b>COOLANT:</b> Flood	<b>T48 D48 L48</b> <b>TYPE:</b> drill <b>DIAMETER:</b> 5mm <b>TIP ANGLE:</b> 147° <b>LENGTH:</b> 52mm <b>FLUTES:</b> 2 <b>DESCRIPTION:</b> Fori superiori 5mm <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 860.1-0500-037A1-PM	
Operation 34/60 <b>DESCRIPTION:</b> filetti 5x10 <b>STRATEGY:</b> Drilling <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm	<b>MAXIMUM SPINDLE SPEED:</b> 1440rpm <b>MAXIMUM FEEDRATE:</b> 1440mm/min <b>CUTTING DISTANCE:</b> 286.98mm <b>RAPID DISTANCE:</b> 160.56mm <b>ESTIMATED CYCLE TIME:</b> 14s (0.9%) <b>COOLANT:</b> Flood	<b>T44 D44 L44</b> <b>TYPE:</b> right hand tap <b>DIAMETER:</b> 5mm <b>LENGTH:</b> 50mm <b>FLUTES:</b> 3 <b>DESCRIPTION:</b> Filettatura foro M6x1 S2 <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> T300-PM104DA-M6	

Operation 35/60 <b>DESCRIPTION:</b> foro sup 3x8mm <b>STRATEGY:</b> Drilling <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm	<b>MAXIMUM SPINDLE SPEED:</b> 5305rpm <b>MAXIMUM FEEDRATE:</b> 530.516mm/min <b>CUTTING DISTANCE:</b> 13mm <b>RAPID DISTANCE:</b> 23mm <b>ESTIMATED CYCLE TIME:</b> 2s (0.1%) <b>COOLANT:</b> Flood	<b>T22 D22 L22</b> <b>TYPE:</b> drill <b>DIAMETER:</b> 3mm <b>TIP ANGLE:</b> 140° <b>LENGTH:</b> 33mm <b>FLUTES:</b> 2 <b>DESCRIPTION:</b> Fori sup 3x8 mm <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 862.1-3000-270A0-GM	
Operation 36/60 <b>DESCRIPTION:</b> foro lato 12x37mm <b>STRATEGY:</b> Drilling <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm	<b>MAXIMUM SPINDLE SPEED:</b> 4536rpm <b>MAXIMUM FEEDRATE:</b> 2472.074mm/min <b>CUTTING DISTANCE:</b> 39.78mm <b>RAPID DISTANCE:</b> 62.78mm <b>ESTIMATED CYCLE TIME:</b> 2s (0.1%) <b>COOLANT:</b> Flood	<b>T23 D23 L23</b> <b>TYPE:</b> drill <b>DIAMETER:</b> 12mm <b>TIP ANGLE:</b> 147° <b>LENGTH:</b> 55mm <b>FLUTES:</b> 2 <b>DESCRIPTION:</b> Foratura laterale 12mm <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 860.1-1200-037A1-PM	
Operation 37/60 <b>DESCRIPTION:</b> foro lato 12x37mm1 <b>STRATEGY:</b> Drilling <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm	<b>MAXIMUM SPINDLE SPEED:</b> 4536rpm <b>MAXIMUM FEEDRATE:</b> 2472.074mm/min <b>CUTTING DISTANCE:</b> 39.78mm <b>RAPID DISTANCE:</b> 62.78mm <b>ESTIMATED CYCLE TIME:</b> 2s (0.1%) <b>COOLANT:</b> Flood	<b>T23 D23 L23</b> <b>TYPE:</b> drill <b>DIAMETER:</b> 12mm <b>TIP ANGLE:</b> 147° <b>LENGTH:</b> 55mm <b>FLUTES:</b> 2 <b>DESCRIPTION:</b> Foratura laterale 12mm <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 860.1-1200-037A1-PM	
Operation 38/60 <b>DESCRIPTION:</b> foro anteriore 12x16,5mm <b>STRATEGY:</b> Drilling <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm	<b>MAXIMUM SPINDLE SPEED:</b> 4536rpm <b>MAXIMUM FEEDRATE:</b> 2472.074mm/min <b>CUTTING DISTANCE:</b> 24.56mm <b>RAPID DISTANCE:</b> 56.56mm <b>ESTIMATED CYCLE TIME:</b> 1s (0.1%) <b>COOLANT:</b> Flood	<b>T23 D23 L23</b> <b>TYPE:</b> drill <b>DIAMETER:</b> 12mm <b>TIP ANGLE:</b> 147° <b>LENGTH:</b> 55mm <b>FLUTES:</b> 2 <b>DESCRIPTION:</b> Foratura laterale 12mm <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 860.1-1200-037A1-PM	
Operation 39/60 <b>DESCRIPTION:</b> foro posteriore 20x60mm <b>STRATEGY:</b> Drilling <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm	<b>MAXIMUM SPINDLE SPEED:</b> 2355rpm <b>MAXIMUM FEEDRATE:</b> 1648.845mm/min <b>CUTTING DISTANCE:</b> 62.6mm <b>RAPID DISTANCE:</b> 80.6mm <b>ESTIMATED CYCLE TIME:</b> 3s (0.2%) <b>COOLANT:</b> Flood	<b>T27 D27 L27</b> <b>TYPE:</b> drill <b>DIAMETER:</b> 20mm <b>TIP ANGLE:</b> 147° <b>LENGTH:</b> 105mm <b>FLUTES:</b> 2 <b>DESCRIPTION:</b> Foro da 20x70 <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 860.1-2000-077A1-PM	
Operation 40/60 <b>DESCRIPTION:</b> spallamento posteriore 35mm <b>STRATEGY:</b> Contour 2D <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPOVER:</b> 12.06mm	<b>MAXIMUM SPINDLE SPEED:</b> 7519rpm <b>MAXIMUM FEEDRATE:</b> 864.7mm/min <b>CUTTING DISTANCE:</b> 89.31mm <b>RAPID DISTANCE:</b> 28.73mm <b>ESTIMATED CYCLE TIME:</b> 8s (0.5%) <b>COOLANT:</b> Flood	<b>T39 D39 L39</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 12.7mm <b>LENGTH:</b> 37.1mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Spallamento fori <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 2N342-1270-PD	
Operation 41/60 <b>DESCRIPTION:</b> foro corpo ant 16x38mm <b>STRATEGY:</b> Drilling <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm	<b>MAXIMUM SPINDLE SPEED:</b> 2467rpm <b>MAXIMUM FEEDRATE:</b> 1401.2mm/min <b>CUTTING DISTANCE:</b> 47.37mm <b>RAPID DISTANCE:</b> 73.37mm <b>ESTIMATED CYCLE TIME:</b> 3s (0.2%) <b>COOLANT:</b> Flood	<b>T28 D28 L28</b> <b>TYPE:</b> drill <b>DIAMETER:</b> 16mm <b>TIP ANGLE:</b> 147° <b>LENGTH:</b> 90mm <b>FLUTES:</b> 2 <b>DESCRIPTION:</b> Foro da 14mm <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 860.1-1600-044A1-PM	
Operation 42/60 <b>DESCRIPTION:</b> allargamento corpo anteriore 18x8mm <b>STRATEGY:</b> Drilling <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm	<b>MAXIMUM SPINDLE SPEED:</b> 2193rpm <b>MAXIMUM FEEDRATE:</b> 1359.537mm/min <b>CUTTING DISTANCE:</b> 14.67mm <b>RAPID DISTANCE:</b> 36.67mm <b>ESTIMATED CYCLE TIME:</b> 1s (0.1%) <b>COOLANT:</b> Flood	<b>T46 D46 L46</b> <b>TYPE:</b> drill <b>DIAMETER:</b> 18mm <b>TIP ANGLE:</b> 147° <b>LENGTH:</b> 80mm <b>FLUTES:</b> 2 <b>DESCRIPTION:</b> allargatura foro corpo centrale <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 860.1-1800-050A1-PM	
Operation 43/60 <b>DESCRIPTION:</b> foro anteriore 14x16,5mm <b>STRATEGY:</b> Drilling <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm	<b>MAXIMUM SPINDLE SPEED:</b> 2865rpm <b>MAXIMUM FEEDRATE:</b> 1627.2mm/min <b>CUTTING DISTANCE:</b> 25.03mm <b>RAPID DISTANCE:</b> 173.03mm <b>ESTIMATED CYCLE TIME:</b> 3s (0.2%) <b>COOLANT:</b> Flood	<b>T26 D26 L26</b> <b>TYPE:</b> drill <b>DIAMETER:</b> 14mm <b>TIP ANGLE:</b> 147° <b>LENGTH:</b> 134mm <b>FLUTES:</b> 2 <b>DESCRIPTION:</b> Foro da 14mm <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 860.1-1400-115A1-PM	
Operation 44/60 <b>DESCRIPTION:</b> preforo 34x46 <b>STRATEGY:</b> Drilling <b>WCS:</b> #1 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm	<b>MAXIMUM SPINDLE SPEED:</b> 2387rpm <b>MAXIMUM FEEDRATE:</b> 596.831mm/min <b>CUTTING DISTANCE:</b> 61mm <b>RAPID DISTANCE:</b> 77mm <b>ESTIMATED CYCLE TIME:</b> 7s (0.4%) <b>COOLANT:</b> Air through tool	<b>T11 D11 L11</b> <b>TYPE:</b> drill <b>DIAMETER:</b> 34mm <b>TIP ANGLE:</b> 176° <b>LENGTH:</b> 130.37mm <b>FLUTES:</b> 2 <b>DESCRIPTION:</b> Pre foro 35 (H15 tolleranza) <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> 880-D3400L40-03	

<p>Operation 45/60  <b>DESCRIPTION:</b> barenatura 35x92  <b>STRATEGY:</b> Drilling  <b>WCS:</b> #1  <b>TOLERANCE:</b> 0.01mm  <b>STOCK TO LEAVE:</b> 0mm</p>	<p><b>MAXIMUM SPINDLE SPEED:</b> 1400rpm  <b>MAXIMUM FEEDRATE:</b> 333.333mm/min  <b>CUTTING DISTANCE:</b> 97mm  <b>RAPID DISTANCE:</b> 103mm  <b>ESTIMATED CYCLE TIME:</b> 19s (1.2%)  <b>COOLANT:</b> Flood</p>	<p><b>T16 D16 L16</b>  <b>TYPE:</b> boring bar  <b>DIAMETER:</b> 35mm  <b>LENGTH:</b> 99mm  <b>FLUTES:</b> 1  <b>DESCRIPTION:</b> barenatura 35 mm  <b>VENDOR:</b> Sandvik  <b>PRODUCT:</b> 825-45TC09-C3</p>	
<p>Operation 46/60  <b>DESCRIPTION:</b> spallamento superiore 45mm  <b>STRATEGY:</b> Contour 2D  <b>WCS:</b> #1  <b>TOLERANCE:</b> 0.01mm  <b>STOCK TO LEAVE:</b> 0mm  <b>MAXIMUM STEPOVER:</b> 15.2mm</p>	<p><b>MAXIMUM SPINDLE SPEED:</b> 4934rpm  <b>MAXIMUM FEEDRATE:</b> 986.736mm/min  <b>CUTTING DISTANCE:</b> 117.76mm  <b>RAPID DISTANCE:</b> 25.4mm  <b>ESTIMATED CYCLE TIME:</b> 9s (0.6%)  <b>COOLANT:</b> Flood</p>	<p><b>T4 D4 L4</b>  <b>TYPE:</b> flat end mill  <b>DIAMETER:</b> 16mm  <b>LENGTH:</b> 42mm  <b>FLUTES:</b> 5  <b>DESCRIPTION:</b> Tasche  <b>VENDOR:</b> Sandvik  <b>PRODUCT:</b> 2N342-1600-PD</p>	
<p>Operation 47/60  <b>DESCRIPTION:</b> slot spallamento superiore  <b>STRATEGY:</b> Circular  <b>WCS:</b> #1  <b>STOCK TO LEAVE:</b> 0mm  <b>MAXIMUM STEPDOWN:</b> 1mm</p>	<p><b>MAXIMUM SPINDLE SPEED:</b> 7548rpm  <b>MAXIMUM FEEDRATE:</b> 758.529mm/min  <b>CUTTING DISTANCE:</b> 375.83mm  <b>RAPID DISTANCE:</b> 78.77mm  <b>ESTIMATED CYCLE TIME:</b> 31s (1.9%)  <b>COOLANT:</b> Flood</p>	<p><b>T41 D41 L41</b>  <b>TYPE:</b> slot mill  <b>DIAMETER:</b> 9.7mm  <b>CORNER RADIUS:</b> 0.2mm  <b>LENGTH:</b> 41.5mm  <b>FLUTES:</b> 3  <b>DESCRIPTION:</b> Slot S2  <b>VENDOR:</b> Sandvik  <b>PRODUCT:</b> 327R06-10 15002-GM</p>	
<p>Operation 48/60  <b>DESCRIPTION:</b> slot corpo anteriore 1  <b>STRATEGY:</b> Circular  <b>WCS:</b> #1  <b>STOCK TO LEAVE:</b> 0mm  <b>MAXIMUM STEPDOWN:</b> 1mm</p>	<p><b>MAXIMUM SPINDLE SPEED:</b> 5000rpm  <b>MAXIMUM FEEDRATE:</b> 1000mm/min  <b>CUTTING DISTANCE:</b> 79.4mm  <b>RAPID DISTANCE:</b> 56.9mm  <b>ESTIMATED CYCLE TIME:</b> 5s (0.3%)  <b>COOLANT:</b> Flood</p>	<p><b>T42 D42 L42</b>  <b>TYPE:</b> slot mill  <b>DIAMETER:</b> 10mm  <b>LENGTH:</b> 40mm  <b>FLUTES:</b> 7  <b>DESCRIPTION:</b> Prova 2 S2 contour</p>	
<p>Operation 49/60  <b>DESCRIPTION:</b> slot corpo anteriore 2  <b>STRATEGY:</b> Circular  <b>WCS:</b> #1  <b>STOCK TO LEAVE:</b> 0mm  <b>MAXIMUM STEPDOWN:</b> 1mm</p>	<p><b>MAXIMUM SPINDLE SPEED:</b> 7548rpm  <b>MAXIMUM FEEDRATE:</b> 758.529mm/min  <b>CUTTING DISTANCE:</b> 68.34mm  <b>RAPID DISTANCE:</b> 50mm  <b>ESTIMATED CYCLE TIME:</b> 6s (0.4%)  <b>COOLANT:</b> Flood</p>	<p><b>T41 D41 L41</b>  <b>TYPE:</b> slot mill  <b>DIAMETER:</b> 9.7mm  <b>CORNER RADIUS:</b> 0.2mm  <b>LENGTH:</b> 41.5mm  <b>FLUTES:</b> 3  <b>DESCRIPTION:</b> Slot S2  <b>VENDOR:</b> Sandvik  <b>PRODUCT:</b> 327R06-10 15002-GM</p>	
<p>Operation 50/60  <b>DESCRIPTION:</b> contornatura sm con raggi sx  <b>STRATEGY:</b> Contour 2D  <b>WCS:</b> #1  <b>TOLERANCE:</b> 0.01mm  <b>STOCK TO LEAVE:</b> 0mm  <b>MAXIMUM STEPOVER:</b> 7.6mm</p>	<p><b>MAXIMUM SPINDLE SPEED:</b> 2274rpm  <b>MAXIMUM FEEDRATE:</b> 682.093mm/min  <b>CUTTING DISTANCE:</b> 75.35mm  <b>RAPID DISTANCE:</b> 30.5mm  <b>ESTIMATED CYCLE TIME:</b> 9s (0.6%)  <b>COOLANT:</b> Flood</p>	<p><b>T47 D47 L47</b>  <b>TYPE:</b> bullnose end mill  <b>DIAMETER:</b> 14mm  <b>CORNER RADIUS:</b> 3mm  <b>LENGTH:</b> 70mm  <b>FLUTES:</b> 4  <b>DESCRIPTION:</b> Contour sm con raggi S2  <b>VENDOR:</b> Sandvik  <b>PRODUCT:</b> R216.24-14050GAK26P</p>	
<p>Operation 51/60  <b>DESCRIPTION:</b> contornatura sm con raggi dx  <b>STRATEGY:</b> Contour 2D  <b>WCS:</b> #1  <b>TOLERANCE:</b> 0.01mm  <b>STOCK TO LEAVE:</b> 0mm  <b>MAXIMUM STEPOVER:</b> 7.6mm</p>	<p><b>MAXIMUM SPINDLE SPEED:</b> 2274rpm  <b>MAXIMUM FEEDRATE:</b> 682.093mm/min  <b>CUTTING DISTANCE:</b> 81.38mm  <b>RAPID DISTANCE:</b> 33.1mm  <b>ESTIMATED CYCLE TIME:</b> 10s (0.6%)  <b>COOLANT:</b> Flood</p>	<p><b>T47 D47 L47</b>  <b>TYPE:</b> bullnose end mill  <b>DIAMETER:</b> 14mm  <b>CORNER RADIUS:</b> 3mm  <b>LENGTH:</b> 70mm  <b>FLUTES:</b> 4  <b>DESCRIPTION:</b> Contour sm con raggi S2  <b>VENDOR:</b> Sandvik  <b>PRODUCT:</b> R216.24-14050GAK26P</p>	
<p>Operation 52/60  <b>DESCRIPTION:</b> finitura lato sx corpo anteriore  <b>STRATEGY:</b> Contour 2D  <b>WCS:</b> #1  <b>TOLERANCE:</b> 0.01mm  <b>STOCK TO LEAVE:</b> 0mm  <b>MAXIMUM STEPOVER:</b> 12.06mm</p>	<p><b>MAXIMUM SPINDLE SPEED:</b> 7519rpm  <b>MAXIMUM FEEDRATE:</b> 864.7mm/min  <b>CUTTING DISTANCE:</b> 45.25mm  <b>RAPID DISTANCE:</b> 62.73mm  <b>ESTIMATED CYCLE TIME:</b> 6s (0.4%)  <b>COOLANT:</b> Flood</p>	<p><b>T39 D39 L39</b>  <b>TYPE:</b> flat end mill  <b>DIAMETER:</b> 12.7mm  <b>LENGTH:</b> 37.1mm  <b>FLUTES:</b> 5  <b>DESCRIPTION:</b> Spallamento fori  <b>VENDOR:</b> Sandvik  <b>PRODUCT:</b> 2N342-1270-PD</p>	
<p>Operation 53/60  <b>DESCRIPTION:</b> finitura lato dx corpo anteriore  <b>STRATEGY:</b> Contour 2D  <b>WCS:</b> #1  <b>TOLERANCE:</b> 0.01mm  <b>STOCK TO LEAVE:</b> 0mm  <b>MAXIMUM STEPOVER:</b> 12.06mm</p>	<p><b>MAXIMUM SPINDLE SPEED:</b> 7519rpm  <b>MAXIMUM FEEDRATE:</b> 864.7mm/min  <b>CUTTING DISTANCE:</b> 47.25mm  <b>RAPID DISTANCE:</b> 60.73mm  <b>ESTIMATED CYCLE TIME:</b> 6s (0.4%)  <b>COOLANT:</b> Flood</p>	<p><b>T39 D39 L39</b>  <b>TYPE:</b> flat end mill  <b>DIAMETER:</b> 12.7mm  <b>LENGTH:</b> 37.1mm  <b>FLUTES:</b> 5  <b>DESCRIPTION:</b> Spallamento fori  <b>VENDOR:</b> Sandvik  <b>PRODUCT:</b> 2N342-1270-PD</p>	
<p>Operation 54/60  <b>DESCRIPTION:</b> smusso fori 5mm  <b>STRATEGY:</b> Contour 2D  <b>WCS:</b> #1  <b>TOLERANCE:</b> 0.01mm  <b>STOCK TO LEAVE:</b> 0mm  <b>MAXIMUM STEPOVER:</b> 5.7mm</p>	<p><b>MAXIMUM SPINDLE SPEED:</b> 5836rpm  <b>MAXIMUM FEEDRATE:</b> 1960.789mm/min  <b>CUTTING DISTANCE:</b> 161.79mm  <b>RAPID DISTANCE:</b> 224.88mm  <b>ESTIMATED CYCLE TIME:</b> 16s (1%)  <b>COOLANT:</b> Flood</p>	<p><b>T37 D37 L37</b>  <b>TYPE:</b> chamfer mill  <b>DIAMETER:</b> 6mm  <b>TAPER ANGLE:</b> 45°  <b>LENGTH:</b> 36mm  <b>FLUTES:</b> 4  <b>DESCRIPTION:</b> Smusso 45° interno S1  <b>VENDOR:</b> Sandvik  <b>PRODUCT:</b> 1C050-0100-045-XA</p>	
<p>Operation 55/60  <b>DESCRIPTION:</b> smusso corpo anteriore  <b>STRATEGY:</b> Contour 2D  <b>WCS:</b> #1  <b>TOLERANCE:</b> 0.01mm  <b>STOCK TO LEAVE:</b> 0mm  <b>MAXIMUM STEPOVER:</b> 5.7mm</p>	<p><b>MAXIMUM SPINDLE SPEED:</b> 5836rpm  <b>MAXIMUM FEEDRATE:</b> 1960.789mm/min  <b>CUTTING DISTANCE:</b> 147.51mm  <b>RAPID DISTANCE:</b> 11.4mm  <b>ESTIMATED CYCLE TIME:</b> 5s (0.3%)  <b>COOLANT:</b> Flood</p>	<p><b>T37 D37 L37</b>  <b>TYPE:</b> chamfer mill  <b>DIAMETER:</b> 6mm  <b>TAPER ANGLE:</b> 45°  <b>LENGTH:</b> 36mm  <b>FLUTES:</b> 4  <b>DESCRIPTION:</b> Smusso 45° interno S1  <b>VENDOR:</b> Sandvik  <b>PRODUCT:</b> 1C050-0100-045-XA</p>	

Operation 56/60 DESCRIPTION: smusso spallamento superiore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 5836rpm MAXIMUM FEEDRATE: 1960.789mm/min CUTTING DISTANCE: 161.6mm RAPID DISTANCE: 38.4mm ESTIMATED CYCLE TIME: 8s (0.5%) COOLANT: Flood	<b>T37 D37 L37</b> TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	
Operation 57/60 DESCRIPTION: smusso foro superiore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 5836rpm MAXIMUM FEEDRATE: 1960.789mm/min CUTTING DISTANCE: 117.18mm RAPID DISTANCE: 27.4mm ESTIMATED CYCLE TIME: 5s (0.3%) COOLANT: Flood	<b>T37 D37 L37</b> TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	
Operation 58/60 DESCRIPTION: smusso spallamento posteriore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 5836rpm MAXIMUM FEEDRATE: 1960.789mm/min CUTTING DISTANCE: 70.06mm RAPID DISTANCE: 13.4mm ESTIMATED CYCLE TIME: 3s (0.2%) COOLANT: Flood	<b>T37 D37 L37</b> TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	
Operation 59/60 DESCRIPTION: smusso foro corpo anteriore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 5836rpm MAXIMUM FEEDRATE: 1960.789mm/min CUTTING DISTANCE: 61.78mm RAPID DISTANCE: 11.4mm ESTIMATED CYCLE TIME: 3s (0.2%) COOLANT: Flood	<b>T37 D37 L37</b> TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	
Operation 60/60 DESCRIPTION: smusso foro anteriore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 5836rpm MAXIMUM FEEDRATE: 1960.789mm/min CUTTING DISTANCE: 41.93mm RAPID DISTANCE: 8.4mm ESTIMATED CYCLE TIME: 2s (0.1%) COOLANT: Flood	<b>T37 D37 L37</b> TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	