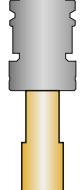
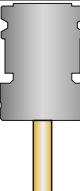
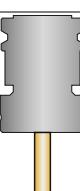


# Setup Sheet for Program 1001

JOB DESCRIPTION: AutoSetup 1

DOCUMENT PATH: X\_TP01\_FORI\_EDIT\_121007 v1

<b>Setup</b>		
<p>WCS: #0</p> <p>STOCK: DX: 160mm DY: 95mm DZ: 35mm</p> <p>PART: DX: 150mm DY: 84.87mm DZ: 25mm</p> <p>STOCK LOWER IN WCS #0: X: -80mm Y: -47.5mm Z: -35mm</p> <p>STOCK UPPER IN WCS #0: X: 80mm Y: 47.5mm Z: 0mm</p>		
<b>Total</b>		
<p>NUMBER OF OPERATIONS: 14</p> <p>NUMBER Of Tools: 12</p> <p>TOOLS: T17000 T17001 T17006 T17009 T17013 T22003 T22005 T22008 T22011 T22012 T22013 T22014</p> <p>MAXIMUM Z: 6.05mm</p> <p>MINIMUM Z: -30.25mm</p> <p>MAXIMUM FEEDRATE: 2470mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8000rpm</p> <p>CUTTING DISTANCE: 27196.61mm</p> <p>RAPID DISTANCE: 16102.92mm</p> <p>ESTIMATED CYCLE TIME: 45m:17s</p>		
<b>Tools</b>		
<b>T17000</b> D17000 L17000	MINIMUM Z: -30.25mm MAXIMUM FEED: 2470mm/min MAXIMUM SPINDLE SPEED: 1880rpm CUTTING DISTANCE: 7196.44mm RAPID DISTANCE: 6651.85mm ESTIMATED CYCLE TIME: 4m:15s (9.4%)	HOLDER: BT40 - B4C4-1000
TYPE: flat end mill DIAMETER: 40mm LENGTH: 100mm FLUTES: 4 DESCRIPTION: CoroMill490 Sgrossatura VENDOR: Sandvik PRODUCT: <a href="#">490-040A32-14H</a>		
<b>T17001</b> D17001 L17001	MINIMUM Z: -30.25mm MAXIMUM FEED: 695mm/min MAXIMUM SPINDLE SPEED: 1620rpm CUTTING DISTANCE: 2520.67mm RAPID DISTANCE: 2487.58mm ESTIMATED CYCLE TIME: 5m:36s (12.4%)	HOLDER: BT40 - B4C4-1000
TYPE: flat end mill DIAMETER: 14mm LENGTH: 60mm FLUTES: 5 DESCRIPTION: CoroMill Plura Contornatura VENDOR: Sandvik PRODUCT: <a href="#">2N342-1400-PC 1730</a>		
<b>T17006</b> D17006 L17006	MINIMUM Z: -19.58mm MAXIMUM FEED: 113mm/min MAXIMUM SPINDLE SPEED: 4010rpm CUTTING DISTANCE: 602.7mm RAPID DISTANCE: 1151.8mm ESTIMATED CYCLE TIME: 5m:34s (12.3%)	HOLDER: BT40 - B4C4-1000
TYPE: drill DIAMETER: 2.5mm TIP ANGLE: 140° LENGTH: 38mm FLUTES: 2 DESCRIPTION: CoroDrill 862 Foripiccoli VENDOR: Sandvik PRODUCT: <a href="#">862.1-2500-225A0-GM X2BL</a>		
<b>T17009</b> D17009 L17009	MINIMUM Z: -30.13mm MAXIMUM FEED: 2100mm/min MAXIMUM SPINDLE SPEED: 3710rpm CUTTING DISTANCE: 496.04mm RAPID DISTANCE: 35.72mm ESTIMATED CYCLE TIME: 19s (0.7%)	HOLDER: BT40 - B4C4-1000
TYPE: flat end mill DIAMETER: 12mm LENGTH: 60mm FLUTES: 4 DESCRIPTION: CoroMill Dura Finituracontornatura VENDOR: Sandvik PRODUCT: <a href="#">1K334-1200-XB 1730</a>		
<b>T17013</b> D17013 L17013	MINIMUM Z: -16mm MAXIMUM FEED: 2330mm/min MAXIMUM SPINDLE SPEED: 8000rpm CUTTING DISTANCE: 2433.55mm RAPID DISTANCE: 998.24mm ESTIMATED CYCLE TIME: 1m:45s (3.9%)	HOLDER: BT40 - B4C4-1000
TYPE: flat end mill DIAMETER: 4mm LENGTH: 30mm FLUTES: 3 DESCRIPTION: CoroMill Plura FinituraTascheLaterali VENDOR: Sandvik PRODUCT: <a href="#">R216.23-04050CAK11P 1620</a>		

**T22003** D22003 L22003

**TYPE:** bullnose end mill  
**DIAMETER:** 8mm  
**CORNER RADIUS:** 0.2mm  
**LENGTH:** 45mm  
**FLUTES:** 5  
**DESCRIPTION:** Sgrossatura tasche 1  
**PRODUCT:** [1K325-0800-XB 1730](#)

**MINIMUM Z:** -16mm  
**MAXIMUM FEED:** 2170mm/min  
**MAXIMUM SPINDLE SPEED:** 2170rpm  
**CUTTING DISTANCE:** 7219.48mm  
**RAPID DISTANCE:** 2494.03mm  
**ESTIMATED CYCLE TIME:** 12m:54s (28.5%)

**T22005** D22005 L22005

**TYPE:** face mill  
**DIAMETER:** 25mm  
**CORNER RADIUS:** 1.6mm  
**LENGTH:** 50mm  
**FLUTES:** 2  
**DESCRIPTION:** Fresa per creazione foro centrale  
**PRODUCT:** [R390-025A25-17L](#)

**MINIMUM Z:** -4.5mm  
**MAXIMUM FEED:** 1687.3mm/min  
**MAXIMUM SPINDLE SPEED:** 3590rpm  
**CUTTING DISTANCE:** 2559.95mm  
**RAPID DISTANCE:** 10.59mm  
**ESTIMATED CYCLE TIME:** 1m:31s (3.4%)

**T22008** D22008 L22008

**TYPE:** face mill  
**DIAMETER:** 50mm  
**CORNER RADIUS:** 0.8mm  
**LENGTH:** 20mm  
**FLUTES:** 3  
**DESCRIPTION:** facciatura\_finitura  
**VENDOR:** mitsubishi  
**PRODUCT:** [ASX400-050A03R con inserto SOET12T308PEER-JL con grado VP30RT](#)

**MINIMUM Z:** -5mm  
**MAXIMUM FEED:** 333.333mm/min  
**MAXIMUM SPINDLE SPEED:** 955rpm  
**CUTTING DISTANCE:** 1616.94mm  
**RAPID DISTANCE:** 5.59mm  
**ESTIMATED CYCLE TIME:** 5m:39s (12.5%)

**T22011** D22011 L22011

**TYPE:** flat end mill  
**DIAMETER:** 4mm  
**LENGTH:** 40mm  
**FLUTES:** 5  
**DESCRIPTION:** Fresa per sgrossatura (tasca piccola) e per finitura totale tasche  
**PRODUCT:** [1K334-0400-050-XC 1730](#)

**MINIMUM Z:** -16mm  
**MAXIMUM FEED:** 2106.67mm/min  
**MAXIMUM SPINDLE SPEED:** 7190rpm  
**CUTTING DISTANCE:** 1221.03mm  
**RAPID DISTANCE:** 1460.3mm  
**ESTIMATED CYCLE TIME:** 2m:2s (4.5%)

**T22012** D22012 L22012

**TYPE:** flat end mill  
**DIAMETER:** 32mm  
**LENGTH:** 100mm  
**FLUTES:** 4  
**DESCRIPTION:** fresa per elicoidale  
**VENDOR:** mitsubishi  
**PRODUCT:** [AQXR324SA32S con inserto QOMT1651R-M2 con grado MP6130](#)

**MINIMUM Z:** -30.1mm  
**MAXIMUM FEED:** 250mm/min  
**MAXIMUM SPINDLE SPEED:** 1393rpm  
**CUTTING DISTANCE:** 491.42mm  
**RAPID DISTANCE:** 34.12mm  
**ESTIMATED CYCLE TIME:** 1m:58s (4.4%)

**T22013** D22013 L22013

**TYPE:** bullnose end mill  
**DIAMETER:** 8mm  
**CORNER RADIUS:** 1mm  
**LENGTH:** 50mm  
**FLUTES:** 4  
**DESCRIPTION:** 54\_finitura\_fondo\_tondo  
**VENDOR:** mitsubishi  
**PRODUCT:** [MPMHVRBD0800R100](#)

**MINIMUM Z:** -16mm  
**MAXIMUM FEED:** 1999.2mm/min  
**MAXIMUM SPINDLE SPEED:** 6000rpm  
**CUTTING DISTANCE:** 459.45mm  
**RAPID DISTANCE:** 710.18mm  
**ESTIMATED CYCLE TIME:** 31s (1.1%)

**T22014** D22014 L22014

**TYPE:** ball end mill  
**DIAMETER:** 8mm  
**CORNER RADIUS:** 4mm  
**LENGTH:** 20mm  
**FLUTES:** 4  
**DESCRIPTION:** nervatura tonda  
**VENDOR:** mitsubishi  
**PRODUCT:** [fresa a punta tonda VQ4SVBR04000](#)

**MINIMUM Z:** -16.29mm  
**MAXIMUM FEED:** 1900.001mm/min  
**MAXIMUM SPINDLE SPEED:** 8000rpm  
**CUTTING DISTANCE:** 378.96mm  
**RAPID DISTANCE:** 62.93mm  
**ESTIMATED CYCLE TIME:** 13s (0.5%)

**Operations**

## Operation 1/14

**DESCRIPTION:** 1 Face  
**STRATEGY:** Facing  
**WCS:** #0  
**TOLERANCE:** 0.03mm  
**MAXIMUM STEPDOWN:** 14.13mm  
**MAXIMUM STEPOVER:** 7.5mm

**MAXIMUM Z:** 6.05mm  
**MINIMUM Z:** -4.5mm  
**MAXIMUM SPINDLE SPEED:** 3590rpm  
**MAXIMUM FEEDRATE:** 1687.3mm/min  
**CUTTING DISTANCE:** 2559.95mm  
**RAPID DISTANCE:** 10.59mm  
**ESTIMATED CYCLE TIME:** 1m:31s (3.4%)  
**COOLANT:** Flood

**T22005** D22005 L22005

**TYPE:** face mill  
**DIAMETER:** 25mm  
**CORNER RADIUS:** 1.6mm  
**LENGTH:** 50mm  
**FLUTES:** 2  
**DESCRIPTION:** Fresa per creazione foro centrale  
**PRODUCT:** [R390-025A25-17L](#)



## Operation 2/14

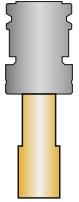
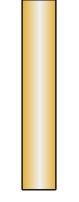
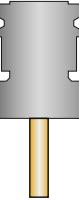
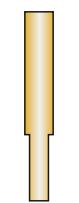
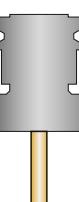
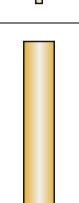
**DESCRIPTION:** 2 Face  
**STRATEGY:** Facing  
**WCS:** #0  
**TOLERANCE:** 0.03mm  
**MAXIMUM STEPOVER:** 15mm

**MAXIMUM Z:** 3.05mm  
**MINIMUM Z:** -5mm  
**MAXIMUM SPINDLE SPEED:** 955rpm  
**MAXIMUM FEEDRATE:** 333.333mm/min  
**CUTTING DISTANCE:** 1616.94mm  
**RAPID DISTANCE:** 5.59mm  
**ESTIMATED CYCLE TIME:** 5m:39s (12.5%)  
**COOLANT:** Flood

**T22008** D22008 L22008

**TYPE:** face mill  
**DIAMETER:** 50mm  
**CORNER RADIUS:** 0.8mm  
**LENGTH:** 20mm  
**FLUTES:** 3  
**DESCRIPTION:** facciatura\_finitura  
**VENDOR:** mitsubishi  
**PRODUCT:** [ASX400-050A03R con inserto SOET12T308PEER-JL con grado VP30RT](#)



Operation 3/14	<p><b>DESCRIPTION:</b> 3 Adaptive Clearing</p> <p><b>STRATEGY:</b> Adaptive</p> <p><b>WCS:</b> #0</p> <p><b>TOLERANCE:</b> 0.05mm</p> <p><b>STOCK TO LEAVE:</b> 0.25mm</p> <p><b>MAXIMUM STEPDOWN:</b> 7.5mm</p> <p><b>OPTIMAL LOAD:</b> 16mm</p> <p><b>LOAD DEVIATION:</b> 1.6mm</p>	<p><b>MAXIMUM Z:</b> 0.51mm</p> <p><b>MINIMUM Z:</b> -30.25mm</p> <p><b>MAXIMUM SPINDLE SPEED:</b> 1880rpm</p> <p><b>MAXIMUM FEEDRATE:</b> 2470mm/min</p> <p><b>CUTTING DISTANCE:</b> 7196.44mm</p> <p><b>RAPID DISTANCE:</b> 6651.85mm</p> <p><b>ESTIMATED CYCLE TIME:</b> 4m:15s (9.4%)</p> <p><b>COOLANT:</b> Air</p>	<p><b>T17000 D17000 L17000</b></p> <p><b>TYPE:</b> flat end mill</p> <p><b>DIAMETER:</b> 40mm</p> <p><b>LENGTH:</b> 100mm</p> <p><b>FLUTES:</b> 4</p> <p><b>DESCRIPTION:</b> CoroMill490 Sgrossatura</p> <p><b>VENDOR:</b> Sandvik</p> <p><b>PRODUCT:</b> <a href="#">490-040A32-14H</a></p>	
Operation 4/14	<p><b>DESCRIPTION:</b> 4 Adaptive Clearing</p> <p><b>STRATEGY:</b> Adaptive</p> <p><b>WCS:</b> #0</p> <p><b>TOLERANCE:</b> 0.05mm</p> <p><b>STOCK TO LEAVE:</b> 0.25mm</p> <p><b>MAXIMUM STEPDOWN:</b> 10.8mm</p> <p><b>OPTIMAL LOAD:</b> 2.4mm</p> <p><b>LOAD DEVIATION:</b> 0.24mm</p>	<p><b>MAXIMUM Z:</b> 0.51mm</p> <p><b>MINIMUM Z:</b> -16mm</p> <p><b>MAXIMUM SPINDLE SPEED:</b> 2170rpm</p> <p><b>MAXIMUM FEEDRATE:</b> 2170mm/min</p> <p><b>CUTTING DISTANCE:</b> 7219.48mm</p> <p><b>RAPID DISTANCE:</b> 2494.03mm</p> <p><b>ESTIMATED CYCLE TIME:</b> 12m:54s (28.5%)</p> <p><b>COOLANT:</b> Flood</p>	<p><b>T22003 D22003 L22003</b></p> <p><b>TYPE:</b> bullnose end mill</p> <p><b>DIAMETER:</b> 8mm</p> <p><b>CORNER RADIUS:</b> 0.2mm</p> <p><b>LENGTH:</b> 45mm</p> <p><b>FLUTES:</b> 5</p> <p><b>DESCRIPTION:</b> Sgrossatura tasche 1</p> <p><b>PRODUCT:</b> <a href="#">1K325-0800-XB 1730</a></p>	
Operation 5/14	<p><b>DESCRIPTION:</b> 5 Adaptive Clearing</p> <p><b>STRATEGY:</b> Adaptive</p> <p><b>WCS:</b> #0</p> <p><b>TOLERANCE:</b> 0.05mm</p> <p><b>STOCK TO LEAVE:</b> 0.25mm</p> <p><b>MAXIMUM STEPDOWN:</b> 22.5mm</p> <p><b>OPTIMAL LOAD:</b> 5.6mm</p> <p><b>LOAD DEVIATION:</b> 0.56mm</p>	<p><b>MAXIMUM Z:</b> 0.51mm</p> <p><b>MINIMUM Z:</b> -30.25mm</p> <p><b>MAXIMUM SPINDLE SPEED:</b> 1620rpm</p> <p><b>MAXIMUM FEEDRATE:</b> 695mm/min</p> <p><b>CUTTING DISTANCE:</b> 2520.67mm</p> <p><b>RAPID DISTANCE:</b> 2487.58mm</p> <p><b>ESTIMATED CYCLE TIME:</b> 5m:36s (12.4%)</p> <p><b>COOLANT:</b> Flood</p>	<p><b>T17001 D17001 L17001</b></p> <p><b>TYPE:</b> flat end mill</p> <p><b>DIAMETER:</b> 14mm</p> <p><b>LENGTH:</b> 60mm</p> <p><b>FLUTES:</b> 5</p> <p><b>DESCRIPTION:</b> CoroMill Plura Contornatura</p> <p><b>VENDOR:</b> Sandvik</p> <p><b>PRODUCT:</b> <a href="#">2N342-1400-PC 1730</a></p>	
Operation 6/14	<p><b>DESCRIPTION:</b> 6 Adaptive Clearing</p> <p><b>STRATEGY:</b> Adaptive</p> <p><b>WCS:</b> #0</p> <p><b>TOLERANCE:</b> 0.05mm</p> <p><b>STOCK TO LEAVE:</b> 0.25mm</p> <p><b>MAXIMUM STEPDOWN:</b> 8.25mm</p> <p><b>OPTIMAL LOAD:</b> 1.6mm</p> <p><b>LOAD DEVIATION:</b> 0.16mm</p>	<p><b>MAXIMUM Z:</b> 0.51mm</p> <p><b>MINIMUM Z:</b> -16mm</p> <p><b>MAXIMUM SPINDLE SPEED:</b> 7190rpm</p> <p><b>MAXIMUM FEEDRATE:</b> 2106.67mm/min</p> <p><b>CUTTING DISTANCE:</b> 1221.03mm</p> <p><b>RAPID DISTANCE:</b> 1460.3mm</p> <p><b>ESTIMATED CYCLE TIME:</b> 2m:2s (4.5%)</p> <p><b>COOLANT:</b> Flood</p>	<p><b>T22011 D22011 L22011</b></p> <p><b>TYPE:</b> flat end mill</p> <p><b>DIAMETER:</b> 4mm</p> <p><b>LENGTH:</b> 40mm</p> <p><b>FLUTES:</b> 5</p> <p><b>DESCRIPTION:</b> Fresa per sgrossatura (tasca piccola) e per finitura totale tasche</p> <p><b>PRODUCT:</b> <a href="#">1K334-0400-050-XC 1730</a></p>	
Operation 7/14	<p><b>DESCRIPTION:</b> 7 2D Contour</p> <p><b>STRATEGY:</b> Contour 2D</p> <p><b>WCS:</b> #0</p> <p><b>TOLERANCE:</b> 0.01mm</p> <p><b>STOCK TO LEAVE:</b> 0mm</p> <p><b>MAXIMUM STEPOVER:</b> 11.4mm</p>	<p><b>MAXIMUM Z:</b> 3.05mm</p> <p><b>MINIMUM Z:</b> -30.13mm</p> <p><b>MAXIMUM SPINDLE SPEED:</b> 3710rpm</p> <p><b>MAXIMUM FEEDRATE:</b> 2100mm/min</p> <p><b>CUTTING DISTANCE:</b> 496.04mm</p> <p><b>RAPID DISTANCE:</b> 35.72mm</p> <p><b>ESTIMATED CYCLE TIME:</b> 19s (0.7%)</p> <p><b>COOLANT:</b> Flood</p>	<p><b>T17009 D17009 L17009</b></p> <p><b>TYPE:</b> flat end mill</p> <p><b>DIAMETER:</b> 12mm</p> <p><b>LENGTH:</b> 60mm</p> <p><b>FLUTES:</b> 4</p> <p><b>DESCRIPTION:</b> CoroMill Dura Finituracontornatura</p> <p><b>VENDOR:</b> Sandvik</p> <p><b>PRODUCT:</b> <a href="#">1K334-1200-XB 1730</a></p>	
Operation 8/14	<p><b>DESCRIPTION:</b> 8 Drill</p> <p><b>STRATEGY:</b> Drilling</p> <p><b>WCS:</b> #0</p> <p><b>TOLERANCE:</b> 0.01mm</p> <p><b>STOCK TO LEAVE:</b> 0mm</p>	<p><b>MAXIMUM Z:</b> 3.05mm</p> <p><b>MINIMUM Z:</b> -19.58mm</p> <p><b>MAXIMUM SPINDLE SPEED:</b> 4010rpm</p> <p><b>MAXIMUM FEEDRATE:</b> 113mm/min</p> <p><b>CUTTING DISTANCE:</b> 602.7mm</p> <p><b>RAPID DISTANCE:</b> 1151.8mm</p> <p><b>ESTIMATED CYCLE TIME:</b> 5m:34s (12.3%)</p> <p><b>COOLANT:</b> Flood</p>	<p><b>T17006 D17006 L17006</b></p> <p><b>TYPE:</b> drill</p> <p><b>DIAMETER:</b> 2.5mm</p> <p><b>TIFF ANGLE:</b> 140°</p> <p><b>LENGTH:</b> 38mm</p> <p><b>FLUTES:</b> 2</p> <p><b>DESCRIPTION:</b> CoroDrill 862 Foripiccoli</p> <p><b>VENDOR:</b> Sandvik</p> <p><b>PRODUCT:</b> <a href="#">862.1-2500-225A0-GM X2BL</a></p>	
Operation 9/14	<p><b>DESCRIPTION:</b> 9 Flat</p> <p><b>WCS:</b> #0</p> <p><b>TOLERANCE:</b> 0.03mm</p> <p><b>STOCK TO LEAVE:</b> 0.13mm/0mm</p> <p><b>MAXIMUM STEPOVER:</b> 2.8mm</p>	<p><b>MAXIMUM Z:</b> 0.51mm</p> <p><b>MINIMUM Z:</b> -16mm</p> <p><b>MAXIMUM SPINDLE SPEED:</b> 8000rpm</p> <p><b>MAXIMUM FEEDRATE:</b> 2330mm/min</p> <p><b>CUTTING DISTANCE:</b> 1195.79mm</p> <p><b>RAPID DISTANCE:</b> 448.7mm</p> <p><b>ESTIMATED CYCLE TIME:</b> 37s (1.4%)</p> <p><b>COOLANT:</b> Flood</p>	<p><b>T17013 D17013 L17013</b></p> <p><b>TYPE:</b> flat end mill</p> <p><b>DIAMETER:</b> 4mm</p> <p><b>LENGTH:</b> 30mm</p> <p><b>FLUTES:</b> 3</p> <p><b>DESCRIPTION:</b> CoroMill Plura FinituraTascheLaterali</p> <p><b>VENDOR:</b> Sandvik</p> <p><b>PRODUCT:</b> <a href="#">R216.23-04050CAK11P 1620</a></p>	
Operation 10/14	<p><b>DESCRIPTION:</b> 10 2D Contour</p> <p><b>STRATEGY:</b> Contour 2D</p> <p><b>WCS:</b> #0</p> <p><b>TOLERANCE:</b> 0mm</p> <p><b>STOCK TO LEAVE:</b> 0mm/0.03mm</p> <p><b>MAXIMUM STEPDOWN:</b> 9.9mm</p> <p><b>MAXIMUM STEPOVER:</b> 3.8mm</p>	<p><b>MAXIMUM Z:</b> 3.05mm</p> <p><b>MINIMUM Z:</b> -15.97mm</p> <p><b>MAXIMUM SPINDLE SPEED:</b> 8000rpm</p> <p><b>MAXIMUM FEEDRATE:</b> 2330mm/min</p> <p><b>CUTTING DISTANCE:</b> 1237.76mm</p> <p><b>RAPID DISTANCE:</b> 549.54mm</p> <p><b>ESTIMATED CYCLE TIME:</b> 1m:8s (2.5%)</p> <p><b>COOLANT:</b> Flood</p>	<p><b>T17013 D17013 L17013</b></p> <p><b>TYPE:</b> flat end mill</p> <p><b>DIAMETER:</b> 4mm</p> <p><b>LENGTH:</b> 30mm</p> <p><b>FLUTES:</b> 3</p> <p><b>DESCRIPTION:</b> CoroMill Plura FinituraTascheLaterali</p> <p><b>VENDOR:</b> Sandvik</p> <p><b>PRODUCT:</b> <a href="#">R216.23-04050CAK11P 1620</a></p>	
Operation 11/14	<p><b>DESCRIPTION:</b> 11 Flat</p> <p><b>WCS:</b> #0</p> <p><b>TOLERANCE:</b> 0.03mm</p> <p><b>STOCK TO LEAVE:</b> 0.13mm/0mm</p> <p><b>MAXIMUM STEPOVER:</b> 4.2mm</p>	<p><b>MAXIMUM Z:</b> 0.51mm</p> <p><b>MINIMUM Z:</b> -16mm</p> <p><b>MAXIMUM SPINDLE SPEED:</b> 6000rpm</p> <p><b>MAXIMUM FEEDRATE:</b> 1999.2mm/min</p> <p><b>CUTTING DISTANCE:</b> 303.39mm</p> <p><b>RAPID DISTANCE:</b> 525.4mm</p> <p><b>ESTIMATED CYCLE TIME:</b> 17s (0.6%)</p> <p><b>COOLANT:</b> Flood</p>	<p><b>T22013 D22013 L22013</b></p> <p><b>TYPE:</b> bullnose end mill</p> <p><b>DIAMETER:</b> 8mm</p> <p><b>CORNER RADIUS:</b> 1mm</p> <p><b>LENGTH:</b> 50mm</p> <p><b>FLUTES:</b> 4</p> <p><b>DESCRIPTION:</b> 54_finitura_fondo_tondo</p> <p><b>VENDOR:</b> mitsubishi</p> <p><b>PRODUCT:</b> <a href="#">MPMHVRBD0800R100</a></p>	

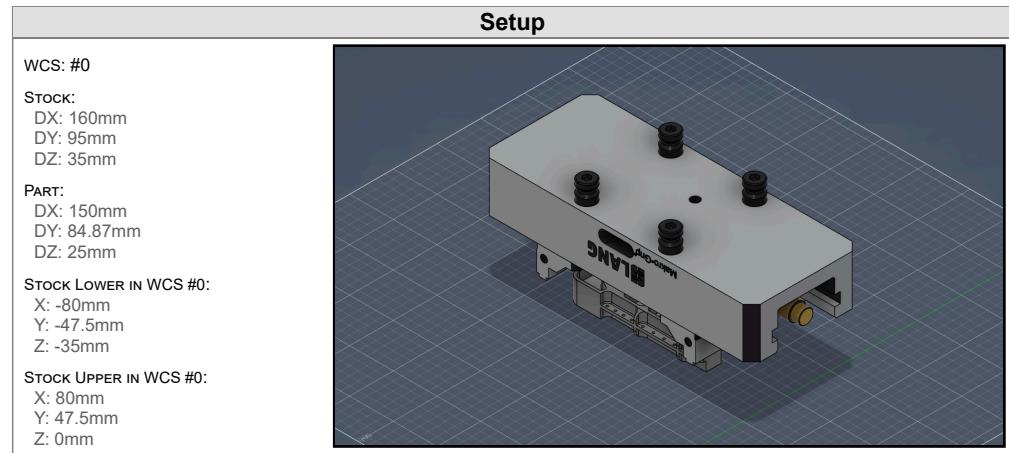
Operation 12/14	MAXIMUM Z: 3.05mm MINIMUM Z: -15.97mm MAXIMUM SPINDLE SPEED: 6000rpm MAXIMUM FEEDRATE: 1999.2mm/min CUTTING DISTANCE: 156.05mm RAPID DISTANCE: 184.78mm ESTIMATED CYCLE TIME: 14s (0.5%) COOLANT: Flood	<b>T22013</b> D22013 L22013 <b>TYPE:</b> bullnose end mill <b>DIAMETER:</b> 8mm <b>CORNER RADIUS:</b> 1mm <b>LENGTH:</b> 50mm <b>FLUTES:</b> 4 <b>DESCRIPTION:</b> 54_finitura_fondo_tondo <b>VENDOR:</b> mitsubishi <b>PRODUCT:</b> <a href="#">MPMHVRBD0800R100</a>	
Operation 13/14	MAXIMUM Z: 0.51mm MINIMUM Z: -30.1mm MAXIMUM SPINDLE SPEED: 1393rpm MAXIMUM FEEDRATE: 250mm/min CUTTING DISTANCE: 491.42mm RAPID DISTANCE: 34.12mm ESTIMATED CYCLE TIME: 1m:58s (4.4%) COOLANT: Flood	<b>T22012</b> D22012 L22012 <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 32mm <b>LENGTH:</b> 100mm <b>FLUTES:</b> 4 <b>DESCRIPTION:</b> fresa per elicoidale <b>VENDOR:</b> mitsubishi <b>PRODUCT:</b> <a href="#">AQXR324SA32S con inserto QOMT1651R-M2 con grado MP6130</a>	
Operation 14/14	MAXIMUM Z: 0.51mm MINIMUM Z: -16.29mm MAXIMUM SPINDLE SPEED: 8000rpm MAXIMUM FEEDRATE: 1900.001mm/min CUTTING DISTANCE: 378.96mm RAPID DISTANCE: 62.93mm ESTIMATED CYCLE TIME: 13s (0.5%) COOLANT: Flood	<b>T22014</b> D22014 L22014 <b>TYPE:</b> ball end mill <b>DIAMETER:</b> 8mm <b>CORNER RADIUS:</b> 4mm <b>LENGTH:</b> 20mm <b>FLUTES:</b> 4 <b>DESCRIPTION:</b> nervatura tonda <b>VENDOR:</b> mitsubishi <b>PRODUCT:</b> <a href="#">fresa a punta tonda VQ4SVBR04000</a>	

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# Setup Sheet for Program 1002

JOB DESCRIPTION: AutoSetup 2

DOCUMENT PATH: X\_TP01\_FORI\_EDIT\_121007 v1



Total	
<p>NUMBER OF OPERATIONS: 9</p> <p>NUMBER OF TOOLS: 6</p> <p>TOOLS: T22003 T22005 T22008 T22011 T22013 T22014</p> <p>MAXIMUM Z: 6.05mm</p> <p>MINIMUM Z: -16.29mm</p> <p>MAXIMUM FEEDRATE: 2170mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8000rpm</p> <p>CUTTING DISTANCE: 14046.77mm</p> <p>RAPID DISTANCE: 5674.07mm</p> <p>ESTIMATED CYCLE TIME: 24m:46s</p>	

Tools	
<p><b>T22003</b> D22003 L22003</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 0.2mm</p> <p>LENGTH: 45mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Sgrossatura tasche 1</p> <p>PRODUCT: <a href="#">1K325-0800-XB 1730</a></p>	
<p><b>T22005</b> D22005 L22005</p> <p>TYPE: face mill</p> <p>DIAMETER: 25mm</p> <p>CORNER RADIUS: 1.6mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: Fresa per creazione foro centrale</p> <p>PRODUCT: <a href="#">R390-025A25-17L</a></p>	
<p><b>T22008</b> D22008 L22008</p> <p>TYPE: face mill</p> <p>DIAMETER: 50mm</p> <p>CORNER RADIUS: 0.8mm</p> <p>LENGTH: 20mm</p> <p>FLUTES: 3</p> <p>DESCRIPTION: facciatura_finitura</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: <a href="#">ASX400-050A03R con inserto SOET12T308PEER-JL con grado VP30RT</a></p>	
<p><b>T22011</b> D22011 L22011</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa per sgrossatura (tasca piccola) e per finitura totale tasche</p> <p>PRODUCT: <a href="#">1K334-0400-050-XC 1730</a></p>	
<p><b>T22013</b> D22013 L22013</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: 54_finitura_fondo_tondo</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: <a href="#">MPMHVRBD0800R100</a></p>	

**T22014** D22014 L22014

**TYPE:** ball end mill  
**DIAMETER:** 8mm  
**CORNER RADIUS:** 4mm  
**LENGTH:** 20mm  
**FLUTES:** 4  
**DESCRIPTION:** nervatura tonda  
**VENDOR:** mitsubishi  
**PRODUCT:** [fresa a punta tonda VQ4SVBR04000](#)

**MINIMUM Z:** -16.29mm  
**MAXIMUM FEED:** 1900.001mm/min  
**MAXIMUM SPINDLE SPEED:** 8000rpm  
**CUTTING DISTANCE:** 376.28mm  
**RAPID DISTANCE:** 62.53mm  
**ESTIMATED CYCLE TIME:** 13s (0.9%)

**Operations**

Operation 1/9	<b>T22005</b> D22005 L22005	
<b>DESCRIPTION:</b> 1 Face (2) <b>STRATEGY:</b> Facing <b>WCS:</b> #0 <b>TOLERANCE:</b> 0.03mm <b>MAXIMUM STEPDOWN:</b> 14.13mm <b>MAXIMUM STEPOVER:</b> 7.5mm	<b>MAXIMUM Z:</b> 6.05mm <b>MINIMUM Z:</b> -4.5mm <b>MAXIMUM SPINDLE SPEED:</b> 3590rpm <b>MAXIMUM FEEDRATE:</b> 1687.3mm/min <b>CUTTING DISTANCE:</b> 2559.95mm <b>RAPID DISTANCE:</b> 10.59mm <b>ESTIMATED CYCLE TIME:</b> 1m:31s (6.1%) <b>COOLANT:</b> Flood	<b>TYPE:</b> face mill <b>DIAMETER:</b> 25mm <b>CORNER RADIUS:</b> 1.6mm <b>LENGTH:</b> 50mm <b>FLUTES:</b> 2 <b>DESCRIPTION:</b> Fresa per creazione foro centrale <b>PRODUCT:</b> <a href="#">R390-025A25-17L</a>
Operation 2/9	<b>T22008</b> D22008 L22008	
<b>DESCRIPTION:</b> 2 Face (2) <b>STRATEGY:</b> Facing <b>WCS:</b> #0 <b>TOLERANCE:</b> 0.03mm <b>MAXIMUM STEPOVER:</b> 15mm	<b>MAXIMUM Z:</b> 3.05mm <b>MINIMUM Z:</b> -5mm <b>MAXIMUM SPINDLE SPEED:</b> 955rpm <b>MAXIMUM FEEDRATE:</b> 333.333mm/min <b>CUTTING DISTANCE:</b> 1614.22mm <b>RAPID DISTANCE:</b> 5.59mm <b>ESTIMATED CYCLE TIME:</b> 5m:38s (22.7%) <b>COOLANT:</b> Flood	<b>TYPE:</b> face mill <b>DIAMETER:</b> 50mm <b>CORNER RADIUS:</b> 0.8mm <b>LENGTH:</b> 20mm <b>FLUTES:</b> 3 <b>DESCRIPTION:</b> facciatura_finitura <b>VENDOR:</b> mitsubishi <b>PRODUCT:</b> <a href="#">ASX400-050A03R con inserto SOET12T308PEER-JL con grado VP30RT</a>
Operation 3/9	<b>T22003</b> D22003 L22003	
<b>DESCRIPTION:</b> 3 Adaptive Clearing (2) <b>STRATEGY:</b> Adaptive <b>WCS:</b> #0 <b>TOLERANCE:</b> 0.05mm <b>STOCK TO LEAVE:</b> 0.25mm <b>MAXIMUM STEPDOWN:</b> 10.8mm <b>OPTIMAL LOAD:</b> 2.4mm <b>LOAD DEVIATION:</b> 0.24mm	<b>MAXIMUM Z:</b> 0.51mm <b>MINIMUM Z:</b> -15.75mm <b>MAXIMUM SPINDLE SPEED:</b> 2170rpm <b>MAXIMUM FEEDRATE:</b> 2170mm/min <b>CUTTING DISTANCE:</b> 6025.82mm <b>RAPID DISTANCE:</b> 2716.63mm <b>ESTIMATED CYCLE TIME:</b> 10m:56s (44.1%) <b>COOLANT:</b> Flood	<b>TYPE:</b> bullnose end mill <b>DIAMETER:</b> 8mm <b>CORNER RADIUS:</b> 0.2mm <b>LENGTH:</b> 45mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Sgrossatura tasche 1 <b>PRODUCT:</b> <a href="#">1K325-0800-XB 1730</a>
Operation 4/9	<b>T22011</b> D22011 L22011	
<b>DESCRIPTION:</b> 4 Adaptive Clearing (2) <b>STRATEGY:</b> Adaptive <b>WCS:</b> #0 <b>TOLERANCE:</b> 0.05mm <b>STOCK TO LEAVE:</b> 0.25mm <b>MAXIMUM STEPDOWN:</b> 8.25mm <b>OPTIMAL LOAD:</b> 1.6mm <b>LOAD DEVIATION:</b> 0.16mm	<b>MAXIMUM Z:</b> 0.51mm <b>MINIMUM Z:</b> -15.75mm <b>MAXIMUM SPINDLE SPEED:</b> 7190rpm <b>MAXIMUM FEEDRATE:</b> 2106.67mm/min <b>CUTTING DISTANCE:</b> 1216.11mm <b>RAPID DISTANCE:</b> 1367.99mm <b>ESTIMATED CYCLE TIME:</b> 2m:1s (8.1%) <b>COOLANT:</b> Flood	<b>TYPE:</b> flat end mill <b>DIAMETER:</b> 4mm <b>LENGTH:</b> 40mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Fresa per sgrossatura (tasca piccola) e per finitura totale tasche <b>PRODUCT:</b> <a href="#">1K334-0400-050-XC 1730</a>
Operation 5/9	<b>T22011</b> D22011 L22011	
<b>DESCRIPTION:</b> 5 Flat <b>WCS:</b> #0 <b>TOLERANCE:</b> 0.03mm <b>STOCK TO LEAVE:</b> 0.13mm/0mm <b>MAXIMUM STEPOVER:</b> 2.8mm	<b>MAXIMUM Z:</b> 0.51mm <b>MINIMUM Z:</b> -16mm <b>MAXIMUM SPINDLE SPEED:</b> 7190rpm <b>MAXIMUM FEEDRATE:</b> 2106.67mm/min <b>CUTTING DISTANCE:</b> 1197.93mm <b>RAPID DISTANCE:</b> 476.91mm <b>ESTIMATED CYCLE TIME:</b> 41s (2.8%) <b>COOLANT:</b> Flood	<b>TYPE:</b> flat end mill <b>DIAMETER:</b> 4mm <b>LENGTH:</b> 40mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Fresa per sgrossatura (tasca piccola) e per finitura totale tasche <b>PRODUCT:</b> <a href="#">1K334-0400-050-XC 1730</a>
Operation 6/9	<b>T22011</b> D22011 L22011	
<b>DESCRIPTION:</b> 6 2D Contour <b>STRATEGY:</b> Contour 2D <b>WCS:</b> #0 <b>TOLERANCE:</b> 0mm <b>STOCK TO LEAVE:</b> 0mm/0.03mm <b>MAXIMUM STEPOVER:</b> 3.8mm	<b>MAXIMUM Z:</b> 3.05mm <b>MINIMUM Z:</b> -15.97mm <b>MAXIMUM SPINDLE SPEED:</b> 4510rpm <b>MAXIMUM FEEDRATE:</b> 369.82mm/min <b>CUTTING DISTANCE:</b> 622.17mm <b>RAPID DISTANCE:</b> 405.32mm <b>ESTIMATED CYCLE TIME:</b> 1m:48s (7.2%) <b>COOLANT:</b> Flood	<b>TYPE:</b> flat end mill <b>DIAMETER:</b> 4mm <b>LENGTH:</b> 40mm <b>FLUTES:</b> 5 <b>DESCRIPTION:</b> Fresa per sgrossatura (tasca piccola) e per finitura totale tasche <b>PRODUCT:</b> <a href="#">1K334-0400-050-XC 1730</a>
Operation 7/9	<b>T22013</b> D22013 L22013	
<b>DESCRIPTION:</b> 7 Flat <b>WCS:</b> #0 <b>TOLERANCE:</b> 0.03mm <b>STOCK TO LEAVE:</b> 0.13mm/0mm <b>MAXIMUM STEPOVER:</b> 4.2mm	<b>MAXIMUM Z:</b> 0.51mm <b>MINIMUM Z:</b> -16mm <b>MAXIMUM SPINDLE SPEED:</b> 6000rpm <b>MAXIMUM FEEDRATE:</b> 1999.2mm/min <b>CUTTING DISTANCE:</b> 278.24mm <b>RAPID DISTANCE:</b> 416.01mm <b>ESTIMATED CYCLE TIME:</b> 14s (1%) <b>COOLANT:</b> Flood	<b>TYPE:</b> bullnose end mill <b>DIAMETER:</b> 8mm <b>CORNER RADIUS:</b> 1mm <b>LENGTH:</b> 50mm <b>FLUTES:</b> 4 <b>DESCRIPTION:</b> 54_finitura_fondo_tondo <b>VENDOR:</b> mitsubishi <b>PRODUCT:</b> <a href="#">MPMHVRBD0800R100</a>
Operation 8/9	<b>T22013</b> D22013 L22013	
<b>DESCRIPTION:</b> 8 2D Contour <b>STRATEGY:</b> Contour 2D <b>WCS:</b> #0 <b>TOLERANCE:</b> 0mm <b>STOCK TO LEAVE:</b> 0mm/0.03mm <b>MAXIMUM STEPOVER:</b> 5.7mm	<b>MAXIMUM Z:</b> 3.05mm <b>MINIMUM Z:</b> -15.97mm <b>MAXIMUM SPINDLE SPEED:</b> 6000rpm <b>MAXIMUM FEEDRATE:</b> 1999.2mm/min <b>CUTTING DISTANCE:</b> 156.05mm <b>RAPID DISTANCE:</b> 212.5mm <b>ESTIMATED CYCLE TIME:</b> 15s (1%) <b>COOLANT:</b> Flood	<b>TYPE:</b> bullnose end mill <b>DIAMETER:</b> 8mm <b>CORNER RADIUS:</b> 1mm <b>LENGTH:</b> 50mm <b>FLUTES:</b> 4 <b>DESCRIPTION:</b> 54_finitura_fondo_tondo <b>VENDOR:</b> mitsubishi <b>PRODUCT:</b> <a href="#">MPMHVRBD0800R100</a>

Operation 9/9  
DESCRIPTION: 9 Scallop  
STRATEGY: Scallop  
WCS: #0  
TOLERANCE: 0.03mm  
STOCK TO LEAVE: 0mm  
MAXIMUM STEPOVER: 0.64mm

MAXIMUM Z: 0.51mm  
MINIMUM Z: -16.29mm  
MAXIMUM SPINDLE SPEED: 8000rpm  
MAXIMUM FEEDRATE: 1900.001mm/min  
CUTTING DISTANCE: 376.28mm  
RAPID DISTANCE: 62.53mm  
ESTIMATED CYCLE TIME: 13s (0.9%)  
COOLANT: Flood

**T22014 D22014 L22014**  
TYPE: ball end mill  
DIAMETER: 8mm  
CORNER RADIUS: 4mm  
LENGTH: 20mm  
FLUTES: 4  
DESCRIPTION: nervatura tonda  
VENDOR: mitsubishi  
PRODUCT: [fresa a punta tonda VQ4SVBR04000](#)



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