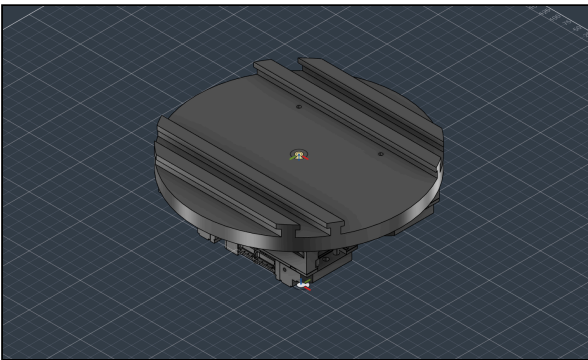


Setup Sheet for Program 1001

JOB DESCRIPTION: Setup1


DOCUMENT PATH: Finito v20 v1

Setup	
<p>WCS: #1</p> <p>Stock:</p> <p>DX: 160mm</p> <p>DY: 295mm</p> <p>DZ: 35mm</p> <p>PART:</p> <p>DX: 150mm</p> <p>DY: 284.87mm</p> <p>DZ: 25mm</p> <p>Stock LOWER IN WCS #1:</p> <p>X: 0mm</p> <p>Y: -295mm</p> <p>Z: -35mm</p> <p>Stock UPPER IN WCS #1:</p> <p>X: 160mm</p> <p>Y: 0mm</p> <p>Z: 0mm</p>	

Total
<p>NUMBER OF OPERATIONS: 24</p> <p>NUMBER OF TOOLS: 14</p> <p>TOOLS: T1 T2 T3 T4 T5 T6 T7 T8 T9 T10 T12 T13 T16 T17</p> <p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -35mm</p> <p>MAXIMUM FEEDRATE: 2896.62mm/min</p> <p>MAXIMUM SPINDLE SPEED: 7759rpm</p> <p>CUTTING DISTANCE: 29052.97mm</p> <p>RAPID DISTANCE: 15894.87mm</p> <p>ESTIMATED CYCLE TIME: 47m:5s</p>

Tools		
<p>T1 D1 L1</p> <p>TYPE: drill</p> <p>DIAMETER: 2.5mm</p> <p>TIP ANGLE: 140°</p> <p>LENGTH: 50mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: fori piccoli</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 862.1-2500-225A0-GM X2BL</p>	<p>MINIMUM Z: -21mm</p> <p>MAXIMUM FEED: 177.362mm/min</p> <p>MAXIMUM SPINDLE SPEED: 5067rpm</p> <p>CUTTING DISTANCE: 630mm</p> <p>RAPID DISTANCE: 2345.06mm</p> <p>ESTIMATED CYCLE TIME: 4m:1s (8.5%)</p>	
<p>T2 D2 L2</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 8mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: sgrossatura tasche</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 2P342-0800-PA 1730</p>	<p>MINIMUM Z: -19mm</p> <p>MAXIMUM FEED: 1314.62mm/min</p> <p>MAXIMUM SPINDLE SPEED: 5570rpm</p> <p>CUTTING DISTANCE: 4342.73mm</p> <p>RAPID DISTANCE: 2443.01mm</p> <p>ESTIMATED CYCLE TIME: 5m:51s (12.4%)</p>	
<p>T3 D3 L3</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4.5mm</p> <p>LENGTH: 35mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: SGROSSATURA TASCHE PICCOLE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1P240-0450-XA 1630</p>	<p>MINIMUM Z: -15.5mm</p> <p>MAXIMUM FEED: 367.825mm/min</p> <p>MAXIMUM SPINDLE SPEED: 5659rpm</p> <p>CUTTING DISTANCE: 1557.18mm</p> <p>RAPID DISTANCE: 570.09mm</p> <p>ESTIMATED CYCLE TIME: 5m:15s (11.1%)</p>	
<p>T4 D4 L4</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 5mm</p> <p>CORNER RADIUS: 0.1mm</p> <p>LENGTH: 45mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: FINITURA TASCHE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: R216.33-05050-AK13P</p>	<p>MINIMUM Z: -16mm</p> <p>MAXIMUM FEED: 757.578mm/min</p> <p>MAXIMUM SPINDLE SPEED: 5411rpm</p> <p>CUTTING DISTANCE: 4920.55mm</p> <p>RAPID DISTANCE: 2204.34mm</p> <p>ESTIMATED CYCLE TIME: 9m:4s (19.3%)</p>	
<p>T5 D5 L5</p> <p>TYPE: drill</p> <p>DIAMETER: 12mm</p> <p>TIP ANGLE: 140°</p> <p>LENGTH: 226mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: FORO GRANDE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 861.1-1200-144A1-GM GC34</p>	<p>MINIMUM Z: -35mm</p> <p>MAXIMUM FEED: 891.692mm/min</p> <p>MAXIMUM SPINDLE SPEED: 2533rpm</p> <p>CUTTING DISTANCE: 66mm</p> <p>RAPID DISTANCE: 296mm</p> <p>ESTIMATED CYCLE TIME: 8s (0.3%)</p>	
<p>T6 D6 L6</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 5mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: FORI PER TASCHE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1K334-0600-XB 1730</p>	<p>MINIMUM Z: -15.5mm</p> <p>MAXIMUM FEED: 509.296mm/min</p> <p>MAXIMUM SPINDLE SPEED: 5093rpm</p> <p>CUTTING DISTANCE: 2084.92mm</p> <p>RAPID DISTANCE: 872.32mm</p> <p>ESTIMATED CYCLE TIME: 5m:12s (11.1%)</p>	

T7 D7 L7 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 1mm LENGTH: 50mm FLUTES: 5 DESCRIPTION: FINITURA TASCHE ESTERNE VENDOR: SANDVIK PRODUCT: 1K335-0800-100-XD 1730	MINIMUM Z: -16mm MAXIMUM FEED: 1581.602mm/min MAXIMUM SPINDLE SPEED: 5968rpm CUTTING DISTANCE: 1330.68mm RAPID DISTANCE: 1478.74mm ESTIMATED CYCLE TIME: 1m:22s (2.9%)	
T8 D8 L8 TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 1.6mm LENGTH: 120mm FLUTES: 6 DESCRIPTION: SPIANATURA VENDOR: SANDVIK PRODUCT: 490-040A32-08H	MINIMUM Z: -4.5mm MAXIMUM FEED: 2745.423mm/min MAXIMUM SPINDLE SPEED: 1830rpm CUTTING DISTANCE: 1868.83mm RAPID DISTANCE: 158.26mm ESTIMATED CYCLE TIME: 44s (1.6%)	
T9 D9 L9 TYPE: face mill DIAMETER: 25mm CORNER RADIUS: 1.6mm LENGTH: 50mm FLUTES: 2 DESCRIPTION: SPALLAMENTO VENDOR: SANDVIK PRODUCT: R390-025A25-17L	MINIMUM Z: -19mm MAXIMUM FEED: 2896.62mm/min MAXIMUM SPINDLE SPEED: 4138rpm CUTTING DISTANCE: 5388.63mm RAPID DISTANCE: 3787.71mm ESTIMATED CYCLE TIME: 2m:47s (5.9%)	
T10 D10 L10 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.5mm LENGTH: 50mm FLUTES: 5 DESCRIPTION: FORO GRANDE VENDOR: SANVIK PRODUCT: 1K335-1000-050-XD 1730	MINIMUM Z: -20mm MAXIMUM FEED: 552.968mm/min MAXIMUM SPINDLE SPEED: 3215rpm CUTTING DISTANCE: 410.42mm RAPID DISTANCE: 262.33mm ESTIMATED CYCLE TIME: 48s (1.7%)	
T12 D12 L12 TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 8mm LENGTH: 100mm FLUTES: 2 DESCRIPTION: F SGROSSATURA VENDOR: SANDVIK PRODUCT: R200-024A32-16L	MINIMUM Z: -5mm MAXIMUM FEED: 852.275mm/min MAXIMUM SPINDLE SPEED: 2029rpm CUTTING DISTANCE: 2374.06mm RAPID DISTANCE: 314.55mm ESTIMATED CYCLE TIME: 2m:51s (6.1%)	
T13 D13 L13 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: F LATERALE VENDOR: SANDVIK PRODUCT: 2S342-0800-050-PA 1730	MINIMUM Z: -18.5mm MAXIMUM FEED: 2079.359mm/min MAXIMUM SPINDLE SPEED: 7759rpm CUTTING DISTANCE: 1927.46mm RAPID DISTANCE: 130.56mm ESTIMATED CYCLE TIME: 1m:9s (2.4%)	
T16 D16 L16 TYPE: ball end mill DIAMETER: 2mm CORNER RADIUS: 1mm LENGTH: 50mm FLUTES: 2 DESCRIPTION: raccordo laterale VENDOR: sandvik PRODUCT: R216.42-02030-AI20G 1610	MINIMUM Z: -12.37mm MAXIMUM FEED: 429.718mm/min MAXIMUM SPINDLE SPEED: 7162rpm CUTTING DISTANCE: 1305.57mm RAPID DISTANCE: 401.64mm ESTIMATED CYCLE TIME: 3m:7s (6.6%)	
T17 D17 L17 TYPE: ball end mill DIAMETER: 5mm CORNER RADIUS: 2.5mm LENGTH: 50mm FLUTES: 2 DESCRIPTION: f raccordo laterale VENDOR: sandvik PRODUCT: R216.42-05030-AI05G 1610	MINIMUM Z: -12.19mm MAXIMUM FEED: 802.141mm/min MAXIMUM SPINDLE SPEED: 5730rpm CUTTING DISTANCE: 845.94mm RAPID DISTANCE: 630.25mm ESTIMATED CYCLE TIME: 1m:15s (2.7%)	

Operations			
Operation 1/24 DESCRIPTION: S SUPERIORE STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 25.76mm	MAXIMUM Z: 15mm MINIMUM Z: -4.5mm MAXIMUM SPINDLE SPEED: 1830rpm MAXIMUM FEEDRATE: 2745.423mm/min CUTTING DISTANCE: 1868.83mm RAPID DISTANCE: 158.26mm ESTIMATED CYCLE TIME: 44s (1.6%) COOLANT: Flood	T8 D8 L8 TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 1.6mm LENGTH: 120mm FLUTES: 6 DESCRIPTION: SPIANATURA VENDOR: SANDVIK PRODUCT: 490-040A32-08H	
Operation 2/24 DESCRIPTION: S LATERALE STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 20.71mm	MAXIMUM Z: 10.5mm MINIMUM Z: -19mm MAXIMUM SPINDLE SPEED: 4138rpm MAXIMUM FEEDRATE: 2896.62mm/min CUTTING DISTANCE: 837.51mm RAPID DISTANCE: 239.75mm ESTIMATED CYCLE TIME: 25s (0.9%) COOLANT: Flood	T9 D9 L9 TYPE: face mill DIAMETER: 25mm CORNER RADIUS: 1.6mm LENGTH: 50mm FLUTES: 2 DESCRIPTION: SPALLAMENTO VENDOR: SANDVIK PRODUCT: R390-025A25-17L	

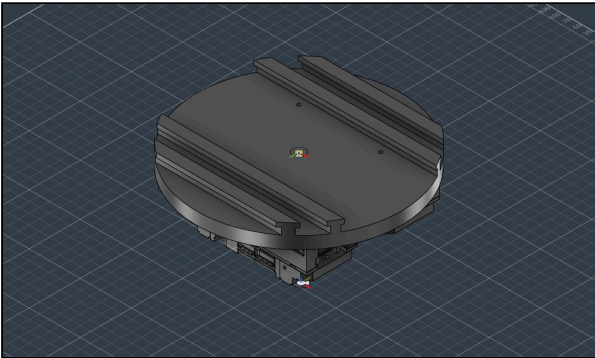
Operation 3/24 DESCRIPTION: S LATERALE STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 20.71mm	MAXIMUM Z: 14.5mm MINIMUM Z: -19mm MAXIMUM SPINDLE SPEED: 4138rpm MAXIMUM FEEDRATE: 2896.62mm/min CUTTING DISTANCE: 804.67mm RAPID DISTANCE: 246.5mm ESTIMATED CYCLE TIME: 25s (0.9%) COOLANT: Flood	T9 D9 L9 TYPE: face mill DIAMETER: 25mm CORNER RADIUS: 1.6mm LENGTH: 50mm FLUTES: 2 DESCRIPTION: SPALLAMENTO VENDOR: SANDVIK PRODUCT: R390-025A25-17L	
Operation 4/24 DESCRIPTION: S LATERALE 2 STRATEGY: Adaptive 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8mm OPTIMAL LOAD: 10mm LOAD DEVIATION: 1mm	MAXIMUM Z: 10.5mm MINIMUM Z: -19mm MAXIMUM SPINDLE SPEED: 4138rpm MAXIMUM FEEDRATE: 2896.62mm/min CUTTING DISTANCE: 1874.47mm RAPID DISTANCE: 1588.73mm ESTIMATED CYCLE TIME: 58s (2%) COOLANT: Flood	T9 D9 L9 TYPE: face mill DIAMETER: 25mm CORNER RADIUS: 1.6mm LENGTH: 50mm FLUTES: 2 DESCRIPTION: SPALLAMENTO VENDOR: SANDVIK PRODUCT: R390-025A25-17L	
Operation 5/24 DESCRIPTION: S LATERALE 2 STRATEGY: Adaptive 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8mm OPTIMAL LOAD: 10mm LOAD DEVIATION: 1mm	MAXIMUM Z: 15mm MINIMUM Z: -19mm MAXIMUM SPINDLE SPEED: 4138rpm MAXIMUM FEEDRATE: 2896.62mm/min CUTTING DISTANCE: 1871.98mm RAPID DISTANCE: 1712.73mm ESTIMATED CYCLE TIME: 59s (2.1%) COOLANT: Flood	T9 D9 L9 TYPE: face mill DIAMETER: 25mm CORNER RADIUS: 1.6mm LENGTH: 50mm FLUTES: 2 DESCRIPTION: SPALLAMENTO VENDOR: SANDVIK PRODUCT: R390-025A25-17L	
Operation 6/24 DESCRIPTION: GUIDE TASCHE STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm/0.5mm MAXIMUM STEPDOWN: 3mm MAXIMUM STEPOVER: 3mm	MAXIMUM Z: 10.5mm MINIMUM Z: -15.5mm MAXIMUM SPINDLE SPEED: 5093rpm MAXIMUM FEEDRATE: 509.296mm/min CUTTING DISTANCE: 2084.92mm RAPID DISTANCE: 872.32mm ESTIMATED CYCLE TIME: 5m:12s (11.1%) COOLANT: Flood	T6 D6 L6 TYPE: flat end mill DIAMETER: 5mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: FORI PER TASCHE VENDOR: SANDVIK PRODUCT: 1K334-0600-XB 1730	
Operation 7/24 DESCRIPTION: S TASCHE STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.5mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 4.8mm	MAXIMUM Z: 10.5mm MINIMUM Z: -15.5mm MAXIMUM SPINDLE SPEED: 4576rpm MAXIMUM FEEDRATE: 640.599mm/min CUTTING DISTANCE: 2175.32mm RAPID DISTANCE: 1058.54mm ESTIMATED CYCLE TIME: 3m:36s (7.7%) COOLANT: Flood	T2 D2 L2 TYPE: flat end mill DIAMETER: 8mm LENGTH: 40mm FLUTES: 4 DESCRIPTION: sgrossature tasche VENDOR: sandvik PRODUCT: 2P342-0800-PA 1730	
Operation 8/24 DESCRIPTION: ULTIMAZIONE S LATERALE STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM Z: 10.5mm MINIMUM Z: -19mm MAXIMUM SPINDLE SPEED: 5570rpm MAXIMUM FEEDRATE: 1314.62mm/min CUTTING DISTANCE: 746.02mm RAPID DISTANCE: 632.67mm ESTIMATED CYCLE TIME: 50s (1.8%) COOLANT: Flood	T2 D2 L2 TYPE: flat end mill DIAMETER: 8mm LENGTH: 40mm FLUTES: 4 DESCRIPTION: sgrossature tasche VENDOR: sandvik PRODUCT: 2P342-0800-PA 1730	
Operation 9/24 DESCRIPTION: S TASCHE LATERALI STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm/1mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 4.8mm	MAXIMUM Z: 15mm MINIMUM Z: -15mm MAXIMUM SPINDLE SPEED: 5570rpm MAXIMUM FEEDRATE: 1314.62mm/min CUTTING DISTANCE: 1421.39mm RAPID DISTANCE: 751.8mm ESTIMATED CYCLE TIME: 1m:25s (3%) COOLANT: Flood	T2 D2 L2 TYPE: flat end mill DIAMETER: 8mm LENGTH: 40mm FLUTES: 4 DESCRIPTION: sgrossature tasche VENDOR: sandvik PRODUCT: 2P342-0800-PA 1730	
Operation 10/24 DESCRIPTION: S TASCA PICCOLA STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.5mm MAXIMUM STEPDOWN: 2.25mm MAXIMUM STEPOVER: 2.7mm	MAXIMUM Z: 10.5mm MINIMUM Z: -15.5mm MAXIMUM SPINDLE SPEED: 4598rpm MAXIMUM FEEDRATE: 367.825mm/min CUTTING DISTANCE: 567.51mm RAPID DISTANCE: 269.56mm ESTIMATED CYCLE TIME: 1m:36s (3.4%) COOLANT: Flood	T3 D3 L3 TYPE: flat end mill DIAMETER: 4.5mm LENGTH: 35mm FLUTES: 4 DESCRIPTION: SGROSSATURA TASCHE PICCOLE VENDOR: SANDVIK PRODUCT: 1P240-0450-XA 1630	
Operation 11/24 DESCRIPTION: S TASCA INCOMPLETA STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.5mm MAXIMUM STEPDOWN: 4.5mm MAXIMUM STEPOVER: 4.28mm	MAXIMUM Z: 10.5mm MINIMUM Z: -15.5mm MAXIMUM SPINDLE SPEED: 5659rpm MAXIMUM FEEDRATE: 333.333mm/min CUTTING DISTANCE: 989.67mm RAPID DISTANCE: 300.54mm ESTIMATED CYCLE TIME: 3m:39s (7.8%) COOLANT: Flood	T3 D3 L3 TYPE: flat end mill DIAMETER: 4.5mm LENGTH: 35mm FLUTES: 4 DESCRIPTION: SGROSSATURA TASCHE PICCOLE VENDOR: SANDVIK PRODUCT: 1P240-0450-XA 1630	
Operation 12/24 DESCRIPTION: FORI PICCOLI STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM Z: 6mm MINIMUM Z: -21mm MAXIMUM SPINDLE SPEED: 5067rpm MAXIMUM FEEDRATE: 177.362mm/min CUTTING DISTANCE: 630mm RAPID DISTANCE: 2345.06mm ESTIMATED CYCLE TIME: 4m:1s (8.5%) COOLANT: Flood	T1 D1 L1 TYPE: drill DIAMETER: 2.5mm TIP ANGLE: 140° LENGTH: 50mm FLUTES: 2 DESCRIPTION: fori piccoli VENDOR: sandvik PRODUCT: 862.1-2500-225A0-GM X2BL	

Operation 13/24 DESCRIPTION: F PARETI TASCHE STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 5mm MAXIMUM STEPOVER: 4.56mm	MAXIMUM Z: 10.5mm MINIMUM Z: -14.5mm MAXIMUM SPINDLE SPEED: 5411rpm MAXIMUM FEEDRATE: 757.578mm/min CUTTING DISTANCE: 2380.48mm RAPID DISTANCE: 1019.04mm ESTIMATED CYCLE TIME: 3m:50s (8.1%) COOLANT: Flood	T4 D4 L4 TYPE: bullnose end mill DIAMETER: 5mm CORNER RADIUS: 0.1mm LENGTH: 45mm FLUTES: 4 DESCRIPTION: FINITURA TASCHE VENDOR: SANDVIK PRODUCT: R216.33-05050-AK13P	
Operation 14/24 DESCRIPTION: F FONDO TASCHE STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 3mm	MAXIMUM Z: 10.5mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 4138rpm MAXIMUM FEEDRATE: 579.324mm/min CUTTING DISTANCE: 2540.07mm RAPID DISTANCE: 1185.31mm ESTIMATED CYCLE TIME: 5m:14s (11.1%) COOLANT: Flood	T4 D4 L4 TYPE: bullnose end mill DIAMETER: 5mm CORNER RADIUS: 0.1mm LENGTH: 45mm FLUTES: 4 DESCRIPTION: FINITURA TASCHE VENDOR: SANDVIK PRODUCT: R216.33-05050-AK13P	
Operation 15/24 DESCRIPTION: F PARETI TASCHE LAT STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM Z: 15mm MINIMUM Z: -12mm MAXIMUM SPINDLE SPEED: 5968rpm MAXIMUM FEEDRATE: 1581.602mm/min CUTTING DISTANCE: 342.38mm RAPID DISTANCE: 490.72mm ESTIMATED CYCLE TIME: 32s (1.1%) COOLANT: Flood	T7 D7 L7 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 1mm LENGTH: 50mm FLUTES: 5 DESCRIPTION: FINITURA TASCHE ESTERNE VENDOR: SANDVIK PRODUCT: 1K335-0800-100-XD 1730	
Operation 16/24 DESCRIPTION: F FONDO TASCHE LAT STRATEGY: Adaptive 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm OPTIMAL LOAD: 3.2mm LOAD DEVIATION: 0.32mm	MAXIMUM Z: 10.5mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 5968rpm MAXIMUM FEEDRATE: 1581.602mm/min CUTTING DISTANCE: 494.11mm RAPID DISTANCE: 494.01mm ESTIMATED CYCLE TIME: 25s (0.9%) COOLANT: Flood	T7 D7 L7 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 1mm LENGTH: 50mm FLUTES: 5 DESCRIPTION: FINITURA TASCHE ESTERNE VENDOR: SANDVIK PRODUCT: 1K335-0800-100-XD 1730	
Operation 17/24 DESCRIPTION: F FONDO TASCHE LAT STRATEGY: Adaptive 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm OPTIMAL LOAD: 3.2mm LOAD DEVIATION: 0.32mm	MAXIMUM Z: 10.5mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 5968rpm MAXIMUM FEEDRATE: 1581.602mm/min CUTTING DISTANCE: 494.18mm RAPID DISTANCE: 494.01mm ESTIMATED CYCLE TIME: 25s (0.9%) COOLANT: Flood	T7 D7 L7 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 1mm LENGTH: 50mm FLUTES: 5 DESCRIPTION: FINITURA TASCHE ESTERNE VENDOR: SANDVIK PRODUCT: 1K335-0800-100-XD 1730	
Operation 18/24 DESCRIPTION: PRE FORO CENTRALE STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM Z: 10.5mm MINIMUM Z: -35mm MAXIMUM SPINDLE SPEED: 2533rpm MAXIMUM FEEDRATE: 891.692mm/min CUTTING DISTANCE: 66mm RAPID DISTANCE: 296mm ESTIMATED CYCLE TIME: 8s (0.3%) COOLANT: Flood	T5 D5 L5 TYPE: drill DIAMETER: 12mm TIP ANGLE: 140° LENGTH: 226mm FLUTES: 2 DESCRIPTION: FORO GRANDE VENDOR: SANDVIK PRODUCT: 861.1-1200-144A1-GM GC34	
Operation 19/24 DESCRIPTION: S FORO CENTRALE STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.5mm/0mm MAXIMUM STEPOVER: 6mm	MAXIMUM Z: 11.5mm MINIMUM Z: -20mm MAXIMUM SPINDLE SPEED: 3215rpm MAXIMUM FEEDRATE: 552.968mm/min CUTTING DISTANCE: 410.42mm RAPID DISTANCE: 262.33mm ESTIMATED CYCLE TIME: 48s (1.7%) COOLANT: Flood	T10 D10 L10 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.5mm LENGTH: 50mm FLUTES: 5 DESCRIPTION: FORO GRANDE VENDOR: SANDVIK PRODUCT: 1K335-1000-050-XD 1730	
Operation 20/24 DESCRIPTION: F SUPERIORE STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 16.8mm	MAXIMUM Z: 10.5mm MINIMUM Z: -5mm MAXIMUM SPINDLE SPEED: 2029rpm MAXIMUM FEEDRATE: 852.275mm/min CUTTING DISTANCE: 2374.06mm RAPID DISTANCE: 314.55mm ESTIMATED CYCLE TIME: 2m:51s (6.1%) COOLANT: Flood	T12 D12 L12 TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 8mm LENGTH: 100mm FLUTES: 2 DESCRIPTION: F SGROSSATURA VENDOR: SANDVIK PRODUCT: R200-024A32-16L	
Operation 21/24 DESCRIPTION: F LATERALE STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 6.65mm	MAXIMUM Z: 14mm MINIMUM Z: -18.5mm MAXIMUM SPINDLE SPEED: 7759rpm MAXIMUM FEEDRATE: 2079.359mm/min CUTTING DISTANCE: 950.67mm RAPID DISTANCE: 59.5mm ESTIMATED CYCLE TIME: 34s (1.2%) COOLANT: Flood	T13 D13 L13 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: F LATERALE VENDOR: SANDVIK PRODUCT: 2S342-0800-050-PA 1730	
Operation 22/24 DESCRIPTION: F LATERALE STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 6.65mm	MAXIMUM Z: 14mm MINIMUM Z: -18.5mm MAXIMUM SPINDLE SPEED: 7759rpm MAXIMUM FEEDRATE: 2079.359mm/min CUTTING DISTANCE: 976.79mm RAPID DISTANCE: 71.06mm ESTIMATED CYCLE TIME: 35s (1.2%) COOLANT: Flood	T13 D13 L13 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: F LATERALE VENDOR: SANDVIK PRODUCT: 2S342-0800-050-PA 1730	

Operation 23/24			
DESCRIPTION: S RACCORDO LATERALE	MAXIMUM Z: 15mm	T17 D17 L17	
STRATEGY: Parallel	MINIMUM Z: -12.19mm	TYPE: ball end mill	
WCS: #1	MAXIMUM SPINDLE SPEED: 5730rpm	DIAMETER: 5mm	
TOLERANCE: 0.01mm	MAXIMUM FEEDRATE: 802.141mm/min	CORNER RADIUS: 2.5mm	
STOCK TO LEAVE: 0mm/0.5mm	CUTTING DISTANCE: 845.94mm	LENGTH: 50mm	
MAXIMUM STEPOVER: 0.2mm	RAPID DISTANCE: 630.25mm	FLUTES: 2	
	ESTIMATED CYCLE TIME: 1m:15s (2.7%)	DESCRIPTION: f raccordo laterale	
	COOLANT: Flood	VENDOR: sandvik	
		PRODUCT: R216.42-05030-AI05G 1610	
Operation 24/24			
DESCRIPTION: F RACCORDO LATERALE	MAXIMUM Z: 15mm	T16 D16 L16	
STRATEGY: Parallel	MINIMUM Z: -12.37mm	TYPE: ball end mill	
WCS: #1	MAXIMUM SPINDLE SPEED: 7162rpm	DIAMETER: 2mm	
TOLERANCE: 0.01mm	MAXIMUM FEEDRATE: 429.718mm/min	CORNER RADIUS: 1mm	
STOCK TO LEAVE: 0mm	CUTTING DISTANCE: 1305.57mm	LENGTH: 50mm	
MAXIMUM STEPOVER: 0.1mm	RAPID DISTANCE: 401.64mm	FLUTES: 2	
	ESTIMATED CYCLE TIME: 3m:7s (6.6%)	DESCRIPTION: raccordo laterale	
	COOLANT: Flood	VENDOR: sandvik	
		PRODUCT: R216.42-02030-AI20G 1610	

Setup Sheet for Program 1002




JOB DESCRIPTION: SETUP2
DOCUMENT PATH: Finito v20 v1

Setup	
<p>WCS: #1</p> <p>Stock:</p> <p>DX: 160mm</p> <p>DY: 295mm</p> <p>DZ: 30.01mm</p> <p>PART:</p> <p>DX: 150mm</p> <p>DY: 284.87mm</p> <p>DZ: 25mm</p> <p>Stock Lower in WCS #1:</p> <p>X: 0mm</p> <p>Y: -295mm</p> <p>Z: -30.01mm</p> <p>Stock Upper in WCS #1:</p> <p>X: 160mm</p> <p>Y: 0mm</p> <p>Z: 0mm</p>	

Total
<p>NUMBER OF OPERATIONS: 23</p> <p>NUMBER OF TOOLS: 13</p> <p>TOOLS: T2 T3 T4 T6 T7 T8 T9 T10 T11 T12 T13 T16 T17</p> <p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -31mm</p> <p>MAXIMUM FEEDRATE: 2896.62mm/min</p> <p>MAXIMUM SPINDLE SPEED: 7427rpm</p> <p>CUTTING DISTANCE: 29106.73mm</p> <p>RAPID DISTANCE: 12580.32mm</p> <p>ESTIMATED CYCLE TIME: 43m:8s</p>

Tools		
<p>T2 D2 L2</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 8mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: sgrossature tasche</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 2P342-0800-PA 1730</p>	<p>MINIMUM Z: -18mm</p> <p>MAXIMUM FEED: 1314.62mm/min</p> <p>MAXIMUM SPINDLE SPEED: 5570rpm</p> <p>CUTTING DISTANCE: 4507.91mm</p> <p>RAPID DISTANCE: 2170.29mm</p> <p>ESTIMATED CYCLE TIME: 5m:53s (13.6%)</p>	
<p>T3 D3 L3</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4.5mm</p> <p>LENGTH: 35mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: SGROSSATURA TASCHE PICCOLE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1P240-0450-XA 1630</p>	<p>MINIMUM Z: -15.5mm</p> <p>MAXIMUM FEED: 367.825mm/min</p> <p>MAXIMUM SPINDLE SPEED: 5659rpm</p> <p>CUTTING DISTANCE: 1556.96mm</p> <p>RAPID DISTANCE: 568.82mm</p> <p>ESTIMATED CYCLE TIME: 5m:15s (12.2%)</p>	
<p>T4 D4 L4</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 5mm</p> <p>CORNER RADIUS: 0.1mm</p> <p>LENGTH: 45mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: FINITURA TASCHE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: R216.33-05050-AK13P</p>	<p>MINIMUM Z: -16mm</p> <p>MAXIMUM FEED: 757.578mm/min</p> <p>MAXIMUM SPINDLE SPEED: 5411rpm</p> <p>CUTTING DISTANCE: 4920.42mm</p> <p>RAPID DISTANCE: 2163.81mm</p> <p>ESTIMATED CYCLE TIME: 9m:4s (21%)</p>	
<p>T6 D6 L6</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 5mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: FORI PER TASCHE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1K334-0600-XB 1730</p>	<p>MINIMUM Z: -15.5mm</p> <p>MAXIMUM FEED: 509.296mm/min</p> <p>MAXIMUM SPINDLE SPEED: 5093rpm</p> <p>CUTTING DISTANCE: 2084.92mm</p> <p>RAPID DISTANCE: 878.21mm</p> <p>ESTIMATED CYCLE TIME: 5m:12s (12.1%)</p>	
<p>T7 D7 L7</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: FINITURA TASCHE ESTERNE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1K335-0800-100-XD 1730</p>	<p>MINIMUM Z: -16mm</p> <p>MAXIMUM FEED: 1581.602mm/min</p> <p>MAXIMUM SPINDLE SPEED: 5968rpm</p> <p>CUTTING DISTANCE: 1404.56mm</p> <p>RAPID DISTANCE: 1209.66mm</p> <p>ESTIMATED CYCLE TIME: 1m:21s (3.1%)</p>	
<p>T8 D8 L8</p> <p>TYPE: face mill</p> <p>DIAMETER: 40mm</p> <p>CORNER RADIUS: 1.6mm</p> <p>LENGTH: 120mm</p> <p>FLUTES: 6</p> <p>DESCRIPTION: SPIANATURA</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 490-040A32-08H</p>	<p>MINIMUM Z: -4.5mm</p> <p>MAXIMUM FEED: 2745.423mm/min</p> <p>MAXIMUM SPINDLE SPEED: 1830rpm</p> <p>CUTTING DISTANCE: 1868.84mm</p> <p>RAPID DISTANCE: 303.76mm</p> <p>ESTIMATED CYCLE TIME: 46s (1.8%)</p>	

T9 D9 L9 TYPE: face mill DIAMETER: 25mm CORNER RADIUS: 1.6mm LENGTH: 50mm FLUTES: 2 DESCRIPTION: SPALLAMENTO VENDOR: SANDVIK PRODUCT: R390-025A25-17L	MINIMUM Z: -19mm MAXIMUM FEED: 2896.62mm/min MAXIMUM SPINDLE SPEED: 4138rpm CUTTING DISTANCE: 5176.03mm RAPID DISTANCE: 3614.09mm ESTIMATED CYCLE TIME: 2m:40s (6.2%)	
T10 D10 L10 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.5mm LENGTH: 50mm FLUTES: 5 DESCRIPTION: FORO GRANDE VENDOR: SANVIK PRODUCT: 1K335-1000-050-XD 1730	MINIMUM Z: -20mm MAXIMUM FEED: 552.968mm/min MAXIMUM SPINDLE SPEED: 3215rpm CUTTING DISTANCE: 410.42mm RAPID DISTANCE: 260.65mm ESTIMATED CYCLE TIME: 48s (1.8%)	
T11 D11 L11 TYPE: boring bar DIAMETER: 40mm LENGTH: 40mm FLUTES: 1 DESCRIPTION: bareno VENDOR: sandvik PRODUCT: 825-45TC09-C3	MINIMUM Z: -31mm MAXIMUM FEED: 262.606mm/min MAXIMUM SPINDLE SPEED: 1313rpm CUTTING DISTANCE: 126mm RAPID DISTANCE: 220mm ESTIMATED CYCLE TIME: 31s (1.2%)	
T12 D12 L12 TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 8mm LENGTH: 100mm FLUTES: 2 DESCRIPTION: F SGROSSATURA VENDOR: SANDVIK PRODUCT: R200-024A32-16L	MINIMUM Z: -5mm MAXIMUM FEED: 852.275mm/min MAXIMUM SPINDLE SPEED: 2029rpm CUTTING DISTANCE: 2069.16mm RAPID DISTANCE: 176.86mm ESTIMATED CYCLE TIME: 2m:28s (5.7%)	
T13 D13 L13 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: F LATERALE VENDOR: SANDVIK PRODUCT: 2S342-0800-050-PA 1730	MINIMUM Z: -22mm MAXIMUM FEED: 2234.535mm/min MAXIMUM SPINDLE SPEED: 7427rpm CUTTING DISTANCE: 2845.5mm RAPID DISTANCE: 153.6mm ESTIMATED CYCLE TIME: 1m:35s (3.7%)	
T16 D16 L16 TYPE: ball end mill DIAMETER: 2mm CORNER RADIUS: 1mm LENGTH: 50mm FLUTES: 2 DESCRIPTION: raccordo laterale VENDOR: sandvik PRODUCT: R216.42-02030-AI20G 1610	MINIMUM Z: -12.31mm MAXIMUM FEED: 429.718mm/min MAXIMUM SPINDLE SPEED: 7162rpm CUTTING DISTANCE: 1320.62mm RAPID DISTANCE: 388.82mm ESTIMATED CYCLE TIME: 3m:10s (7.3%)	
T17 D17 L17 TYPE: ball end mill DIAMETER: 5mm CORNER RADIUS: 2.5mm LENGTH: 50mm FLUTES: 2 DESCRIPTION: f raccordo laterale VENDOR: sandvik PRODUCT: R216.42-05030-AI05G 1610	MINIMUM Z: -11.75mm MAXIMUM FEED: 802.141mm/min MAXIMUM SPINDLE SPEED: 5730rpm CUTTING DISTANCE: 815.39mm RAPID DISTANCE: 471.75mm ESTIMATED CYCLE TIME: 1m:10s (2.7%)	

Operations			
Operation 1/23 DESCRIPTION: S SUPERIORE STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 25.76mm	MAXIMUM Z: 15mm MINIMUM Z: -4.5mm MAXIMUM SPINDLE SPEED: 1830rpm MAXIMUM FEEDRATE: 2745.423mm/min CUTTING DISTANCE: 1868.84mm RAPID DISTANCE: 303.76mm ESTIMATED CYCLE TIME: 46s (1.8%) COOLANT: Flood	T8 D8 L8 TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 1.6mm LENGTH: 120mm FLUTES: 6 DESCRIPTION: SPIANATURA VENDOR: SANDVIK PRODUCT: 490-040A32-08H	
Operation 2/23 DESCRIPTION: S LATERALE STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 20.71mm	MAXIMUM Z: 10.5mm MINIMUM Z: -18mm MAXIMUM SPINDLE SPEED: 4138rpm MAXIMUM FEEDRATE: 2896.62mm/min CUTTING DISTANCE: 836.51mm RAPID DISTANCE: 238.75mm ESTIMATED CYCLE TIME: 24s (0.9%) COOLANT: Flood	T9 D9 L9 TYPE: face mill DIAMETER: 25mm CORNER RADIUS: 1.6mm LENGTH: 50mm FLUTES: 2 DESCRIPTION: SPALLAMENTO VENDOR: SANDVIK PRODUCT: R390-025A25-17L	
Operation 3/23 DESCRIPTION: S LATERALE STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 20.71mm	MAXIMUM Z: 14.5mm MINIMUM Z: -18mm MAXIMUM SPINDLE SPEED: 4138rpm MAXIMUM FEEDRATE: 2896.62mm/min CUTTING DISTANCE: 803.67mm RAPID DISTANCE: 245.5mm ESTIMATED CYCLE TIME: 25s (1%) COOLANT: Flood	T9 D9 L9 TYPE: face mill DIAMETER: 25mm CORNER RADIUS: 1.6mm LENGTH: 50mm FLUTES: 2 DESCRIPTION: SPALLAMENTO VENDOR: SANDVIK PRODUCT: R390-025A25-17L	

Operation 4/23 DESCRIPTION: S LATERALE 2 STRATEGY: Adaptive 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8mm OPTIMAL LOAD: 10mm LOAD DEVIATION: 1mm	MAXIMUM Z: 10.5mm MINIMUM Z: -18mm MAXIMUM SPINDLE SPEED: 4138rpm MAXIMUM FEEDRATE: 2896.62mm/min CUTTING DISTANCE: 1768.29mm RAPID DISTANCE: 1505.3mm ESTIMATED CYCLE TIME: 55s (2.1%) COOLANT: Flood	T9 D9 L9 TYPE: face mill DIAMETER: 25mm CORNER RADIUS: 1.6mm LENGTH: 50mm FLUTES: 2 DESCRIPTION: SPALLAMENTO VENDOR: SANDVIK PRODUCT: R390-025A25-17L	
Operation 5/23 DESCRIPTION: S LATERALE 2 STRATEGY: Adaptive 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8mm OPTIMAL LOAD: 10mm LOAD DEVIATION: 1mm	MAXIMUM Z: 15mm MINIMUM Z: -19mm MAXIMUM SPINDLE SPEED: 4138rpm MAXIMUM FEEDRATE: 2896.62mm/min CUTTING DISTANCE: 1767.56mm RAPID DISTANCE: 1624.54mm ESTIMATED CYCLE TIME: 56s (2.2%) COOLANT: Flood	T9 D9 L9 TYPE: face mill DIAMETER: 25mm CORNER RADIUS: 1.6mm LENGTH: 50mm FLUTES: 2 DESCRIPTION: SPALLAMENTO VENDOR: SANDVIK PRODUCT: R390-025A25-17L	
Operation 6/23 DESCRIPTION: GUIDE TASCHE STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm/0.5mm MAXIMUM STEPDOWN: 3mm MAXIMUM STEPOVER: 3mm	MAXIMUM Z: 10.5mm MINIMUM Z: -15.5mm MAXIMUM SPINDLE SPEED: 5093rpm MAXIMUM FEEDRATE: 509.296mm/min CUTTING DISTANCE: 2084.92mm RAPID DISTANCE: 878.21mm ESTIMATED CYCLE TIME: 5m:12s (12.1%) COOLANT: Flood	T6 D6 L6 TYPE: flat end mill DIAMETER: 5mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: FORI PER TASCHE VENDOR: SANDVIK PRODUCT: 1K334-0600-XB 1730	
Operation 7/23 DESCRIPTION: S TASCHE STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.5mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 4.8mm	MAXIMUM Z: 10.5mm MINIMUM Z: -15.5mm MAXIMUM SPINDLE SPEED: 4576rpm MAXIMUM FEEDRATE: 640.599mm/min CUTTING DISTANCE: 2125.95mm RAPID DISTANCE: 985.57mm ESTIMATED CYCLE TIME: 3m:31s (8.2%) COOLANT: Flood	T2 D2 L2 TYPE: flat end mill DIAMETER: 8mm LENGTH: 40mm FLUTES: 4 DESCRIPTION: sgrossature tasche VENDOR: sandvik PRODUCT: 2P342-0800-PA 1730	
Operation 8/23 DESCRIPTION: ULTIMAZIONE S LATERALE STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM Z: 10.5mm MINIMUM Z: -18mm MAXIMUM SPINDLE SPEED: 5570rpm MAXIMUM FEEDRATE: 1314.62mm/min CUTTING DISTANCE: 971.32mm RAPID DISTANCE: 549.33mm ESTIMATED CYCLE TIME: 59s (2.3%) COOLANT: Flood	T2 D2 L2 TYPE: flat end mill DIAMETER: 8mm LENGTH: 40mm FLUTES: 4 DESCRIPTION: sgrossature tasche VENDOR: sandvik PRODUCT: 2P342-0800-PA 1730	
Operation 9/23 DESCRIPTION: S TASCHE LATERALI STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm/1mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 4.8mm	MAXIMUM Z: 15mm MINIMUM Z: -15mm MAXIMUM SPINDLE SPEED: 5570rpm MAXIMUM FEEDRATE: 1314.62mm/min CUTTING DISTANCE: 1410.63mm RAPID DISTANCE: 635.39mm ESTIMATED CYCLE TIME: 1m:23s (3.2%) COOLANT: Flood	T2 D2 L2 TYPE: flat end mill DIAMETER: 8mm LENGTH: 40mm FLUTES: 4 DESCRIPTION: sgrossature tasche VENDOR: sandvik PRODUCT: 2P342-0800-PA 1730	
Operation 10/23 DESCRIPTION: S TASCA PICCOLA STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.5mm MAXIMUM STEPDOWN: 2.25mm MAXIMUM STEPOVER: 2.7mm	MAXIMUM Z: 10.5mm MINIMUM Z: -15.5mm MAXIMUM SPINDLE SPEED: 4598rpm MAXIMUM FEEDRATE: 367.825mm/min CUTTING DISTANCE: 567.29mm RAPID DISTANCE: 269.56mm ESTIMATED CYCLE TIME: 1m:36s (3.7%) COOLANT: Flood	T3 D3 L3 TYPE: flat end mill DIAMETER: 4.5mm LENGTH: 35mm FLUTES: 4 DESCRIPTION: SGROSSATURA TASCHE PICCOLE VENDOR: SANDVIK PRODUCT: 1P240-0450-XA 1630	
Operation 11/23 DESCRIPTION: S TASCA INCOMPLETA STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.5mm MAXIMUM STEPDOWN: 4.5mm MAXIMUM STEPOVER: 4.28mm	MAXIMUM Z: 10.5mm MINIMUM Z: -15.5mm MAXIMUM SPINDLE SPEED: 5659rpm MAXIMUM FEEDRATE: 333.333mm/min CUTTING DISTANCE: 989.67mm RAPID DISTANCE: 299.26mm ESTIMATED CYCLE TIME: 3m:39s (8.5%) COOLANT: Flood	T3 D3 L3 TYPE: flat end mill DIAMETER: 4.5mm LENGTH: 35mm FLUTES: 4 DESCRIPTION: SGROSSATURA TASCHE PICCOLE VENDOR: SANDVIK PRODUCT: 1P240-0450-XA 1630	
Operation 12/23 DESCRIPTION: F PARETI TASCHE STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 5mm MAXIMUM STEPOVER: 4.56mm	MAXIMUM Z: 10.5mm MINIMUM Z: -14.5mm MAXIMUM SPINDLE SPEED: 5411rpm MAXIMUM FEEDRATE: 757.578mm/min CUTTING DISTANCE: 2380.48mm RAPID DISTANCE: 1024.46mm ESTIMATED CYCLE TIME: 3m:50s (8.9%) COOLANT: Flood	T4 D4 L4 TYPE: bullnose end mill DIAMETER: 5mm CORNER RADIUS: 0.1mm LENGTH: 45mm FLUTES: 4 DESCRIPTION: FINITURA TASCHE VENDOR: SANDVIK PRODUCT: R216.33-05050-AK13P	
Operation 13/23 DESCRIPTION: F FONDO TASCHE STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 3mm	MAXIMUM Z: 10.5mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 4138rpm MAXIMUM FEEDRATE: 579.324mm/min CUTTING DISTANCE: 2539.94mm RAPID DISTANCE: 1139.35mm ESTIMATED CYCLE TIME: 5m:14s (12.1%) COOLANT: Flood	T4 D4 L4 TYPE: bullnose end mill DIAMETER: 5mm CORNER RADIUS: 0.1mm LENGTH: 45mm FLUTES: 4 DESCRIPTION: FINITURA TASCHE VENDOR: SANDVIK PRODUCT: R216.33-05050-AK13P	

<p>Operation 14/23</p> <p>DESCRIPTION: F PARETI TASCHE LAT</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 8mm</p> <p>MAXIMUM STEPOVER: 5.7mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -12mm</p> <p>MAXIMUM SPINDLE SPEED: 5968rpm</p> <p>MAXIMUM FEEDRATE: 1581.602mm/min</p> <p>CUTTING DISTANCE: 342.38mm</p> <p>RAPID DISTANCE: 566.48mm</p> <p>ESTIMATED CYCLE TIME: 33s (1.3%)</p> <p>COOLANT: Flood</p>	<p>T7 D7 L7</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: FINITURA TASCHE ESTERNE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1K335-0800-100-XD 1730</p>	
<p>Operation 15/23</p> <p>DESCRIPTION: F FONDO TASCHE LAT</p> <p>STRATEGY: Adaptive 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>OPTIMAL LOAD: 3.2mm</p> <p>LOAD DEVIATION: 0.32mm</p>	<p>MAXIMUM Z: 10.5mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 5968rpm</p> <p>MAXIMUM FEEDRATE: 1581.602mm/min</p> <p>CUTTING DISTANCE: 531.11mm</p> <p>RAPID DISTANCE: 321.59mm</p> <p>ESTIMATED CYCLE TIME: 24s (0.9%)</p> <p>COOLANT: Flood</p>	<p>T7 D7 L7</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: FINITURA TASCHE ESTERNE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1K335-0800-100-XD 1730</p>	
<p>Operation 16/23</p> <p>DESCRIPTION: F FONDO TASCHE LAT</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>OPTIMAL LOAD: 3.2mm</p> <p>LOAD DEVIATION: 0.32mm</p>	<p>MAXIMUM Z: 10.5mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 5968rpm</p> <p>MAXIMUM FEEDRATE: 1581.602mm/min</p> <p>CUTTING DISTANCE: 531.07mm</p> <p>RAPID DISTANCE: 321.59mm</p> <p>ESTIMATED CYCLE TIME: 24s (0.9%)</p> <p>COOLANT: Flood</p>	<p>T7 D7 L7</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: FINITURA TASCHE ESTERNE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1K335-0800-100-XD 1730</p>	
<p>Operation 17/23</p> <p>DESCRIPTION: S FORO CENTRALE</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.5mm/0mm</p> <p>MAXIMUM STEPOVER: 6mm</p>	<p>MAXIMUM Z: 11.5mm</p> <p>MINIMUM Z: -20mm</p> <p>MAXIMUM SPINDLE SPEED: 3215rpm</p> <p>MAXIMUM FEEDRATE: 552.968mm/min</p> <p>CUTTING DISTANCE: 410.42mm</p> <p>RAPID DISTANCE: 260.65mm</p> <p>ESTIMATED CYCLE TIME: 48s (1.8%)</p> <p>COOLANT: Flood</p>	<p>T10 D10 L10</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 10mm</p> <p>CORNER RADIUS: 0.5mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: FORO GRANDE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1K335-1000-050-XD 1730</p>	
<p>Operation 18/23</p> <p>DESCRIPTION: BARENATURA</p> <p>STRATEGY: Drilling</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p>	<p>MAXIMUM Z: 10.5mm</p> <p>MINIMUM Z: -31mm</p> <p>MAXIMUM SPINDLE SPEED: 1313rpm</p> <p>MAXIMUM FEEDRATE: 262.606mm/min</p> <p>CUTTING DISTANCE: 126mm</p> <p>RAPID DISTANCE: 220mm</p> <p>ESTIMATED CYCLE TIME: 31s (1.2%)</p> <p>COOLANT: Flood</p>	<p>T11 D11 L11</p> <p>TYPE: boring bar</p> <p>DIAMETER: 40mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 1</p> <p>DESCRIPTION: bareno</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 825-45TC09-C3</p>	
<p>Operation 19/23</p> <p>DESCRIPTION: F SUPERIORE</p> <p>STRATEGY: Facing</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>MAXIMUM STEPOVER: 16.8mm</p>	<p>MAXIMUM Z: 10.5mm</p> <p>MINIMUM Z: -5mm</p> <p>MAXIMUM SPINDLE SPEED: 2029rpm</p> <p>MAXIMUM FEEDRATE: 852.275mm/min</p> <p>CUTTING DISTANCE: 2069.16mm</p> <p>RAPID DISTANCE: 176.86mm</p> <p>ESTIMATED CYCLE TIME: 2m:28s (5.7%)</p> <p>COOLANT: Flood</p>	<p>T12 D12 L12</p> <p>TYPE: face mill</p> <p>DIAMETER: 40mm</p> <p>CORNER RADIUS: 8mm</p> <p>LENGTH: 100mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: F SGROSSATURA</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: R200-024A32-16L</p>	
<p>Operation 20/23</p> <p>DESCRIPTION: F LATERALE</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 6mm</p> <p>MAXIMUM STEPOVER: 6.65mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -22mm</p> <p>MAXIMUM SPINDLE SPEED: 7427rpm</p> <p>MAXIMUM FEEDRATE: 2234.535mm/min</p> <p>CUTTING DISTANCE: 1422.75mm</p> <p>RAPID DISTANCE: 76.8mm</p> <p>ESTIMATED CYCLE TIME: 47s (1.8%)</p> <p>COOLANT: Flood</p>	<p>T13 D13 L13</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 0.5mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: F LATERALE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 2S342-0800-050-PA 1730</p>	
<p>Operation 21/23</p> <p>DESCRIPTION: F LATERALE</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 6mm</p> <p>MAXIMUM STEPOVER: 6.65mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -22mm</p> <p>MAXIMUM SPINDLE SPEED: 7427rpm</p> <p>MAXIMUM FEEDRATE: 2234.535mm/min</p> <p>CUTTING DISTANCE: 1422.75mm</p> <p>RAPID DISTANCE: 76.8mm</p> <p>ESTIMATED CYCLE TIME: 47s (1.8%)</p> <p>COOLANT: Flood</p>	<p>T13 D13 L13</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 0.5mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: F LATERALE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 2S342-0800-050-PA 1730</p>	
<p>Operation 22/23</p> <p>DESCRIPTION: S RACCORDO LATERALE</p> <p>STRATEGY: Parallel</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm/0.5mm</p> <p>MAXIMUM STEPOVER: 0.2mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -11.75mm</p> <p>MAXIMUM SPINDLE SPEED: 5730rpm</p> <p>MAXIMUM FEEDRATE: 802.141mm/min</p> <p>CUTTING DISTANCE: 815.39mm</p> <p>RAPID DISTANCE: 471.75mm</p> <p>ESTIMATED CYCLE TIME: 1m:10s (2.7%)</p> <p>COOLANT: Flood</p>	<p>T17 D17 L17</p> <p>TYPE: ball end mill</p> <p>DIAMETER: 5mm</p> <p>CORNER RADIUS: 2.5mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: f raccordo laterale</p> <p>VENDOR: sandvik</p> <p>PRODUCT: R216.42-05030-AI05G 1610</p>	
<p>Operation 23/23</p> <p>DESCRIPTION: F RACCORDO LATERALE</p> <p>STRATEGY: Parallel</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPOVER: 0.1mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -12.31mm</p> <p>MAXIMUM SPINDLE SPEED: 7162rpm</p> <p>MAXIMUM FEEDRATE: 429.718mm/min</p> <p>CUTTING DISTANCE: 1320.62mm</p> <p>RAPID DISTANCE: 388.82mm</p> <p>ESTIMATED CYCLE TIME: 3m:10s (7.3%)</p> <p>COOLANT: Flood</p>	<p>T16 D16 L16</p> <p>TYPE: ball end mill</p> <p>DIAMETER: 2mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: raccordo laterale</p> <p>VENDOR: sandvik</p> <p>PRODUCT: R216.42-02030-AI20G 1610</p>	