

Setup Sheet for Program 1001

JOB DESCRIPTION: AutoSetup 1

DOCUMENT PATH: X_NC03-FORI_EDIT_1210070903 v3

Setup

WCS: #0

Stock:

DX: 160mm

DY: 95mm

DZ: 35mm

PART:

DX: 150mm

DY: 84.87mm

DZ: 25mm

Stock Lower in WCS #0:

X: -80mm

Y: -47.5mm

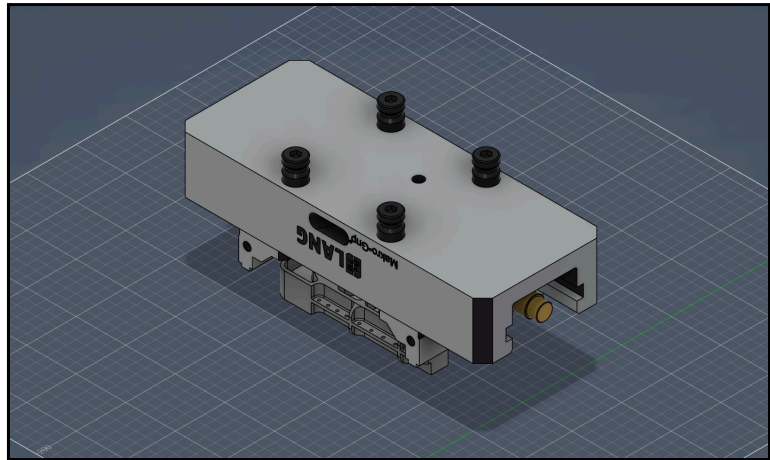
Z: -35mm

Stock Upper in WCS #0:

X: 80mm

Y: 47.5mm

Z: 0mm



Total

NUMBER OF OPERATIONS: 21

NUMBER OF TOOLS: 12

TOOLS: T13000 T13002 T13008 T17002 T17006 T17007 T17009 T19010 T20001 T20002 T20009 T22014

MAXIMUM Z: 15mm

MINIMUM Z: -30.5mm

MAXIMUM FEEDRATE: 4307.336mm/min

MAXIMUM SPINDLE SPEED: 8100rpm

CUTTING DISTANCE: 27506.42mm

RAPID DISTANCE: 18338.62mm

ESTIMATED CYCLE TIME: 31m:47s

Tools

T13000 D13000 L13000

TYPE: face mill

DIAMETER: 40mm

CORNER RADIUS: 0.8mm

TAPER ANGLE: 45°

LENGTH: 40mm

FLUTES: 4

DESCRIPTION: Sgrossatura

VENDOR: Sandvik

PRODUCT: [345-040Q22-13L](#)

MINIMUM Z: -5mm

MAXIMUM FEED: 3819.719mm/min

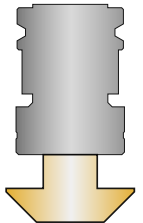
MAXIMUM SPINDLE SPEED: 4775rpm

CUTTING DISTANCE: 1654.86mm

RAPID DISTANCE: 51.75mm

ESTIMATED CYCLE TIME: 42s (2.2%)

HOLDER: BT40 - B4C4-1000



T13002 D13002 L13002

TYPE: bullnose end mill

DIAMETER: 5mm

CORNER RADIUS: 0.5mm

LENGTH: 18.5mm

FLUTES: 5

DESCRIPTION: Tasche

VENDOR: Sandvik

PRODUCT: [1K335-0500-050-XC 1730](#)

MINIMUM Z: -15.75mm

MAXIMUM FEED: 2252.614mm/min

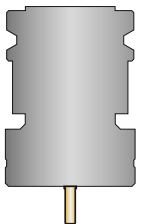
MAXIMUM SPINDLE SPEED: 8100rpm

CUTTING DISTANCE: 3161.18mm

RAPID DISTANCE: 1084.45mm

ESTIMATED CYCLE TIME: 3m:49s (12%)

HOLDER: BT40 - B4C4-1000



T13008 D13008 L13008

TYPE: bullnose end mill

DIAMETER: 4mm

CORNER RADIUS: 1mm

LENGTH: 14.87mm

FLUTES: 5

DESCRIPTION: Finitura fondo

VENDOR: Sandvik

PRODUCT: [R216.23-04050CAK11P 1630](#)

MINIMUM Z: -15.75mm

MAXIMUM FEED: 1834mm/min

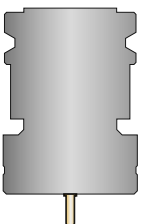
MAXIMUM SPINDLE SPEED: 8100rpm

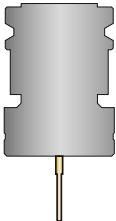
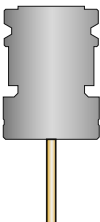
CUTTING DISTANCE: 1181.99mm

RAPID DISTANCE: 562.25mm

ESTIMATED CYCLE TIME: 2m:26s (7.6%)

HOLDER: BT40 - B4C4-1000



T17002 D17002 L17002 TYPE: flat end mill DIAMETER: 2.5mm LENGTH: 21mm FLUTES: 2 DESCRIPTION: CoroMill Plura Tascapiccola VENDOR: Sandvik PRODUCT: 1P250-0250-XA 1630	MINIMUM Z: -15.75mm MAXIMUM FEED: 304.409mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 2769.79mm RAPID DISTANCE: 706.46mm ESTIMATED CYCLE TIME: 9m:14s (29.1%)	HOLDER: BT40 - B4C4-1000	
T17006 D17006 L17006 TYPE: drill DIAMETER: 2.5mm TIP ANGLE: 140° LENGTH: 38mm FLUTES: 2 DESCRIPTION: CoroDrill 862 Foripiccoli VENDOR: Sandvik PRODUCT: 862.1-2500-225A0-GM X2BL	MINIMUM Z: -20.91mm MAXIMUM FEED: 465.75mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 627.3mm RAPID DISTANCE: 1311.37mm ESTIMATED CYCLE TIME: 1m:37s (5.1%)	HOLDER: BT40 - B4C4-1000	
T17007 D17007 L17007 TYPE: flat end mill DIAMETER: 25mm LENGTH: 60mm FLUTES: 2 DESCRIPTION: CoroMill 390 Finituraforogrande VENDOR: Sandvik PRODUCT: R390-025A25-17L	MINIMUM Z: -30.5mm MAXIMUM FEED: 3055.775mm/min MAXIMUM SPINDLE SPEED: 7639rpm CUTTING DISTANCE: 1257.85mm RAPID DISTANCE: 59.5mm ESTIMATED CYCLE TIME: 26s (1.4%)	HOLDER: BT40 - B4C4-1000	
T17009 D17009 L17009 TYPE: flat end mill DIAMETER: 12mm LENGTH: 60mm FLUTES: 4 DESCRIPTION: CoroMill Dura Finituracontornatura VENDOR: Sandvik PRODUCT: 1K334-1200-XB 1730	MINIMUM Z: -30.2mm MAXIMUM FEED: 3110.4mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 528.63mm RAPID DISTANCE: 112.55mm ESTIMATED CYCLE TIME: 20s (1%)	HOLDER: BT40 - B4C4-1000	
T19010 D19010 L19010 TYPE: bullnose end mill DIAMETER: 6mm CORNER RADIUS: 1mm LENGTH: 57mm FLUTES: 5 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-0600-100-XD 1730	MINIMUM Z: -16mm MAXIMUM FEED: 2584.402mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 807.99mm RAPID DISTANCE: 1107.48mm ESTIMATED CYCLE TIME: 57s (3%)	HOLDER: BT40 - B4C4-1000	
T20001 D20001 L20001 TYPE: flat end mill DIAMETER: 8mm LENGTH: 40mm FLUTES: 4 DESCRIPTION: sgrossature tasche VENDOR: sandvik PRODUCT: 2P342-0800-PA 1730	MINIMUM Z: -16mm MAXIMUM FEED: 2756.695mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 2326.38mm RAPID DISTANCE: 1895.69mm ESTIMATED CYCLE TIME: 1m:28s (4.6%)	HOLDER: BT40 - B4C4-1000	
T20002 D20002 L20002 TYPE: flat end mill DIAMETER: 4.5mm LENGTH: 35mm FLUTES: 4 DESCRIPTION: SGROSSATURA TASCHE PICCOLE VENDOR: SANDVIK PRODUCT: 1P240-0450-XA 1630	MINIMUM Z: -16mm MAXIMUM FEED: 1550.641mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 1060.68mm RAPID DISTANCE: 662.11mm ESTIMATED CYCLE TIME: 1m:19s (4.2%)	HOLDER: BT40 - B4C4-1000	
T20009 D20009 L20009 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: -30.2mm MAXIMUM FEED: 4307.336mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 10853.89mm RAPID DISTANCE: 10127.33mm ESTIMATED CYCLE TIME: 4m:39s (14.6%)	HOLDER: BT40 - B4C4-1000	

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: -15.82mm

MAXIMUM FEED: 1900mm/min

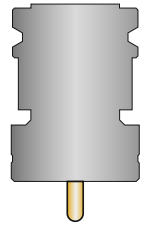
MAXIMUM SPINDLE SPEED: 8100rpm

CUTTING DISTANCE: 1275.89mm

RAPID DISTANCE: 657.67mm

ESTIMATED CYCLE TIME: 1m:6s (3.4%)

HOLDER: BT40 - B4C4-1000

**Operations****Operation 1/21**

DESCRIPTION: Roughing

STRATEGY: Facing

WCS: #0

TOLERANCE: 0.01mm

MAXIMUM STEPDOWN: 16.65mm

MAXIMUM STEPOVER: 30mm

MAXIMUM Z: 15mm

MINIMUM Z: -4.75mm

MAXIMUM SPINDLE SPEED: 2501rpm

MAXIMUM FEEDRATE: 2390mm/min

CUTTING DISTANCE: 933.67mm

RAPID DISTANCE: 25.75mm

ESTIMATED CYCLE TIME: 29s (1.5%)

COOLANT: Flood

T13000 D13000 L13000

TYPE: face mill

DIAMETER: 40mm

CORNER RADIUS: 0.8mm

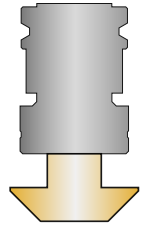
TAPER ANGLE: 45°

LENGTH: 40mm

FLUTES: 4

DESCRIPTION: Sgrossatura

VENDOR: Sandvik

PRODUCT: [345-040Q22-13L](#)**Operation 2/21**

DESCRIPTION: Finishing

STRATEGY: Facing

WCS: #0

TOLERANCE: 0.01mm

MAXIMUM STEPOVER: 36mm

MAXIMUM Z: 15mm

MINIMUM Z: -5mm

MAXIMUM SPINDLE SPEED: 4775rpm

MAXIMUM FEEDRATE: 3819.719mm/min

CUTTING DISTANCE: 721.19mm

RAPID DISTANCE: 26mm

ESTIMATED CYCLE TIME: 13s (0.7%)

COOLANT: Flood

T13000 D13000 L13000

TYPE: face mill

DIAMETER: 40mm

CORNER RADIUS: 0.8mm

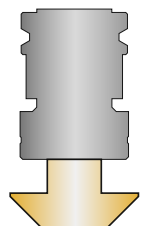
TAPER ANGLE: 45°

LENGTH: 40mm

FLUTES: 4

DESCRIPTION: Sgrossatura

VENDOR: Sandvik

PRODUCT: [345-040Q22-13L](#)**Operation 3/21**

DESCRIPTION: Roughing

STRATEGY: Adaptive

WCS: #0

TOLERANCE: 0.1mm

STOCK TO LEAVE: 0.25mm

MAXIMUM STEPDOWN: 5.15mm

OPTIMAL LOAD: 9.5mm

LOAD DEVIATION: 0.25mm

MAXIMUM Z: 15mm

MINIMUM Z: -30.2mm

MAXIMUM SPINDLE SPEED: 8100rpm

MAXIMUM FEEDRATE: 4307.336mm/min

CUTTING DISTANCE: 10853.89mm

RAPID DISTANCE: 10127.33mm

ESTIMATED CYCLE TIME: 4m:39s (14.6%)

COOLANT: Flood

T20009 D20009 L20009

TYPE: bullnose end mill

DIAMETER: 10mm

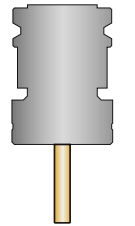
CORNER RADIUS: 0.5mm

LENGTH: 50mm

FLUTES: 5

DESCRIPTION: FORO GRANDE

VENDOR: SANVIK

PRODUCT: [1K335-1000-050-XD 1730](#)**Operation 4/21**

DESCRIPTION: Roughing1

STRATEGY: Adaptive

WCS: #0

TOLERANCE: 0.1mm

STOCK TO LEAVE: 0.25mm

MAXIMUM STEPDOWN: 5.38mm

OPTIMAL LOAD: 7.6mm

LOAD DEVIATION: 0.2mm

MAXIMUM Z: 15mm

MINIMUM Z: -15.75mm

MAXIMUM SPINDLE SPEED: 8100rpm

MAXIMUM FEEDRATE: 2756.695mm/min

CUTTING DISTANCE: 1757.83mm

RAPID DISTANCE: 1423.61mm

ESTIMATED CYCLE TIME: 57s (3%)

COOLANT: Flood

T20001 D20001 L20001

TYPE: flat end mill

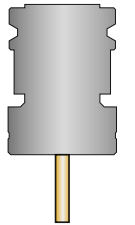
DIAMETER: 8mm

LENGTH: 40mm

FLUTES: 4

DESCRIPTION: sgrossature tasche

VENDOR: sandvik

PRODUCT: [2P342-0800-PA 1730](#)**Operation 5/21**

DESCRIPTION: Roughing2

STRATEGY: Adaptive

WCS: #0

TOLERANCE: 0.1mm

STOCK TO LEAVE: 0.25mm

MAXIMUM STEPDOWN: 4mm

OPTIMAL LOAD: 1.31mm

LOAD DEVIATION: 0.13mm

MAXIMUM Z: 15mm

MINIMUM Z: -15.75mm

MAXIMUM SPINDLE SPEED: 8100rpm

MAXIMUM FEEDRATE: 2252.614mm/min

CUTTING DISTANCE: 3161.18mm

RAPID DISTANCE: 1084.45mm

ESTIMATED CYCLE TIME: 3m:49s (12%)

COOLANT: Flood

T13002 D13002 L13002

TYPE: bullnose end mill

DIAMETER: 5mm

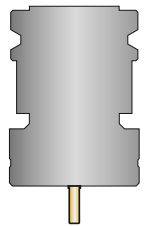
CORNER RADIUS: 0.5mm

LENGTH: 18.5mm

FLUTES: 5

DESCRIPTION: Tasche

VENDOR: Sandvik

PRODUCT: [1K335-0500-050-XC 1730](#)**Operation 6/21**

DESCRIPTION: Roughing3

STRATEGY: Adaptive

WCS: #0

TOLERANCE: 0.1mm

STOCK TO LEAVE: 0.25mm

MAXIMUM STEPDOWN: 3.3mm

OPTIMAL LOAD: 0.9mm

LOAD DEVIATION: 0.09mm

MAXIMUM Z: 15mm

MINIMUM Z: -15.75mm

MAXIMUM SPINDLE SPEED: 8100rpm

MAXIMUM FEEDRATE: 1834mm/min

CUTTING DISTANCE: 1181.99mm

RAPID DISTANCE: 562.25mm

ESTIMATED CYCLE TIME: 2m:26s (7.6%)

COOLANT: Flood

T13008 D13008 L13008

TYPE: bullnose end mill

DIAMETER: 4mm

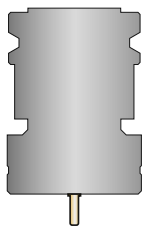
CORNER RADIUS: 1mm

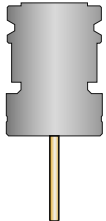
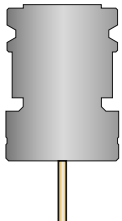
LENGTH: 14.87mm

FLUTES: 5

DESCRIPTION: Finitura fondo

VENDOR: Sandvik

PRODUCT: [R216.23-04050CAK11P 1630](#)

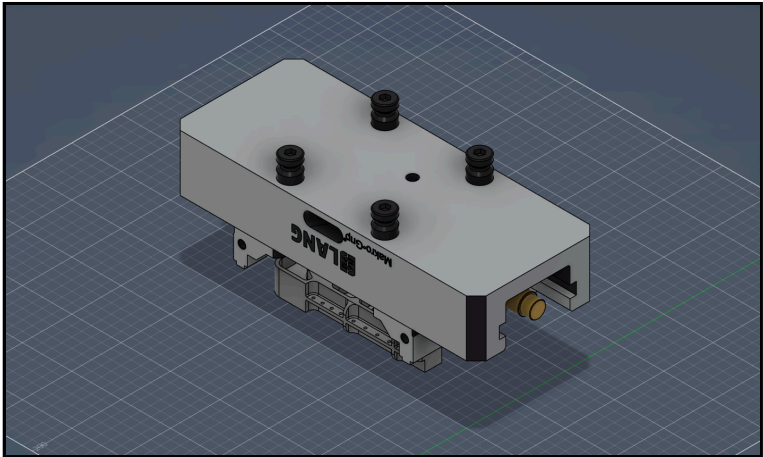
<p>Operation 7/21</p> <p>DESCRIPTION: Roughing4</p> <p>STRATEGY: Adaptive</p> <p>WCS: #0</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.25mm</p> <p>MAXIMUM STEPDOWN: 5mm</p> <p>OPTIMAL LOAD: 0.09mm</p> <p>LOAD DEVIATION: 0.01mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -15.75mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 304.409mm/min</p> <p>CUTTING DISTANCE: 2769.79mm</p> <p>RAPID DISTANCE: 706.46mm</p> <p>ESTIMATED CYCLE TIME: 9m:14s (29.1%)</p> <p>COOLANT: Flood</p>	<p>T17002 D17002 L17002</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 2.5mm</p> <p>LENGTH: 21mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: CoroMill Plura Tascapiccola</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1P250-0250-XA 1630</p>	
<p>Operation 8/21</p> <p>DESCRIPTION: Flat</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0.27mm/0mm</p> <p>MAXIMUM STEPOVER: 5.6mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 2370.136mm/min</p> <p>CUTTING DISTANCE: 292.12mm</p> <p>RAPID DISTANCE: 251.5mm</p> <p>ESTIMATED CYCLE TIME: 12s (0.6%)</p> <p>COOLANT: Flood</p>	<p>T20001 D20001 L20001</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>Operation 9/21</p> <p>DESCRIPTION: Flat1</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0.27mm/0mm</p> <p>MAXIMUM STEPOVER: 2.8mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 2584.402mm/min</p> <p>CUTTING DISTANCE: 332.8mm</p> <p>RAPID DISTANCE: 655.39mm</p> <p>ESTIMATED CYCLE TIME: 19s (1%)</p> <p>COOLANT: Flood</p>	<p>T19010 D19010 L19010</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 6mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 57mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 1K335-0600-100-XD 1730</p>	
<p>Operation 10/21</p> <p>DESCRIPTION: Flat2</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0.27mm/0mm</p> <p>MAXIMUM STEPOVER: 3.15mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1550.641mm/min</p> <p>CUTTING DISTANCE: 462.08mm</p> <p>RAPID DISTANCE: 407.79mm</p> <p>ESTIMATED CYCLE TIME: 24s (1.3%)</p> <p>COOLANT: Flood</p>	<p>T20002 D20002 L20002</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>Operation 11/21</p> <p>DESCRIPTION: Wall</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 8.73mm</p> <p>MAXIMUM STEPOVER: 4.28mm</p>	<p>MAXIMUM Z: 11.9mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 808.957mm/min</p> <p>CUTTING DISTANCE: 331.93mm</p> <p>RAPID DISTANCE: 62.19mm</p> <p>ESTIMATED CYCLE TIME: 28s (1.5%)</p> <p>COOLANT: Flood</p>	<p>T20002 D20002 L20002</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>Operation 12/21</p> <p>DESCRIPTION: Wall1</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 8.73mm</p> <p>MAXIMUM STEPOVER: 4.28mm</p>	<p>MAXIMUM Z: 11.9mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 808.957mm/min</p> <p>CUTTING DISTANCE: 266.66mm</p> <p>RAPID DISTANCE: 192.13mm</p> <p>ESTIMATED CYCLE TIME: 27s (1.4%)</p> <p>COOLANT: Flood</p>	<p>T20002 D20002 L20002</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>Operation 13/21</p> <p>DESCRIPTION: Wall2</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 26mm</p> <p>MAXIMUM STEPOVER: 11.4mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -30mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 3110.4mm/min</p> <p>CUTTING DISTANCE: 45.46mm</p> <p>RAPID DISTANCE: 55.55mm</p> <p>ESTIMATED CYCLE TIME: 6s (0.3%)</p> <p>COOLANT: Flood</p>	<p>T17009 D17009 L17009</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 12mm</p> <p>LENGTH: 60mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura Finituracontornatura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1K334-1200-XB 1730</p>	
<p>Operation 14/21</p> <p>DESCRIPTION: Wall3</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 26mm</p> <p>MAXIMUM STEPOVER: 11.4mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -30.2mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 3110.4mm/min</p> <p>CUTTING DISTANCE: 483.17mm</p> <p>RAPID DISTANCE: 57mm</p> <p>ESTIMATED CYCLE TIME: 14s (0.7%)</p> <p>COOLANT: Flood</p>	<p>T17009 D17009 L17009</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 12mm</p> <p>LENGTH: 60mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura Finituracontornatura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1K334-1200-XB 1730</p>	

<p>Operation 15/21</p> <p>DESCRIPTION: Wall4</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 17.5mm</p> <p>MAXIMUM STEPOVER: 7.6mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1620mm/min</p> <p>CUTTING DISTANCE: 276.42mm</p> <p>RAPID DISTANCE: 220.58mm</p> <p>ESTIMATED CYCLE TIME: 19s (1%)</p> <p>COOLANT: Flood</p>	<p>T20001 D20001 L20001</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>Operation 16/21</p> <p>DESCRIPTION: Wall5</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 4.87mm</p> <p>MAXIMUM STEPOVER: 3.8mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1525.299mm/min</p> <p>CUTTING DISTANCE: 165.57mm</p> <p>RAPID DISTANCE: 134.29mm</p> <p>ESTIMATED CYCLE TIME: 13s (0.7%)</p> <p>COOLANT: Flood</p>	<p>T19010 D19010 L19010</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 6mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 57mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 1K335-0600-100-XD 1730</p>	
<p>Operation 17/21</p> <p>DESCRIPTION: Wall6</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 4.87mm</p> <p>MAXIMUM STEPOVER: 3.8mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1525.299mm/min</p> <p>CUTTING DISTANCE: 309.62mm</p> <p>RAPID DISTANCE: 317.81mm</p> <p>ESTIMATED CYCLE TIME: 25s (1.3%)</p> <p>COOLANT: Flood</p>	<p>T19010 D19010 L19010</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 6mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 57mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 1K335-0600-100-XD 1730</p>	
<p>Operation 18/21</p> <p>DESCRIPTION: Holemaking</p> <p>STRATEGY: Bore</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -30.5mm</p> <p>MAXIMUM SPINDLE SPEED: 7639rpm</p> <p>MAXIMUM FEEDRATE: 3055.775mm/min</p> <p>CUTTING DISTANCE: 1257.85mm</p> <p>RAPID DISTANCE: 59.5mm</p> <p>ESTIMATED CYCLE TIME: 26s (1.4%)</p> <p>COOLANT: Flood</p>	<p>T17007 D17007 L17007</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 25mm</p> <p>LENGTH: 60mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: CoroMill 390 Finituraforogrande</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: R390-025A25-17L</p>	
<p>Operation 19/21</p> <p>DESCRIPTION: Holemaking1</p> <p>STRATEGY: Drilling</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -20.91mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 465.75mm/min</p> <p>CUTTING DISTANCE: 627.3mm</p> <p>RAPID DISTANCE: 1311.37mm</p> <p>ESTIMATED CYCLE TIME: 1m:37s (5.1%)</p> <p>COOLANT: Flood</p>	<p>T17006 D17006 L17006</p> <p>TYPE: drill</p> <p>DIAMETER: 2.5mm</p> <p>TIP ANGLE: 140°</p> <p>LENGTH: 38mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: CoroDrill 862 Foripiccoli</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 862.1-2500-225A0-GM X2BL</p>	
<p>Operation 20/21</p> <p>DESCRIPTION: Freeform</p> <p>STRATEGY: Contour</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 0.56mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -15.82mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1900mm/min</p> <p>CUTTING DISTANCE: 853.68mm</p> <p>RAPID DISTANCE: 557.9mm</p> <p>ESTIMATED CYCLE TIME: 45s (2.3%)</p> <p>COOLANT: Flood</p>	<p>T22014 D22014 L22014</p> <p>TYPE: ball end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 4mm</p> <p>LENGTH: 20mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: nervatura tonda</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: fresa a punta tonda VQ4SVBR04000</p>	
<p>Operation 21/21</p> <p>DESCRIPTION: Freeform1</p> <p>STRATEGY: Scallop</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPOVER: 0.28mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -7.08mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1900mm/min</p> <p>CUTTING DISTANCE: 422.21mm</p> <p>RAPID DISTANCE: 99.77mm</p> <p>ESTIMATED CYCLE TIME: 21s (1.1%)</p> <p>COOLANT: Flood</p>	<p>T22014 D22014 L22014</p> <p>TYPE: ball end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 4mm</p> <p>LENGTH: 20mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: nervatura tonda</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: fresa a punta tonda VQ4SVBR04000</p>	

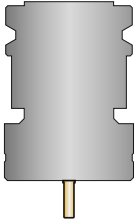
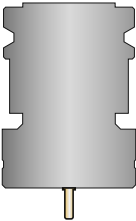
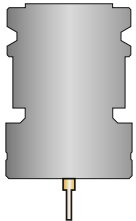
Setup Sheet for Program 1002

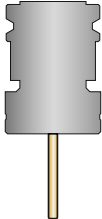
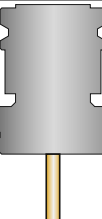
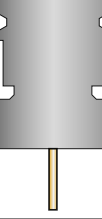

JOB DESCRIPTION: AutoSetup 2

DOCUMENT PATH: X_NC03-FORI_EDIT_1210070903 v3

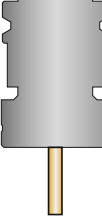


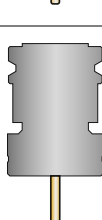
Setup	
<p>WCS: #0</p> <p>Stock:</p> <p>DX: 160mm</p> <p>DY: 95mm</p> <p>DZ: 35mm</p> <p>PART:</p> <p>DX: 150mm</p> <p>DY: 84.87mm</p> <p>DZ: 25mm</p> <p>Stock LOWER IN WCS #0:</p> <p>X: -80mm</p> <p>Y: -47.5mm</p> <p>Z: -35mm</p> <p>Stock UPPER IN WCS #0:</p> <p>X: 80mm</p> <p>Y: 47.5mm</p> <p>Z: 0mm</p>	

Total
<p>NUMBER OF OPERATIONS: 16</p> <p>NUMBER OF TOOLS: 7</p> <p>TOOLS: T13002 T13008 T17002 T19010 T20001 T20002 T22014</p> <p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM FEEDRATE: 2756.695mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>CUTTING DISTANCE: 25871.55mm</p> <p>RAPID DISTANCE: 12959.8mm</p> <p>ESTIMATED CYCLE TIME: 33m:6s</p>

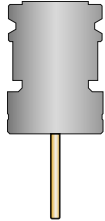
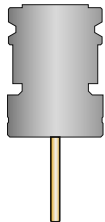
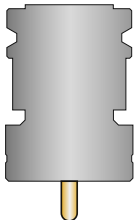
Tools			
<p>T13002 D13002 L13002</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 5mm</p> <p>CORNER RADIUS: 0.5mm</p> <p>LENGTH: 18.5mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Tasche</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1K335-0500-050-XC 1730</p>	<p>MINIMUM Z: -15.75mm</p> <p>MAXIMUM FEED: 2252.614mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>CUTTING DISTANCE: 4654.26mm</p> <p>RAPID DISTANCE: 1398.36mm</p> <p>ESTIMATED CYCLE TIME: 6m:39s (20.1%)</p>	<p>HOLDER: BT40 - B4C4-1000</p>	
<p>T13008 D13008 L13008</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 4mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 14.87mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Finitura fondo</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: R216.23-04050CAK11P 1630</p>	<p>MINIMUM Z: -15.75mm</p> <p>MAXIMUM FEED: 1834mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>CUTTING DISTANCE: 1238.23mm</p> <p>RAPID DISTANCE: 552.92mm</p> <p>ESTIMATED CYCLE TIME: 2m:36s (7.8%)</p>	<p>HOLDER: BT40 - B4C4-1000</p>	
<p>T17002 D17002 L17002</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 2.5mm</p> <p>LENGTH: 21mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: CoroMill Plura Tascapiccola</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1P250-0250-XA 1630</p>	<p>MINIMUM Z: -15.75mm</p> <p>MAXIMUM FEED: 304.409mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>CUTTING DISTANCE: 3155.13mm</p> <p>RAPID DISTANCE: 904.55mm</p> <p>ESTIMATED CYCLE TIME: 10m:33s (31.9%)</p>	<p>HOLDER: BT40 - B4C4-1000</p>	

T19010 D19010 L19010 TYPE: bullnose end mill DIAMETER: 6mm CORNER RADIUS: 1mm LENGTH: 57mm FLUTES: 5 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-0600-100-XD 1730	MINIMUM Z: -16mm MAXIMUM FEED: 2584.402mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 1079.78mm RAPID DISTANCE: 1577.58mm ESTIMATED CYCLE TIME: 1m:12s (3.6%)	HOLDER: BT40 - B4C4-1000	
T20001 D20001 L20001 TYPE: flat end mill DIAMETER: 8mm LENGTH: 40mm FLUTES: 4 DESCRIPTION: sgrossature tasche VENDOR: sandvik PRODUCT: 2P342-0800-PA 1730	MINIMUM Z: -16mm MAXIMUM FEED: 2756.695mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 13411.61mm RAPID DISTANCE: 7281.46mm ESTIMATED CYCLE TIME: 6m:58s (21%)	HOLDER: BT40 - B4C4-1000	
T20002 D20002 L20002 TYPE: flat end mill DIAMETER: 4.5mm LENGTH: 35mm FLUTES: 4 DESCRIPTION: SGROSSATURA TASCHE PICCOLE VENDOR: SANDVIK PRODUCT: 1P240-0450-XA 1630	MINIMUM Z: -16mm MAXIMUM FEED: 1550.641mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 1061.95mm RAPID DISTANCE: 588.42mm ESTIMATED CYCLE TIME: 1m:19s (4%)	HOLDER: BT40 - B4C4-1000	
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: -15.82mm MAXIMUM FEED: 1900mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 1270.6mm RAPID DISTANCE: 656.51mm ESTIMATED CYCLE TIME: 1m:5s (3.3%)	HOLDER: BT40 - B4C4-1000	

Operations

Operation 1/16 DESCRIPTION: Roughing STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 5.38mm OPTIMAL LOAD: 7.6mm LOAD DEVIATION: 0.2mm	MAXIMUM Z: 15mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2756.695mm/min CUTTING DISTANCE: 11499mm RAPID DISTANCE: 6647.99mm ESTIMATED CYCLE TIME: 5m:49s (17.6%) COOLANT: Flood	T20001 D20001 L20001 TYPE: flat end mill DIAMETER: 8mm LENGTH: 40mm FLUTES: 4 DESCRIPTION: sgrossature tasche VENDOR: sandvik PRODUCT: 2P342-0800-PA 1730	
Operation 2/16 DESCRIPTION: Roughing1 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 4mm OPTIMAL LOAD: 1.31mm LOAD DEVIATION: 0.13mm	MAXIMUM Z: 15mm MINIMUM Z: -15.75mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2252.614mm/min CUTTING DISTANCE: 4654.26mm RAPID DISTANCE: 1398.36mm ESTIMATED CYCLE TIME: 6m:39s (20.1%) COOLANT: Flood	T13002 D13002 L13002 TYPE: bullnose end mill DIAMETER: 5mm CORNER RADIUS: 0.5mm LENGTH: 18.5mm FLUTES: 5 DESCRIPTION: Tasche VENDOR: Sandvik PRODUCT: 1K335-0500-050-XC 1730	
Operation 3/16 DESCRIPTION: Roughing2 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 3.3mm OPTIMAL LOAD: 0.9mm LOAD DEVIATION: 0.09mm	MAXIMUM Z: 15mm MINIMUM Z: -15.75mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1834mm/min CUTTING DISTANCE: 1238.23mm RAPID DISTANCE: 552.92mm ESTIMATED CYCLE TIME: 2m:36s (7.8%) COOLANT: Flood	T13008 D13008 L13008 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 1mm LENGTH: 14.87mm FLUTES: 5 DESCRIPTION: Finitura fondo VENDOR: Sandvik PRODUCT: R216.23-04050CAK11P 1630	
Operation 4/16 DESCRIPTION: Roughing3 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.67mm OPTIMAL LOAD: 5mm LOAD DEVIATION: 0.5mm	MAXIMUM Z: 15mm MINIMUM Z: -8.75mm MAXIMUM SPINDLE SPEED: 7945rpm MAXIMUM FEEDRATE: 1679.133mm/min CUTTING DISTANCE: 259.85mm RAPID DISTANCE: 587.37mm ESTIMATED CYCLE TIME: 16s (0.8%) COOLANT: Flood	T19010 D19010 L19010 TYPE: bullnose end mill DIAMETER: 6mm CORNER RADIUS: 1mm LENGTH: 57mm FLUTES: 5 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-0600-100-XD 1730	

<p>Operation 5/16</p> <p>DESCRIPTION: Roughing4</p> <p>STRATEGY: Adaptive</p> <p>WCS: #0</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.25mm</p> <p>MAXIMUM STEPDOWN: 5mm</p> <p>OPTIMAL LOAD: 0.09mm</p> <p>LOAD DEVIATION: 0.01mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -15.75mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 304.409mm/min</p> <p>CUTTING DISTANCE: 3155.13mm</p> <p>RAPID DISTANCE: 904.55mm</p> <p>ESTIMATED CYCLE TIME: 10m:33s (31.9%)</p> <p>COOLANT: Flood</p>	<p>T17002 D17002 L17002</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 2.5mm</p> <p>LENGTH: 21mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: CoroMill Plura Tascapiccola</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1P250-0250-XA 1630</p>	
<p>Operation 6/16</p> <p>DESCRIPTION: Flat</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0.27mm/0mm</p> <p>MAXIMUM STEPOVER: 5.6mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 2370.136mm/min</p> <p>CUTTING DISTANCE: 1636.19mm</p> <p>RAPID DISTANCE: 389.74mm</p> <p>ESTIMATED CYCLE TIME: 49s (2.5%)</p> <p>COOLANT: Flood</p>	<p>T20001 D20001 L20001</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>Operation 7/16</p> <p>DESCRIPTION: Flat1</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0.27mm/0mm</p> <p>MAXIMUM STEPOVER: 2.8mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 2584.402mm/min</p> <p>CUTTING DISTANCE: 344.74mm</p> <p>RAPID DISTANCE: 586.91mm</p> <p>ESTIMATED CYCLE TIME: 18s (0.9%)</p> <p>COOLANT: Flood</p>	<p>T19010 D19010 L19010</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 6mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 57mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 1K335-0600-100-XD 1730</p>	
<p>Operation 8/16</p> <p>DESCRIPTION: Flat2</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0.27mm/0mm</p> <p>MAXIMUM STEPOVER: 3.15mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1550.641mm/min</p> <p>CUTTING DISTANCE: 463.35mm</p> <p>RAPID DISTANCE: 349.39mm</p> <p>ESTIMATED CYCLE TIME: 23s (1.2%)</p> <p>COOLANT: Flood</p>	<p>T20002 D20002 L20002</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>Operation 9/16</p> <p>DESCRIPTION: Wall</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 8.73mm</p> <p>MAXIMUM STEPOVER: 4.28mm</p>	<p>MAXIMUM Z: 11.9mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 808.957mm/min</p> <p>CUTTING DISTANCE: 331.93mm</p> <p>RAPID DISTANCE: 62.19mm</p> <p>ESTIMATED CYCLE TIME: 28s (1.4%)</p> <p>COOLANT: Flood</p>	<p>T20002 D20002 L20002</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>Operation 10/16</p> <p>DESCRIPTION: Wall1</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 8.73mm</p> <p>MAXIMUM STEPOVER: 4.28mm</p>	<p>MAXIMUM Z: 11.9mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 808.957mm/min</p> <p>CUTTING DISTANCE: 266.66mm</p> <p>RAPID DISTANCE: 176.84mm</p> <p>ESTIMATED CYCLE TIME: 27s (1.4%)</p> <p>COOLANT: Flood</p>	<p>T20002 D20002 L20002</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>Operation 11/16</p> <p>DESCRIPTION: Wall2</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 17.5mm</p> <p>MAXIMUM STEPOVER: 7.6mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1620mm/min</p> <p>CUTTING DISTANCE: 276.42mm</p> <p>RAPID DISTANCE: 243.73mm</p> <p>ESTIMATED CYCLE TIME: 20s (1%)</p> <p>COOLANT: Flood</p>	<p>T20001 D20001 L20001</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>Operation 12/16</p> <p>DESCRIPTION: Wall3</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 4.87mm</p> <p>MAXIMUM STEPOVER: 3.8mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1525.299mm/min</p> <p>CUTTING DISTANCE: 165.57mm</p> <p>RAPID DISTANCE: 134.29mm</p> <p>ESTIMATED CYCLE TIME: 13s (0.6%)</p> <p>COOLANT: Flood</p>	<p>T19010 D19010 L19010</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 6mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 57mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 1K335-0600-100-XD 1730</p>	

Operation 13/16 DESCRIPTION: Wall4 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 4.87mm MAXIMUM STEPOVER: 3.8mm	MAXIMUM Z: 12mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1525.299mm/min CUTTING DISTANCE: 191.1mm RAPID DISTANCE: 151.32mm ESTIMATED CYCLE TIME: 14s (0.7%) COOLANT: Flood	T19010 D19010 L19010 TYPE: bullnose end mill DIAMETER: 6mm CORNER RADIUS: 1mm LENGTH: 57mm FLUTES: 5 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-0600-100-XD 1730	
Operation 14/16 DESCRIPTION: Wall5 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 4.87mm MAXIMUM STEPOVER: 3.8mm	MAXIMUM Z: 12mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1525.299mm/min CUTTING DISTANCE: 118.52mm RAPID DISTANCE: 117.7mm ESTIMATED CYCLE TIME: 11s (0.5%) COOLANT: Flood	T19010 D19010 L19010 TYPE: bullnose end mill DIAMETER: 6mm CORNER RADIUS: 1mm LENGTH: 57mm FLUTES: 5 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-0600-100-XD 1730	
Operation 15/16 DESCRIPTION: Freeform STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.56mm	MAXIMUM Z: 15mm MINIMUM Z: -15.82mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1900mm/min CUTTING DISTANCE: 853.56mm RAPID DISTANCE: 557.83mm ESTIMATED CYCLE TIME: 45s (2.2%) 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	
Operation 16/16 DESCRIPTION: Freeform1 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.28mm	MAXIMUM Z: 15mm MINIMUM Z: -7.08mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1900mm/min CUTTING DISTANCE: 417.03mm RAPID DISTANCE: 98.69mm ESTIMATED CYCLE TIME: 21s (1%) 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	