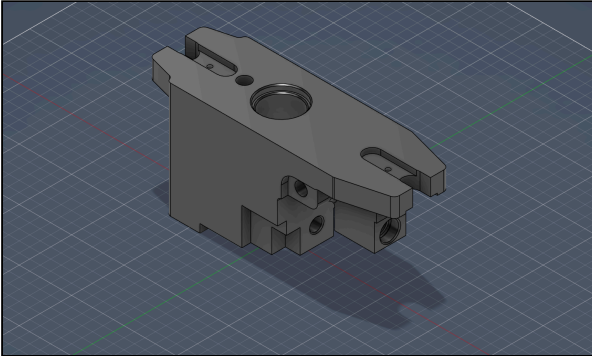


# Setup Sheet for Program 1001

JOB DESCRIPTION: Setup1



DOCUMENT PATH: progetto 2023 v1

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

Total
<p>NUMBER OF OPERATIONS: 19</p> <p>NUMBER OF TOOLS: 14</p> <p>TOOLS: T1 T2 T3 T4 T5 T6 T20 T21 T22 T23 T24 T25 T32 T33</p> <p>MAXIMUM FEEDRATE: 3160mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8035rpm</p> <p>CUTTING DISTANCE: 7260.95mm</p> <p>RAPID DISTANCE: 2008mm</p> <p>ESTIMATED CYCLE TIME: 7m:48s</p>

Tools		
<p><b>T1 D1 L1</b></p> <p>TYPE: face mill</p> <p>DIAMETER: 40mm</p> <p>LENGTH: 48mm</p> <p>FLUTES: 6</p> <p>DESCRIPTION: CoroMill 490 square</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: <a href="#">490-040C4-08H</a></p>	<p>MAXIMUM FEED: 3160mm/min</p> <p>MAXIMUM SPINDLE SPEED: 2485rpm</p> <p>CUTTING DISTANCE: 4094.01mm</p> <p>RAPID DISTANCE: 130mm</p> <p>ESTIMATED CYCLE TIME: 1m:31s (19.5%)</p>	
<p><b>T2 D2 L2</b></p> <p>TYPE: flat end mill</p> <p>DIAMETER: 9.53mm</p> <p>LENGTH: 31.75mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill plura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 2F342-0953-PD P2BM</p>	<p>MAXIMUM FEED: 2356mm/min</p> <p>MAXIMUM SPINDLE SPEED: 7990rpm</p> <p>CUTTING DISTANCE: 271.63mm</p> <p>RAPID DISTANCE: 313.54mm</p> <p>ESTIMATED CYCLE TIME: 12s (2.5%)</p>	
<p><b>T3 D3 L3</b></p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 16mm</p> <p>CORNER RADIUS: 0.5mm</p> <p>LENGTH: 42mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Plura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: <a href="#">2F342-1600-050-PD P2BM</a></p>	<p>MAXIMUM FEED: 1840mm/min</p> <p>MAXIMUM SPINDLE SPEED: 4300rpm</p> <p>CUTTING DISTANCE: 2158.91mm</p> <p>RAPID DISTANCE: 96.6mm</p> <p>ESTIMATED CYCLE TIME: 1m:16s (16.3%)</p>	
<p><b>T4 D4 L4</b></p> <p>TYPE: chamfer mill</p> <p>DIAMETER: 6mm</p> <p>TAPER ANGLE: 45°</p> <p>LENGTH: 25mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: <a href="#">1C050-0100-045-XA 1620</a></p>	<p>MAXIMUM FEED: 1500mm/min</p> <p>MAXIMUM SPINDLE SPEED: 7960rpm</p> <p>CUTTING DISTANCE: 132.89mm</p> <p>RAPID DISTANCE: 35.4mm</p> <p>ESTIMATED CYCLE TIME: 6s (1.3%)</p>	
<p><b>T5 D5 L5</b></p> <p>TYPE: face mill</p> <p>DIAMETER: 4.6mm</p> <p>TAPER ANGLE: 45°</p> <p>LENGTH: 15mm</p> <p>FLUTES: 3</p> <p>DESCRIPTION: CoroMill 326</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: <a href="#">A326R06-M1502006-CH 1025</a></p>	<p>MAXIMUM FEED: 1000mm/min</p> <p>MAXIMUM SPINDLE SPEED: 7000rpm</p> <p>CUTTING DISTANCE: 212.35mm</p> <p>RAPID DISTANCE: 71.63mm</p> <p>ESTIMATED CYCLE TIME: 15s (3.2%)</p>	
<p><b>T6 D6 L6</b></p> <p>TYPE: flat end mill</p> <p>DIAMETER: 6mm</p> <p>LENGTH: 28.8mm</p> <p>FLUTES: 7</p> <p>DESCRIPTION: CoroMill dura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: <a href="#">1K377-0600-050-XD 1730</a></p>	<p>MAXIMUM FEED: 1500mm/min</p> <p>MAXIMUM SPINDLE SPEED: 7960rpm</p> <p>CUTTING DISTANCE: 165.53mm</p> <p>RAPID DISTANCE: 270.39mm</p> <p>ESTIMATED CYCLE TIME: 19s (4.1%)</p>	

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

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

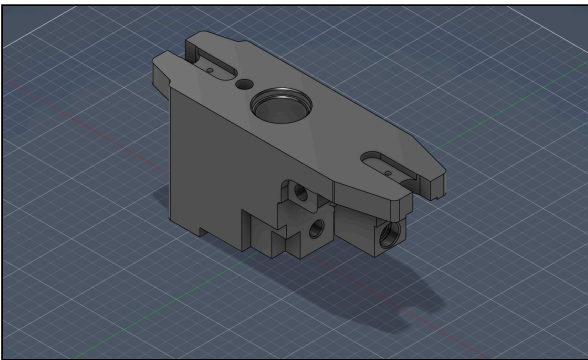
Operation 3/19 DESCRIPTION: Sgrossatura 3 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 28mm	MAXIMUM SPINDLE SPEED: 2485rpm MAXIMUM FEEDRATE: 3160mm/min CUTTING DISTANCE: 947.72mm RAPID DISTANCE: 26mm ESTIMATED CYCLE TIME: 19s (4%) COOLANT: Flood	<b>T1 D1 L1</b> TYPE: face mill DIAMETER: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

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

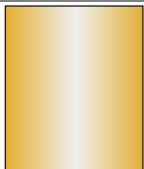


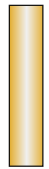
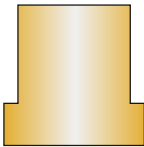
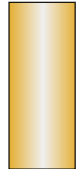
# Setup Sheet for Program 1002

JOB DESCRIPTION: Setup2










DOCUMENT PATH: progetto 2023 v1


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

Total
<p>NUMBER OF OPERATIONS: 54</p> <p>NUMBER OF TOOLS: 25</p> <p>TOOLS: T1 T2 T4 T6 T7 T8 T9 T10 T11 T12 T13 T14 T15 T16 T17 T18 T21 T24 T26 T27 T28 T29 T30 T31 T33</p> <p>MAXIMUM FEEDRATE: 15000mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8053rpm</p> <p>CUTTING DISTANCE: 22037.37mm</p> <p>RAPID DISTANCE: 17529.53mm</p> <p>ESTIMATED CYCLE TIME: 35m:9s</p>

Tools		
<p><b>T1 D1 L1</b></p> <p>TYPE: face mill</p> <p>DIAMETER: 40mm</p> <p>LENGTH: 48mm</p> <p>FLUTES: 6</p> <p>DESCRIPTION: CoroMill 490 square</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: <a href="#">490-040C4-08H</a></p>	<p>MAXIMUM FEED: 3110mm/min</p> <p>MAXIMUM SPINDLE SPEED: 2500rpm</p> <p>CUTTING DISTANCE: 2511.83mm</p> <p>RAPID DISTANCE: 78mm</p> <p>ESTIMATED CYCLE TIME: 50s (2.4%)</p>	
<p><b>T2 D2 L2</b></p> <p>TYPE: flat end mill</p> <p>DIAMETER: 9.53mm</p> <p>LENGTH: 31.75mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill plura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 2F342-0953-PD P2BM</p>	<p>MAXIMUM FEED: 2350mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8053rpm</p> <p>CUTTING DISTANCE: 2393.42mm</p> <p>RAPID DISTANCE: 445.19mm</p> <p>ESTIMATED CYCLE TIME: 1m:45s (5%)</p>	
<p><b>T4 D4 L4</b></p> <p>TYPE: chamfer mill</p> <p>DIAMETER: 6mm</p> <p>TAPER ANGLE: 45°</p> <p>LENGTH: 25mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: <a href="#">1C050-0100-045-XA 1620</a></p>	<p>MAXIMUM FEED: 15000mm/min</p> <p>MAXIMUM SPINDLE SPEED: 7960rpm</p> <p>CUTTING DISTANCE: 1056.84mm</p> <p>RAPID DISTANCE: 678.9mm</p> <p>ESTIMATED CYCLE TIME: 1m:14s (3.5%)</p>	
<p><b>T6 D6 L6</b></p> <p>TYPE: flat end mill</p> <p>DIAMETER: 6mm</p> <p>LENGTH: 28.8mm</p> <p>FLUTES: 7</p> <p>DESCRIPTION: CoroMill dura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: <a href="#">1K377-0600-050-XD 1730</a></p>	<p>MAXIMUM FEED: 1500mm/min</p> <p>MAXIMUM SPINDLE SPEED: 7960rpm</p> <p>CUTTING DISTANCE: 188.49mm</p> <p>RAPID DISTANCE: 103.75mm</p> <p>ESTIMATED CYCLE TIME: 14s (0.7%)</p>	
<p><b>T7 D7 L7</b></p> <p>TYPE: face mill</p> <p>DIAMETER: 40mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 6</p> <p>DESCRIPTION: CoroMill 490</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: <a href="#">490-040A32-14M</a></p>	<p>MAXIMUM FEED: 1660mm/min</p> <p>MAXIMUM SPINDLE SPEED: 2070rpm</p> <p>CUTTING DISTANCE: 3221.61mm</p> <p>RAPID DISTANCE: 3224.97mm</p> <p>ESTIMATED CYCLE TIME: 3m:9s (9%)</p>	
<p><b>T8 D8 L8</b></p> <p>TYPE: flat end mill</p> <p>DIAMETER: 25mm</p> <p>LENGTH: 63mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Plura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: <a href="#">2N342-2500-PD P2BM</a></p>	<p>MAXIMUM FEED: 1290mm/min</p> <p>MAXIMUM SPINDLE SPEED: 2600rpm</p> <p>CUTTING DISTANCE: 4945.95mm</p> <p>RAPID DISTANCE: 4827.77mm</p> <p>ESTIMATED CYCLE TIME: 5m:58s (17%)</p>	

<b>T9 D9 L9</b> TYPE: bullnose end mill DIAMETER: 12mm CORNER RADIUS: 0.5mm LENGTH: 36mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: <a href="#">2F342-1200-050-PD P2BM</a>	MAXIMUM FEED: 3216mm/min MAXIMUM SPINDLE SPEED: 6850rpm CUTTING DISTANCE: 1832.13mm RAPID DISTANCE: 614.62mm ESTIMATED CYCLE TIME: 1m:10s (3.3%)	
<b>T10 D10 L10</b> TYPE: ball end mill DIAMETER: 6mm CORNER RADIUS: 3mm LENGTH: 30mm FLUTES: 2 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: <a href="#">R216.62-06030-AO07G 1610</a>	MAXIMUM FEED: 1500mm/min MAXIMUM SPINDLE SPEED: 7960rpm CUTTING DISTANCE: 783.42mm RAPID DISTANCE: 744.32mm ESTIMATED CYCLE TIME: 2m:5s (5.9%)	
<b>T11 D11 L11</b> TYPE: flat end mill DIAMETER: 12mm LENGTH: 36mm FLUTES: 4 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: 2F342-1200-050-PD P2BM	MAXIMUM FEED: 1780mm/min MAXIMUM SPINDLE SPEED: 6850rpm CUTTING DISTANCE: 70mm RAPID DISTANCE: 219.8mm ESTIMATED CYCLE TIME: 5s (0.3%)	
<b>T12 D12 L12</b> TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 60mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: <a href="#">1K334-2000-300-XD 1730</a>	MAXIMUM FEED: 963mm/min MAXIMUM SPINDLE SPEED: 3060rpm CUTTING DISTANCE: 355.1mm RAPID DISTANCE: 119mm ESTIMATED CYCLE TIME: 46s (2.2%)	
<b>T13 D13 L13</b> TYPE: bullnose end mill DIAMETER: 12mm CORNER RADIUS: 1mm LENGTH: 53mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: <a href="#">R216.24-12050CCK26P 1620</a>	MAXIMUM FEED: 730mm/min MAXIMUM SPINDLE SPEED: 3980rpm CUTTING DISTANCE: 3045.27mm RAPID DISTANCE: 3120.68mm ESTIMATED CYCLE TIME: 7m:14s (20.6%)	
<b>T14 D14 L14</b> TYPE: flat end mill DIAMETER: 20mm LENGTH: 90mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>	MAXIMUM FEED: 5700mm/min MAXIMUM SPINDLE SPEED: 3870rpm CUTTING DISTANCE: 425.61mm RAPID DISTANCE: 504.48mm ESTIMATED CYCLE TIME: 16s (0.8%)	
<b>T15 D15 L15</b> TYPE: bullnose end mill DIAMETER: 3mm CORNER RADIUS: 0.2mm LENGTH: 17.4mm FLUTES: 5 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: <a href="#">1K365-0300-020-XC 1730</a>	MAXIMUM FEED: 796mm/min MAXIMUM SPINDLE SPEED: 7960rpm CUTTING DISTANCE: 308.74mm RAPID DISTANCE: 251.92mm ESTIMATED CYCLE TIME: 41s (2%)	
<b>T16 D16 L16</b> TYPE: slot mill DIAMETER: 21.7mm LENGTH: 22.3mm FLUTES: 3 DESCRIPTION: CoroMill 327 VENDOR: Sandvik PRODUCT: 327-16B24SC-12 ; 327R12-22 16000-GM 1025	MAXIMUM FEED: 1500mm/min MAXIMUM SPINDLE SPEED: 2200rpm CUTTING DISTANCE: 205.17mm RAPID DISTANCE: 114.6mm ESTIMATED CYCLE TIME: 10s (0.5%)	
<b>T17 D17 L17</b> TYPE: slot mill DIAMETER: 9.7mm LENGTH: 23.23mm FLUTES: 3 DESCRIPTION: CoroMill 327 VENDOR: Sandvik PRODUCT: 327-12B21EC-06 ; 327R06-10 10000-GM 1025	MAXIMUM FEED: 2000mm/min MAXIMUM SPINDLE SPEED: 6565rpm CUTTING DISTANCE: 91.85mm RAPID DISTANCE: 209mm ESTIMATED CYCLE TIME: 6s (0.3%)	
<b>T18 D18 L18</b> TYPE: dovetail mill DIAMETER: 11.7mm TAPER ANGLE: 45° LENGTH: 23.23mm FLUTES: 3 DESCRIPTION: T0404 VENDOR: Sandvik PRODUCT: 327R06-12 12045-CH 1025 ; 327-12B21EC-06	MAXIMUM FEED: 1000mm/min MAXIMUM SPINDLE SPEED: 5440rpm CUTTING DISTANCE: 77.55mm RAPID DISTANCE: 223.55mm ESTIMATED CYCLE TIME: 8s (0.4%)	

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

Operations		
Operation 1/54 DESCRIPTION: Sgrossatura 6 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 28mm	MAXIMUM SPINDLE SPEED: 2500rpm MAXIMUM FEEDRATE: 3110mm/min CUTTING DISTANCE: 1257.29mm RAPID DISTANCE: 26mm ESTIMATED CYCLE TIME: 25s (1.2%) COOLANT: Flood	<b>T1 D1 L1</b> TYPE: face mill DIAMETER: 40mm LENGTH: 48mm FLUTES: 6 DESCRIPTION: CoroMill 490 square VENDOR: Sandvik PRODUCT: <a href="#">490-040C4-08H</a>
		

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




Operation 13/54 DESCRIPTION: Spallamento 6 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 7.2mm	MAXIMUM SPINDLE SPEED: 5385rpm MAXIMUM FEEDRATE: 1680mm/min CUTTING DISTANCE: 253.75mm RAPID DISTANCE: 37.3mm ESTIMATED CYCLE TIME: 11s (0.5%) COOLANT: Flood	<b>T9 D9 L9</b> TYPE: bullnose end mill DIAMETER: 12mm CORNER RADIUS: 0.5mm LENGTH: 36mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: <a href="#">2F342-1200-050-PD P2BM</a>	
Operation 14/54 DESCRIPTION: Spallamento 7 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 7.2mm	MAXIMUM SPINDLE SPEED: 5385rpm MAXIMUM FEEDRATE: 1680mm/min CUTTING DISTANCE: 256.13mm RAPID DISTANCE: 37.3mm ESTIMATED CYCLE TIME: 11s (0.5%) COOLANT: Flood	<b>T9 D9 L9</b> TYPE: bullnose end mill DIAMETER: 12mm CORNER RADIUS: 0.5mm LENGTH: 36mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: <a href="#">2F342-1200-050-PD P2BM</a>	
Operation 15/54 DESCRIPTION: Spallamento 8 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 7.2mm	MAXIMUM SPINDLE SPEED: 6850rpm MAXIMUM FEEDRATE: 3216mm/min CUTTING DISTANCE: 135.46mm RAPID DISTANCE: 50.3mm ESTIMATED CYCLE TIME: 4s (0.2%) COOLANT: Flood	<b>T9 D9 L9</b> TYPE: bullnose end mill DIAMETER: 12mm CORNER RADIUS: 0.5mm LENGTH: 36mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: <a href="#">2F342-1200-050-PD P2BM</a>	
Operation 16/54 DESCRIPTION: Spallamento 9 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 7.2mm	MAXIMUM SPINDLE SPEED: 6850rpm MAXIMUM FEEDRATE: 3216mm/min CUTTING DISTANCE: 125.1mm RAPID DISTANCE: 50.3mm ESTIMATED CYCLE TIME: 4s (0.2%) COOLANT: Flood	<b>T9 D9 L9</b> TYPE: bullnose end mill DIAMETER: 12mm CORNER RADIUS: 0.5mm LENGTH: 36mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: <a href="#">2F342-1200-050-PD P2BM</a>	
Operation 17/54 DESCRIPTION: Spallamento 10 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.71mm	MAXIMUM SPINDLE SPEED: 6500rpm MAXIMUM FEEDRATE: 1700mm/min CUTTING DISTANCE: 596.28mm RAPID DISTANCE: 36.5mm ESTIMATED CYCLE TIME: 22s (1%) COOLANT: Flood	<b>T2 D2 L2</b> TYPE: flat end mill DIAMETER: 9.53mm LENGTH: 31.75mm FLUTES: 4 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: <a href="#">2F342-0953-PD P2BM</a>	
Operation 18/54 DESCRIPTION: Spallamento 11 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.71mm	MAXIMUM SPINDLE SPEED: 6500rpm MAXIMUM FEEDRATE: 1700mm/min CUTTING DISTANCE: 596.33mm RAPID DISTANCE: 36.5mm ESTIMATED CYCLE TIME: 22s (1%) COOLANT: Flood	<b>T2 D2 L2</b> TYPE: flat end mill DIAMETER: 9.53mm LENGTH: 31.75mm FLUTES: 4 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: <a href="#">2F342-0953-PD P2BM</a>	
Operation 19/54 DESCRIPTION: Finitura retro STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 7mm MAXIMUM STEPOVER: 1.2mm	MAXIMUM SPINDLE SPEED: 7430rpm MAXIMUM FEEDRATE: 1200mm/min CUTTING DISTANCE: 366.56mm RAPID DISTANCE: 357.42mm ESTIMATED CYCLE TIME: 32s (1.5%) COOLANT: Flood	<b>T10 D10 L10</b> TYPE: ball end mill DIAMETER: 6mm CORNER RADIUS: 3mm LENGTH: 30mm FLUTES: 2 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: <a href="#">R216.62-06030-AQ07G 1610</a>	
Operation 20/54 DESCRIPTION: Tasca 2 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 7.2mm	MAXIMUM SPINDLE SPEED: 6850rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 70mm RAPID DISTANCE: 219.8mm ESTIMATED CYCLE TIME: 5s (0.3%) COOLANT: Flood	<b>T11 D11 L11</b> TYPE: flat end mill DIAMETER: 12mm LENGTH: 36mm FLUTES: 4 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: <a href="#">2F342-1200-050-PD P2BM</a>	
Operation 21/54 DESCRIPTION: Spallamento 12 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 12mm	MAXIMUM SPINDLE SPEED: 3060rpm MAXIMUM FEEDRATE: 963mm/min CUTTING DISTANCE: 355.1mm RAPID DISTANCE: 119mm ESTIMATED CYCLE TIME: 46s (2.2%) COOLANT: Flood	<b>T12 D12 L12</b> TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 60mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: <a href="#">1K334-2000-300-XD 1730</a>	
Operation 22/54 DESCRIPTION: Spallamento 13 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 13mm MAXIMUM STEPOVER: 7.2mm	MAXIMUM SPINDLE SPEED: 3980rpm MAXIMUM FEEDRATE: 500mm/min CUTTING DISTANCE: 2133.41mm RAPID DISTANCE: 1922.98mm ESTIMATED CYCLE TIME: 5m:36s (15.9%) COOLANT: Flood	<b>T13 D13 L13</b> TYPE: bullnose end mill DIAMETER: 12mm CORNER RADIUS: 1mm LENGTH: 53mm FLUTES: 4 DESCRIPTION: CoroMill Plura VENDOR: Sandvik PRODUCT: <a href="#">R216.24-12050CCK26P 1620</a>	

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

Operation 33/54 DESCRIPTION: Spallamento 16 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 9.05mm	MAXIMUM SPINDLE SPEED: 6720rpm MAXIMUM FEEDRATE: 2350mm/min CUTTING DISTANCE: 130.43mm RAPID DISTANCE: 48.55mm ESTIMATED CYCLE TIME: 5s (0.3%) COOLANT: Flood	<b>T2 D2 L2</b> TYPE: flat end mill DIAMETER: 9.53mm LENGTH: 31.75mm FLUTES: 4 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: 2F342-0953-PD P2BM	
Operation 34/54 DESCRIPTION: Finitura frontale STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 7mm MAXIMUM STEPOVER: 1.2mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 318mm/min CUTTING DISTANCE: 234mm RAPID DISTANCE: 258mm ESTIMATED CYCLE TIME: 1m:21s (3.9%) COOLANT: Flood	<b>T10 D10 L10</b> TYPE: ball end mill DIAMETER: 6mm CORNER RADIUS: 3mm LENGTH: 30mm FLUTES: 2 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: <a href="#">R216.62-06030-AQ07G 1610</a>	
Operation 35/54 DESCRIPTION: Tasca 4 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.71mm	MAXIMUM SPINDLE SPEED: 6850rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 223.06mm RAPID DISTANCE: 123.05mm ESTIMATED CYCLE TIME: 16s (0.8%) COOLANT: Flood	<b>T2 D2 L2</b> TYPE: flat end mill DIAMETER: 9.53mm LENGTH: 31.75mm FLUTES: 4 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: 2F342-0953-PD P2BM	
Operation 36/54 DESCRIPTION: Finitura 5 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.71mm	MAXIMUM SPINDLE SPEED: 8053rpm MAXIMUM FEEDRATE: 2340mm/min CUTTING DISTANCE: 420.9mm RAPID DISTANCE: 59.05mm ESTIMATED CYCLE TIME: 14s (0.6%) COOLANT: Flood	<b>T2 D2 L2</b> TYPE: flat end mill DIAMETER: 9.53mm LENGTH: 31.75mm FLUTES: 4 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: 2F342-0953-PD P2BM	
Operation 37/54 DESCRIPTION: Spallamento 17 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 44.5mm MAXIMUM STEPOVER: 19mm	MAXIMUM SPINDLE SPEED: 3870rpm MAXIMUM FEEDRATE: 5700mm/min CUTTING DISTANCE: 425.61mm RAPID DISTANCE: 504.48mm ESTIMATED CYCLE TIME: 16s (0.8%) COOLANT: Flood	<b>T14 D14 L14</b> TYPE: flat end mill DIAMETER: 20mm LENGTH: 90mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>	
Operation 38/54 DESCRIPTION: Finitura 6 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 2.47mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 796mm/min CUTTING DISTANCE: 154.37mm RAPID DISTANCE: 127.54mm ESTIMATED CYCLE TIME: 21s (1%) COOLANT: Flood	<b>T15 D15 L15</b> TYPE: bullnose end mill DIAMETER: 3mm CORNER RADIUS: 0.2mm LENGTH: 17.4mm FLUTES: 5 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: <a href="#">1K365-0300-020-XC 1730</a>	
Operation 39/54 DESCRIPTION: Finitura 7 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 2.47mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 796mm/min CUTTING DISTANCE: 154.37mm RAPID DISTANCE: 124.39mm ESTIMATED CYCLE TIME: 21s (1%) COOLANT: Flood	<b>T15 D15 L15</b> TYPE: bullnose end mill DIAMETER: 3mm CORNER RADIUS: 0.2mm LENGTH: 17.4mm FLUTES: 5 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: <a href="#">1K365-0300-020-XC 1730</a>	
Operation 40/54 DESCRIPTION: Filettatura3 STRATEGY: Thread WCS: #1 STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 5000rpm MAXIMUM FEEDRATE: 1000mm/min CUTTING DISTANCE: 115.76mm RAPID DISTANCE: 469.07mm ESTIMATED CYCLE TIME: 13s (0.6%) COOLANT: Flood	<b>T33 D33 L33</b> TYPE: thread mill DIAMETER: 5mm LENGTH: 80mm FLUTES: 2 DESCRIPTION: CoroTap 300 VENDOR: Sandvik PRODUCT: <a href="#">T300-PM104DA-M6 P1PM</a>	
Operation 41/54 DESCRIPTION: Alesatura 1 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 1.6mm MAXIMUM STEPOVER: 20.62mm	MAXIMUM SPINDLE SPEED: 2200rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 205.17mm RAPID DISTANCE: 114.6mm ESTIMATED CYCLE TIME: 10s (0.5%) COOLANT: Flood	<b>T16 D16 L16</b> TYPE: slot mill DIAMETER: 21.7mm LENGTH: 22.3mm FLUTES: 3 DESCRIPTION: CoroMill 327 VENDOR: Sandvik PRODUCT: 327-16B24SC-12 ; 327R12-22 16000-GM 1025	
Operation 42/54 DESCRIPTION: Contornatura 2D23 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 197.51mm RAPID DISTANCE: 73.4mm ESTIMATED CYCLE TIME: 13s (0.6%) COOLANT: Flood	<b>T4 D4 L4</b> TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 25mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: <a href="#">1C050-0100-045-XA 1620</a>	
Operation 43/54 DESCRIPTION: Smussatura 3 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 15000mm/min CUTTING DISTANCE: 161.6mm RAPID DISTANCE: 38.4mm ESTIMATED CYCLE TIME: 1s (0.1%) COOLANT: Flood	<b>T4 D4 L4</b> TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 25mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: <a href="#">1C050-0100-045-XA 1620</a>	

Operation 44/54 DESCRIPTION: Smussatura 4 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 140.18mm RAPID DISTANCE: 48.4mm ESTIMATED CYCLE TIME: 8s (0.4%) COOLANT: Flood	<b>T4 D4 L4</b> TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 25mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: <a href="#">1C050-0100-045-XA 1620</a>	
Operation 45/54 DESCRIPTION: Smussatura 5 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 149.93mm RAPID DISTANCE: 130.4mm ESTIMATED CYCLE TIME: 16s (0.8%) COOLANT: Flood	<b>T4 D4 L4</b> TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 25mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: <a href="#">1C050-0100-045-XA 1620</a>	
Operation 46/54 DESCRIPTION: Smussatura 6 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 105.06mm RAPID DISTANCE: 60.4mm ESTIMATED CYCLE TIME: 8s (0.4%) COOLANT: Flood	<b>T4 D4 L4</b> TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 25mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: <a href="#">1C050-0100-045-XA 1620</a>	
Operation 47/54 DESCRIPTION: Smussatura 7 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 98.78mm RAPID DISTANCE: 60.4mm ESTIMATED CYCLE TIME: 8s (0.4%) COOLANT: Flood	<b>T4 D4 L4</b> TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 25mm FLUTES: 4 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: <a href="#">1C050-0100-045-XA 1620</a>	
Operation 48/54 DESCRIPTION: Alesatura 2 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 1mm MAXIMUM STEPOVER: 9.21mm	MAXIMUM SPINDLE SPEED: 6565rpm MAXIMUM FEEDRATE: 2000mm/min CUTTING DISTANCE: 91.85mm RAPID DISTANCE: 209mm ESTIMATED CYCLE TIME: 6s (0.3%) COOLANT: Flood	<b>T17 D17 L17</b> TYPE: slot mill DIAMETER: 9.7mm LENGTH: 23.23mm FLUTES: 3 DESCRIPTION: CoroMill 327 VENDOR: Sandvik PRODUCT: 327-12B21EC-06 ; 327R06-10 10000-GM 1025	
Operation 49/54 DESCRIPTION: Smussatura interna STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 11.12mm	MAXIMUM SPINDLE SPEED: 5440rpm MAXIMUM FEEDRATE: 1000mm/min CUTTING DISTANCE: 77.55mm RAPID DISTANCE: 223.55mm ESTIMATED CYCLE TIME: 8s (0.4%) COOLANT: Flood	<b>T18 D18 L18</b> TYPE: dovetail mill DIAMETER: 11.7mm TAPER ANGLE: 45° LENGTH: 23.23mm FLUTES: 3 DESCRIPTION: T0404 VENDOR: Sandvik PRODUCT: 327R06-12 12045-CH 1025 ; 327-12B21EC-06	
Operation 50/54 DESCRIPTION: Finitura 8 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 1.2mm	MAXIMUM SPINDLE SPEED: 7000rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 101.49mm RAPID DISTANCE: 52.5mm ESTIMATED CYCLE TIME: 7s (0.3%) COOLANT: Flood	<b>T10 D10 L10</b> TYPE: ball end mill DIAMETER: 6mm CORNER RADIUS: 3mm LENGTH: 30mm FLUTES: 2 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: <a href="#">R216.62-06030-AQ07G 1610</a>	
Operation 51/54 DESCRIPTION: Finitura 9 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 1.2mm	MAXIMUM SPINDLE SPEED: 7000rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 81.36mm RAPID DISTANCE: 76.4mm ESTIMATED CYCLE TIME: 5s (0.2%) COOLANT: Flood	<b>T10 D10 L10</b> TYPE: ball end mill DIAMETER: 6mm CORNER RADIUS: 3mm LENGTH: 30mm FLUTES: 2 DESCRIPTION: CoroMill plura VENDOR: Sandvik PRODUCT: <a href="#">R216.62-06030-AQ07G 1610</a>	
Operation 52/54 DESCRIPTION: Finitura 10 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 94.22mm RAPID DISTANCE: 51.85mm ESTIMATED CYCLE TIME: 7s (0.3%) COOLANT: Flood	<b>T6 D6 L6</b> TYPE: flat end mill DIAMETER: 6mm LENGTH: 28.8mm FLUTES: 7 DESCRIPTION: CoroMill dura VENDOR: Sandvik PRODUCT: <a href="#">1K377-0600-050-XD 1730</a>	
Operation 53/54 DESCRIPTION: Finitura 11 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 7960rpm MAXIMUM FEEDRATE: 1500mm/min CUTTING DISTANCE: 94.27mm RAPID DISTANCE: 51.9mm ESTIMATED CYCLE TIME: 7s (0.3%) COOLANT: Flood	<b>T6 D6 L6</b> TYPE: flat end mill DIAMETER: 6mm LENGTH: 28.8mm FLUTES: 7 DESCRIPTION: CoroMill dura VENDOR: Sandvik PRODUCT: <a href="#">1K377-0600-050-XD 1730</a>	

Operation 54/54		<b>T4 D4 L4</b>	
DESCRIPTION: Smussatura 9	MAXIMUM SPINDLE SPEED: 7960rpm	TYPE: chamfer mill	
STRATEGY: Contour 2D	MAXIMUM FEEDRATE: 1500mm/min	DIAMETER: 6mm	
WCS: #1	CUTTING DISTANCE: 203.78mm	TAPER ANGLE: 45°	
TOLERANCE: 0.01mm	RAPID DISTANCE: 267.5mm	LENGTH: 25mm	
STOCK TO LEAVE: 0mm	ESTIMATED CYCLE TIME: 19s (0.9%)	FLUTES: 4	
MAXIMUM STEPOVER: 5.7mm	COOLANT: Flood	DESCRIPTION: CoroMill Dura	
		VENDOR: Sandvik	
		PRODUCT: <a href="#">1C050-0100-045-XA 1620</a>	