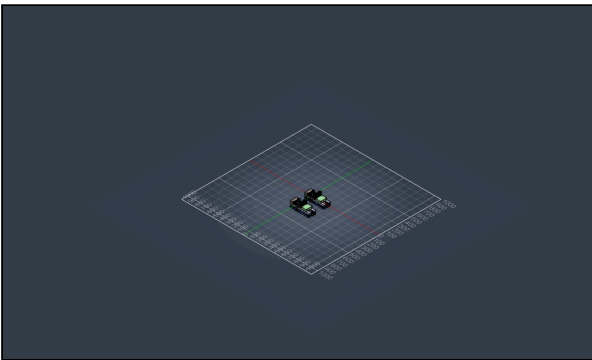
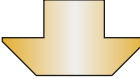



Setup Sheet for Program 1001

JOB DESCRIPTION: Setup1
DOCUMENT PATH: Finito v20 v1

Setup	
<p>WCS: #1</p> <p>Stock:</p> <p>DX: 95mm DY: 395mm DZ: 35mm</p> <p>PART:</p> <p>DX: 84.87mm DY: 385mm DZ: 25mm</p> <p>Stock Lower in WCS #1:</p> <p>X: -28.37mm Y: -278.93mm Z: 0.32mm</p> <p>Stock Upper in WCS #1:</p> <p>X: 66.63mm Y: 116.07mm Z: 35.32mm</p>	

Total
<p>NUMBER OF OPERATIONS: 17</p> <p>NUMBER OF TOOLS: 12</p> <p>TOOLS: T1 T2 T3 T4 T5 T6 T7 T8 T9 T10 T11 T12</p> <p>MAXIMUM Z: 50.32mm</p> <p>MINIMUM Z: 2.32mm</p> <p>MAXIMUM FEEDRATE: 4025mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8060rpm</p> <p>CUTTING DISTANCE: 40798.67mm</p> <p>RAPID DISTANCE: 19831.25mm</p> <p>ESTIMATED CYCLE TIME: 1h:24m:59s</p>

Tools	
<p>T1 D1 L1</p> <p>TYPE: face mill</p> <p>DIAMETER: 40mm</p> <p>CORNER RADIUS: 0.8mm</p> <p>TAPER ANGLE: 45°</p> <p>LENGTH: 40mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: Sgrossatura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 345-040Q22-13L</p>	<p>MINIMUM Z: 30.82mm</p> <p>MAXIMUM FEED: 2390mm/min</p> <p>MAXIMUM SPINDLE SPEED: 1500rpm</p> <p>CUTTING DISTANCE: 2069.87mm</p> <p>RAPID DISTANCE: 139.83mm</p> <p>ESTIMATED CYCLE TIME: 55s (1.1%)</p> 
<p>T2 D2 L2</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 4mm</p> <p>CORNER RADIUS: 0.2mm</p> <p>LENGTH: 15.87mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Tasche piccole</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1K335-0400-020-XC 1730</p>	<p>MINIMUM Z: 19.82mm</p> <p>MAXIMUM FEED: 430mm/min</p> <p>MAXIMUM SPINDLE SPEED: 4540rpm</p> <p>CUTTING DISTANCE: 3136.19mm</p> <p>RAPID DISTANCE: 956.05mm</p> <p>ESTIMATED CYCLE TIME: 8m:2s (9.5%)</p> 
<p>T3 D3 L3</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: 20.32mm</p> <p>MAXIMUM FEED: 426mm/min</p> <p>MAXIMUM SPINDLE SPEED: 3620rpm</p> <p>CUTTING DISTANCE: 8474.95mm</p> <p>RAPID DISTANCE: 1097.95mm</p> <p>ESTIMATED CYCLE TIME: 23m:9s (27.2%)</p> 
<p>T4 D4 L4</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</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 862.1-2500-225A0-GM X2BL</p>	<p>MINIMUM Z: 15.32mm</p> <p>MAXIMUM FEED: 214mm/min</p> <p>MAXIMUM SPINDLE SPEED: 4010rpm</p> <p>CUTTING DISTANCE: 570mm</p> <p>RAPID DISTANCE: 3375.32mm</p> <p>ESTIMATED CYCLE TIME: 3m:20s (3.9%)</p> 
<p>T5 D5 L5</p> <p>TYPE: drill</p> <p>DIAMETER: 20mm</p> <p>TIP ANGLE: 147°</p> <p>LENGTH: 79mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: Foro grande</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 860.1-2000-055A1-PM P1BM</p>	<p>MINIMUM Z: 2.32mm</p> <p>MAXIMUM FEED: 1000mm/min</p> <p>MAXIMUM SPINDLE SPEED: 5000rpm</p> <p>CUTTING DISTANCE: 67mm</p> <p>RAPID DISTANCE: 340mm</p> <p>ESTIMATED CYCLE TIME: 8s (0.2%)</p> 
<p>T6 D6 L6</p> <p>TYPE: boring bar</p> <p>DIAMETER: 40mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 1</p> <p>DESCRIPTION: Finitura foro grande</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 825-45TC09-C3</p>	<p>MINIMUM Z: 4.82mm</p> <p>MAXIMUM FEED: 333.333mm/min</p> <p>MAXIMUM SPINDLE SPEED: 1210rpm</p> <p>CUTTING DISTANCE: 61.5mm</p> <p>RAPID DISTANCE: 120.5mm</p> <p>ESTIMATED CYCLE TIME: 13s (0.2%)</p> 

T7 D7 L7 TYPE: face mill DIAMETER: 13.7mm CORNER RADIUS: 0.4mm LENGTH: 20mm FLUTES: 3 DESCRIPTION: Contornatura VENDOR: Sandvik PRODUCT: R390-0137A14-07M	MINIMUM Z: 18.32mm MAXIMUM FEED: 4025mm/min MAXIMUM SPINDLE SPEED: 8060rpm CUTTING DISTANCE: 11283.01mm RAPID DISTANCE: 8819.06mm ESTIMATED CYCLE TIME: 8m:50s (10.4%)	
T8 D8 L8 TYPE: face mill DIAMETER: 63mm CORNER RADIUS: 1mm TAPER ANGLE: 42° LENGTH: 50mm FLUTES: 7 DESCRIPTION: Finitura superficiale VENDOR: Sandvik PRODUCT: 745-063Q22-21H	MINIMUM Z: 30.32mm MAXIMUM FEED: 1980mm/min MAXIMUM SPINDLE SPEED: 1440rpm CUTTING DISTANCE: 1651.86mm RAPID DISTANCE: 124.99mm ESTIMATED CYCLE TIME: 52s (1%)	
T9 D9 L9 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: 19.32mm MAXIMUM FEED: 2154mm/min MAXIMUM SPINDLE SPEED: 5990rpm CUTTING DISTANCE: 1997.23mm RAPID DISTANCE: 1333.16mm ESTIMATED CYCLE TIME: 2m:45s (3.2%)	
T10 D10 L10 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 0.2mm LENGTH: 18mm FLUTES: 5 DESCRIPTION: Finitura tasche no smusso fondo VENDOR: sandvik PRODUCT: 1K335-0400-020-XC 1730	MINIMUM Z: 17.82mm MAXIMUM FEED: 489mm/min MAXIMUM SPINDLE SPEED: 8000rpm CUTTING DISTANCE: 5707.51mm RAPID DISTANCE: 2750.65mm ESTIMATED CYCLE TIME: 15m:54s (18.7%)	
T11 D11 L11 TYPE: bullnose end mill DIAMETER: 4.76mm CORNER RADIUS: 0.38mm LENGTH: 30mm FLUTES: 2 DESCRIPTION: Spallamento VENDOR: Sandvik PRODUCT: 2S342-0476-038-PA 1730	MINIMUM Z: 18.84mm MAXIMUM FEED: 333.333mm/min MAXIMUM SPINDLE SPEED: 5030rpm CUTTING DISTANCE: 2744.49mm RAPID DISTANCE: 436.47mm ESTIMATED CYCLE TIME: 11m:47s (13.9%)	
T12 D12 L12 TYPE: face mill DIAMETER: 13.7mm CORNER RADIUS: 0.4mm LENGTH: 25mm FLUTES: 3 DESCRIPTION: Allargatura foro grande VENDOR: Sandvik PRODUCT: R390-0137EH12-07M	MINIMUM Z: 4.82mm MAXIMUM FEED: 1930mm/min MAXIMUM SPINDLE SPEED: 7840rpm CUTTING DISTANCE: 3035.06mm RAPID DISTANCE: 337.27mm ESTIMATED CYCLE TIME: 6m:3s (7.1%)	

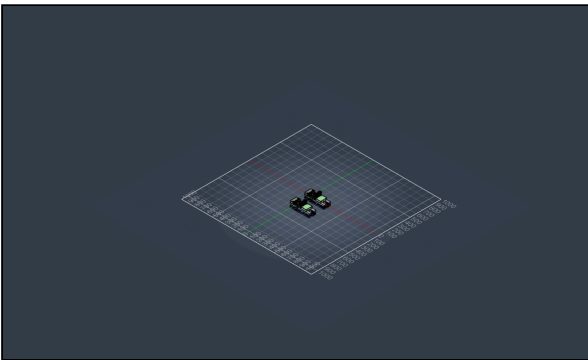
Operations		
Operation 1/17 DESCRIPTION: Face5 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 26.88mm	MAXIMUM Z: 50.32mm MINIMUM Z: 30.82mm MAXIMUM SPINDLE SPEED: 1500rpm MAXIMUM FEEDRATE: 2390mm/min CUTTING DISTANCE: 2069.87mm RAPID DISTANCE: 139.83mm ESTIMATED CYCLE TIME: 55s (1.1%) COOLANT: Flood	T1 D1 L1 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 2/17 DESCRIPTION: 2D Pocket2 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.5mm MAXIMUM STEPDOWN: 10mm MAXIMUM STEPOVER: 3mm	MAXIMUM Z: 50.32mm MINIMUM Z: 20.32mm MAXIMUM SPINDLE SPEED: 3620rpm MAXIMUM FEEDRATE: 426mm/min CUTTING DISTANCE: 8474.95mm RAPID DISTANCE: 1097.95mm ESTIMATED CYCLE TIME: 23m:9s (27.2%) COOLANT: Flood	T3 D3 L3 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 3/17 DESCRIPTION: 2D Pocket7 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.5mm MAXIMUM STEPDOWN: 5.8mm MAXIMUM STEPOVER: 8.22mm	MAXIMUM Z: 50.32mm MINIMUM Z: 18.32mm MAXIMUM SPINDLE SPEED: 8060rpm MAXIMUM FEEDRATE: 4025mm/min CUTTING DISTANCE: 11283.01mm RAPID DISTANCE: 8819.06mm ESTIMATED CYCLE TIME: 8m:50s (10.4%) COOLANT: Flood	T7 D7 L7 TYPE: face mill DIAMETER: 13.7mm CORNER RADIUS: 0.4mm LENGTH: 20mm FLUTES: 3 DESCRIPTION: Contornatura VENDOR: Sandvik PRODUCT: R390-0137A14-07M
Operation 4/17 DESCRIPTION: 2D Pocket4 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.5mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 2.4mm	MAXIMUM Z: 50.32mm MINIMUM Z: 20.32mm MAXIMUM SPINDLE SPEED: 4540rpm MAXIMUM FEEDRATE: 430mm/min CUTTING DISTANCE: 1002.11mm RAPID DISTANCE: 300.58mm ESTIMATED CYCLE TIME: 2m:54s (3.4%) COOLANT: Flood	T2 D2 L2 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 0.2mm LENGTH: 15.87mm FLUTES: 5 DESCRIPTION: Tasche piccole VENDOR: Sandvik PRODUCT: 1K335-0400-020-XC 1730

<p>Operation 5/17 DESCRIPTION: 2D Pocket21 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.5mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 2.4mm</p>	<p>MAXIMUM Z: 50.32mm MINIMUM Z: 19.82mm MAXIMUM SPINDLE SPEED: 4540rpm MAXIMUM FEEDRATE: 430mm/min CUTTING DISTANCE: 2134.08mm RAPID DISTANCE: 655.46mm ESTIMATED CYCLE TIME: 5m:8s (6%) COOLANT: Flood</p>	<p>T2 D2 L2 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 0.2mm LENGTH: 15.87mm FLUTES: 5 DESCRIPTION: Tasche piccole VENDOR: Sandvik PRODUCT: 1K335-0400-020-XC 1730</p>	
<p>Operation 6/17 DESCRIPTION: Drill2 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm</p>	<p>MAXIMUM Z: 50.32mm MINIMUM Z: 2.32mm MAXIMUM SPINDLE SPEED: 5000rpm MAXIMUM FEEDRATE: 1000mm/min CUTTING DISTANCE: 67mm RAPID DISTANCE: 340mm ESTIMATED CYCLE TIME: 8s (0.2%) COOLANT: Flood</p>	<p>T5 D5 L5 TYPE: drill DIAMETER: 20mm TIP ANGLE: 147° LENGTH: 79mm FLUTES: 2 DESCRIPTION: Foro grande VENDOR: Sandvik PRODUCT: 860.1-2000-055A1-PM P1BM</p>	
<p>Operation 7/17 DESCRIPTION: 2D Pocket20 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.5mm MAXIMUM STEPDOWN: 5.8mm MAXIMUM STEPOVER: 8.22mm</p>	<p>MAXIMUM Z: 50.32mm MINIMUM Z: 4.82mm MAXIMUM SPINDLE SPEED: 7840rpm MAXIMUM FEEDRATE: 1930mm/min CUTTING DISTANCE: 3035.06mm RAPID DISTANCE: 337.27mm ESTIMATED CYCLE TIME: 6m:3s (7.1%) COOLANT: Flood</p>	<p>T12 D12 L12 TYPE: face mill DIAMETER: 13.7mm CORNER RADIUS: 0.4mm LENGTH: 25mm FLUTES: 3 DESCRIPTION: Allargatura foro grande VENDOR: Sandvik PRODUCT: R390-0137EH12-07M</p>	
<p>Operation 8/17 DESCRIPTION: Drill3 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm</p>	<p>MAXIMUM Z: 50.32mm MINIMUM Z: 4.82mm MAXIMUM SPINDLE SPEED: 1210rpm MAXIMUM FEEDRATE: 333.333mm/min CUTTING DISTANCE: 31mm RAPID DISTANCE: 60mm ESTIMATED CYCLE TIME: 6s (0.1%) COOLANT: Flood</p>	<p>T6 D6 L6 TYPE: boring bar DIAMETER: 40mm LENGTH: 50mm FLUTES: 1 DESCRIPTION: Finitura foro grande VENDOR: Sandvik PRODUCT: 825-45TC09-C3</p>	
<p>Operation 9/17 DESCRIPTION: Drill5 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm</p>	<p>MAXIMUM Z: 50.32mm MINIMUM Z: 4.82mm MAXIMUM SPINDLE SPEED: 1210rpm MAXIMUM FEEDRATE: 333.333mm/min CUTTING DISTANCE: 30.5mm RAPID DISTANCE: 60.5mm ESTIMATED CYCLE TIME: 6s (0.1%) COOLANT: Flood</p>	<p>T6 D6 L6 TYPE: boring bar DIAMETER: 40mm LENGTH: 50mm FLUTES: 1 DESCRIPTION: Finitura foro grande VENDOR: Sandvik PRODUCT: 825-45TC09-C3</p>	
<p>Operation 10/17 DESCRIPTION: Drill1 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm</p>	<p>MAXIMUM Z: 50.32mm MINIMUM Z: 15.32mm MAXIMUM SPINDLE SPEED: 4010rpm MAXIMUM FEEDRATE: 214mm/min CUTTING DISTANCE: 570mm RAPID DISTANCE: 3375.32mm ESTIMATED CYCLE TIME: 3m:20s (3.9%) COOLANT: Flood</p>	<p>T4 D4 L4 TYPE: drill DIAMETER: 2.5mm TIP ANGLE: 140° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Fori VENDOR: Sanvik PRODUCT: 862.1-2500-225A0-GM X2BL</p>	
<p>Operation 11/17 DESCRIPTION: Face2 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 42.7mm</p>	<p>MAXIMUM Z: 50.32mm MINIMUM Z: 30.32mm MAXIMUM SPINDLE SPEED: 1440rpm MAXIMUM FEEDRATE: 1980mm/min CUTTING DISTANCE: 1651.86mm RAPID DISTANCE: 124.99mm ESTIMATED CYCLE TIME: 52s (1%) COOLANT: Flood</p>	<p>T8 D8 L8 TYPE: face mill DIAMETER: 63mm CORNER RADIUS: 1mm TAPER ANGLE: 42° LENGTH: 50mm FLUTES: 7 DESCRIPTION: Finitura superficiale VENDOR: Sandvik PRODUCT: 745-063Q22-21H</p>	
<p>Operation 12/17 DESCRIPTION: 2D Pocket5 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 2.4mm</p>	<p>MAXIMUM Z: 50.32mm MINIMUM Z: 19.32mm MAXIMUM SPINDLE SPEED: 5340rpm MAXIMUM FEEDRATE: 333.333mm/min CUTTING DISTANCE: 2756.9mm RAPID DISTANCE: 1100.79mm ESTIMATED CYCLE TIME: 9m:25s (11.1%) COOLANT: Flood</p>	<p>T10 D10 L10 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 0.2mm LENGTH: 18mm FLUTES: 5 DESCRIPTION: Finitura tasche no smusso fondo VENDOR: sandvik PRODUCT: 1K335-0400-020-XC 1730</p>	
<p>Operation 13/17 DESCRIPTION: Contornatura 2D3 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 3.8mm</p>	<p>MAXIMUM Z: 50.32mm MINIMUM Z: 19.32mm MAXIMUM SPINDLE SPEED: 8000rpm MAXIMUM FEEDRATE: 489mm/min CUTTING DISTANCE: 1129.2mm RAPID DISTANCE: 1137.06mm ESTIMATED CYCLE TIME: 2m:35s (3%) COOLANT: Flood</p>	<p>T10 D10 L10 TYPE: flat end mill DIAMETER: 4mm LENGTH: 18mm FLUTES: 5 DESCRIPTION: Finitura tasche no smusso pareti VENDOR: sandvik PRODUCT: 1K335-0400-020-XC 1730</p>	
<p>Operation 14/17 DESCRIPTION: 2D Contour3 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 3.8mm</p>	<p>MAXIMUM Z: 50.32mm MINIMUM Z: 17.82mm MAXIMUM SPINDLE SPEED: 8000rpm MAXIMUM FEEDRATE: 489mm/min CUTTING DISTANCE: 1821.42mm RAPID DISTANCE: 512.8mm ESTIMATED CYCLE TIME: 3m:53s (4.6%) COOLANT: Flood</p>	<p>T10 D10 L10 TYPE: flat end mill DIAMETER: 4mm LENGTH: 18mm FLUTES: 5 DESCRIPTION: Finitura tasche no smusso pareti VENDOR: sandvik PRODUCT: 1K335-0400-020-XC 1730</p>	

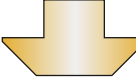

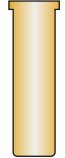
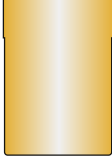
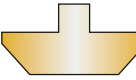
Operation 15/17 DESCRIPTION: 2D Pocket6 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 2.4mm	MAXIMUM Z: 50.32mm MINIMUM Z: 19.32mm MAXIMUM SPINDLE SPEED: 4130rpm MAXIMUM FEEDRATE: 812mm/min CUTTING DISTANCE: 1643.91mm RAPID DISTANCE: 724.54mm ESTIMATED CYCLE TIME: 2m:13s (2.6%) COOLANT: Flood	T9 D9 L9 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 16/17 DESCRIPTION: 2D Contour7 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 1.9mm	MAXIMUM Z: 50.32mm MINIMUM Z: 19.32mm MAXIMUM SPINDLE SPEED: 5990rpm MAXIMUM FEEDRATE: 2154mm/min CUTTING DISTANCE: 353.32mm RAPID DISTANCE: 608.62mm ESTIMATED CYCLE TIME: 31s (0.6%) COOLANT: Flood	T9 D9 L9 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 1mm LENGTH: 14.87mm FLUTES: 5 DESCRIPTION: Finitura pareti VENDOR: Sandvik PRODUCT: R216.23-04050CAK11P 1630	
Operation 17/17 DESCRIPTION: Scallop2 STRATEGY: Scallop WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.12mm	MAXIMUM Z: 50.32mm MINIMUM Z: 18.84mm MAXIMUM SPINDLE SPEED: 5030rpm MAXIMUM FEEDRATE: 333.333mm/min CUTTING DISTANCE: 2744.49mm RAPID DISTANCE: 436.47mm ESTIMATED CYCLE TIME: 11m:47s (13.9%) COOLANT: Flood	T11 D11 L11 TYPE: bullnose end mill DIAMETER: 4.76mm CORNER RADIUS: 0.38mm LENGTH: 30mm FLUTES: 2 DESCRIPTION: Spallamento VENDOR: Sandvik PRODUCT: 2S342-0476-038-PA 1730	

Setup Sheet for Program 1002

JOB DESCRIPTION: Setup2
DOCUMENT PATH: Finito v20 v1

Setup	
<p>WCS: #1</p> <p>STOCK:</p> <p>DX: 95mm DY: 395mm DZ: 35mm</p> <p>PART:</p> <p>DX: 84.87mm DY: 385mm DZ: 25mm</p> <p>STOCK LOWER IN WCS #1:</p> <p>X: -97.21mm Y: -198.04mm Z: 75.46mm</p> <p>STOCK UPPER IN WCS #1:</p> <p>X: -2.21mm Y: 196.96mm Z: 110.46mm</p>	

Total
<p>NUMBER OF OPERATIONS: 12</p> <p>NUMBER OF TOOLS: 8</p> <p>TOOLS: T1 T2 T3 T7 T8 T9 T10 T11</p> <p>MAXIMUM Z: 125.46mm</p> <p>MINIMUM Z: 90.96mm</p> <p>MAXIMUM FEEDRATE: 4025mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8060rpm</p> <p>CUTTING DISTANCE: 39944.95mm</p> <p>RAPID DISTANCE: 14583.21mm</p> <p>ESTIMATED CYCLE TIME: 1h:20m:27s</p>

Tools		
<p>T1 D1 L1</p> <p>TYPE: face mill</p> <p>DIAMETER: 40mm</p> <p>CORNER RADIUS: 0.8mm</p> <p>TAPER ANGLE: 45°</p> <p>LENGTH: 40mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: Sgrossatura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 345-040Q22-13L</p>	<p>MINIMUM Z: 105.96mm</p> <p>MAXIMUM FEED: 2390mm/min</p> <p>MAXIMUM SPINDLE SPEED: 1500rpm</p> <p>CUTTING DISTANCE: 2082.43mm</p> <p>RAPID DISTANCE: 400.36mm</p> <p>ESTIMATED CYCLE TIME: 59s (1.2%)</p>	
<p>T2 D2 L2</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 4mm</p> <p>CORNER RADIUS: 0.2mm</p> <p>LENGTH: 15.87mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Tasche piccole</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1K335-0400-020-XC 1730</p>	<p>MINIMUM Z: 95.46mm</p> <p>MAXIMUM FEED: 430mm/min</p> <p>MAXIMUM SPINDLE SPEED: 4540rpm</p> <p>CUTTING DISTANCE: 4430.56mm</p> <p>RAPID DISTANCE: 908.87mm</p> <p>ESTIMATED CYCLE TIME: 11m:3s (13.7%)</p>	
<p>T3 D3 L3</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: 95.46mm</p> <p>MAXIMUM FEED: 426mm/min</p> <p>MAXIMUM SPINDLE SPEED: 3620rpm</p> <p>CUTTING DISTANCE: 8487.03mm</p> <p>RAPID DISTANCE: 1087.62mm</p> <p>ESTIMATED CYCLE TIME: 23m:11s (28.8%)</p>	
<p>T7 D7 L7</p> <p>TYPE: face mill</p> <p>DIAMETER: 13.7mm</p> <p>CORNER RADIUS: 0.4mm</p> <p>LENGTH: 20mm</p> <p>FLUTES: 3</p> <p>DESCRIPTION: Contornatura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: R390-0137A14-07M</p>	<p>MINIMUM Z: 91.46mm</p> <p>MAXIMUM FEED: 4025mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8060rpm</p> <p>CUTTING DISTANCE: 11483.88mm</p> <p>RAPID DISTANCE: 7506.38mm</p> <p>ESTIMATED CYCLE TIME: 8m:44s (10.9%)</p>	
<p>T8 D8 L8</p> <p>TYPE: face mill</p> <p>DIAMETER: 63mm</p> <p>CORNER RADIUS: 1mm</p> <p>TAPER ANGLE: 42°</p> <p>LENGTH: 50mm</p> <p>FLUTES: 7</p> <p>DESCRIPTION: Finitura superficiale</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 745-063Q22-21H</p>	<p>MINIMUM Z: 105.46mm</p> <p>MAXIMUM FEED: 1980mm/min</p> <p>MAXIMUM SPINDLE SPEED: 1440rpm</p> <p>CUTTING DISTANCE: 1633.22mm</p> <p>RAPID DISTANCE: 119.54mm</p> <p>ESTIMATED CYCLE TIME: 51s (1.1%)</p>	

T9 D9 L9 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: 94.46mm MAXIMUM FEED: 2154mm/min MAXIMUM SPINDLE SPEED: 5990rpm CUTTING DISTANCE: 1997.34mm RAPID DISTANCE: 1294.02mm ESTIMATED CYCLE TIME: 2m:51s (3.5%)	
T10 D10 L10 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 0.2mm LENGTH: 18mm FLUTES: 5 DESCRIPTION: Finitura tasche no smusso fondo VENDOR: sandvik PRODUCT: 1K335-0400-020-XC 1730	MINIMUM Z: 90.96mm MAXIMUM FEED: 489mm/min MAXIMUM SPINDLE SPEED: 8000rpm CUTTING DISTANCE: 7071.33mm RAPID DISTANCE: 2836.1mm ESTIMATED CYCLE TIME: 18m:59s (23.6%)	
T11 D11 L11 TYPE: bullnose end mill DIAMETER: 4.76mm CORNER RADIUS: 0.38mm LENGTH: 30mm FLUTES: 2 DESCRIPTION: Spallamento VENDOR: Sandvik PRODUCT: 2S342-0476-038-PA 1730	MINIMUM Z: 93.98mm MAXIMUM FEED: 333.333mm/min MAXIMUM SPINDLE SPEED: 5030rpm CUTTING DISTANCE: 2759.16mm RAPID DISTANCE: 430.34mm ESTIMATED CYCLE TIME: 11m:50s (14.7%)	

Operations		
Operation 1/12 DESCRIPTION: Face6 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 26.88mm	MAXIMUM Z: 125.46mm MINIMUM Z: 105.96mm MAXIMUM SPINDLE SPEED: 1500rpm MAXIMUM FEEDRATE: 2390mm/min CUTTING DISTANCE: 2082.43mm RAPID DISTANCE: 400.36mm ESTIMATED CYCLE TIME: 59s (1.2%) COOLANT: Flood	T1 D1 L1 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 2/12 DESCRIPTION: 2D Pocket9 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.5mm MAXIMUM STEPDOWN: 10mm MAXIMUM STEPOVER: 3mm	MAXIMUM Z: 125.46mm MINIMUM Z: 95.46mm MAXIMUM SPINDLE SPEED: 3620rpm MAXIMUM FEEDRATE: 426mm/min CUTTING DISTANCE: 8487.03mm RAPID DISTANCE: 1087.62mm ESTIMATED CYCLE TIME: 23m:11s (28.8%) COOLANT: Flood	T3 D3 L3 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 3/12 DESCRIPTION: 2D Pocket13 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.5mm MAXIMUM STEPDOWN: 5.8mm MAXIMUM STEPOVER: 8.22mm	MAXIMUM Z: 125.46mm MINIMUM Z: 91.46mm MAXIMUM SPINDLE SPEED: 8060rpm MAXIMUM FEEDRATE: 4025mm/min CUTTING DISTANCE: 11483.88mm RAPID DISTANCE: 7506.38mm ESTIMATED CYCLE TIME: 8m:44s (10.9%) COOLANT: Flood	T7 D7 L7 TYPE: face mill DIAMETER: 13.7mm CORNER RADIUS: 0.4mm LENGTH: 20mm FLUTES: 3 DESCRIPTION: Contornatura VENDOR: Sandvik PRODUCT: R390-0137A14-07M
Operation 4/12 DESCRIPTION: 2D Pocket14 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.5mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 2.4mm	MAXIMUM Z: 125.46mm MINIMUM Z: 95.46mm MAXIMUM SPINDLE SPEED: 4540rpm MAXIMUM FEEDRATE: 430mm/min CUTTING DISTANCE: 1006.76mm RAPID DISTANCE: 307.01mm ESTIMATED CYCLE TIME: 2m:55s (3.6%) COOLANT: Flood	T2 D2 L2 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 0.2mm LENGTH: 15.87mm FLUTES: 5 DESCRIPTION: Tasche piccole VENDOR: Sandvik PRODUCT: 1K335-0400-020-XC 1730
Operation 5/12 DESCRIPTION: 2D Pocket18 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.5mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 2.4mm	MAXIMUM Z: 125.46mm MINIMUM Z: 95.46mm MAXIMUM SPINDLE SPEED: 4540rpm MAXIMUM FEEDRATE: 430mm/min CUTTING DISTANCE: 3423.8mm RAPID DISTANCE: 601.86mm ESTIMATED CYCLE TIME: 8m:7s (10.1%) COOLANT: Flood	T2 D2 L2 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 0.2mm LENGTH: 15.87mm FLUTES: 5 DESCRIPTION: Tasche piccole VENDOR: Sandvik PRODUCT: 1K335-0400-020-XC 1730
Operation 6/12 DESCRIPTION: Face7 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 42.7mm	MAXIMUM Z: 125.46mm MINIMUM Z: 105.46mm MAXIMUM SPINDLE SPEED: 1440rpm MAXIMUM FEEDRATE: 1980mm/min CUTTING DISTANCE: 1633.22mm RAPID DISTANCE: 119.54mm ESTIMATED CYCLE TIME: 51s (1.1%) COOLANT: Flood	T8 D8 L8 TYPE: face mill DIAMETER: 63mm CORNER RADIUS: 1mm TAPER ANGLE: 42° LENGTH: 50mm FLUTES: 7 DESCRIPTION: Finitura superficiale VENDOR: Sandvik PRODUCT: 745-063Q22-21H
Operation 7/12 DESCRIPTION: 2D Pocket15 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 2.4mm	MAXIMUM Z: 125.46mm MINIMUM Z: 94.46mm MAXIMUM SPINDLE SPEED: 5340rpm MAXIMUM FEEDRATE: 333.333mm/min CUTTING DISTANCE: 2759.52mm RAPID DISTANCE: 1051.31mm ESTIMATED CYCLE TIME: 9m:25s (11.7%) COOLANT: Flood	T10 D10 L10 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 0.2mm LENGTH: 18mm FLUTES: 5 DESCRIPTION: Finitura tasche no smusso fondo VENDOR: sandvik PRODUCT: 1K335-0400-020-XC 1730

Operation 8/12 DESCRIPTION: 2D Contour5 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 3.8mm	MAXIMUM Z: 125.46mm MINIMUM Z: 94.46mm MAXIMUM SPINDLE SPEED: 8000rpm MAXIMUM FEEDRATE: 489mm/min CUTTING DISTANCE: 2486.4mm RAPID DISTANCE: 1280.13mm ESTIMATED CYCLE TIME: 5m:40s (7%) COOLANT: Flood	T10 D10 L10 TYPE: flat end mill DIAMETER: 4mm LENGTH: 18mm FLUTES: 5 DESCRIPTION: Finitura tasche no smusso pareti VENDOR: sandvik PRODUCT: 1K335-0400-020-XC 1730	
Operation 9/12 DESCRIPTION: 2D Contour6 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8mm MAXIMUM STEPOVER: 3.8mm	MAXIMUM Z: 125.46mm MINIMUM Z: 90.96mm MAXIMUM SPINDLE SPEED: 8000rpm MAXIMUM FEEDRATE: 489mm/min CUTTING DISTANCE: 1825.42mm RAPID DISTANCE: 504.66mm ESTIMATED CYCLE TIME: 3m:54s (4.8%) COOLANT: Flood	T10 D10 L10 TYPE: flat end mill DIAMETER: 4mm LENGTH: 18mm FLUTES: 5 DESCRIPTION: Finitura tasche no smusso pareti VENDOR: sandvik PRODUCT: 1K335-0400-020-XC 1730	
Operation 10/12 DESCRIPTION: 2D Pocket17 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 2.4mm	MAXIMUM Z: 125.46mm MINIMUM Z: 94.46mm MAXIMUM SPINDLE SPEED: 4130rpm MAXIMUM FEEDRATE: 812mm/min CUTTING DISTANCE: 1644.02mm RAPID DISTANCE: 696.5mm ESTIMATED CYCLE TIME: 2m:20s (2.9%) COOLANT: Flood	T9 D9 L9 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 11/12 DESCRIPTION: 2D Contour8 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 1.9mm	MAXIMUM Z: 125.46mm MINIMUM Z: 94.46mm MAXIMUM SPINDLE SPEED: 5990rpm MAXIMUM FEEDRATE: 2154mm/min CUTTING DISTANCE: 353.32mm RAPID DISTANCE: 597.52mm ESTIMATED CYCLE TIME: 31s (0.6%) COOLANT: Flood	T9 D9 L9 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 1mm LENGTH: 14.87mm FLUTES: 5 DESCRIPTION: Finitura pareti VENDOR: Sandvik PRODUCT: R216.23-04050CAK11P 1630	
Operation 12/12 DESCRIPTION: Scallop5 STRATEGY: Scallop WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.12mm	MAXIMUM Z: 125.46mm MINIMUM Z: 93.98mm MAXIMUM SPINDLE SPEED: 5030rpm MAXIMUM FEEDRATE: 333.333mm/min CUTTING DISTANCE: 2759.16mm RAPID DISTANCE: 430.34mm ESTIMATED CYCLE TIME: 11m:50s (14.7%) COOLANT: Flood	T11 D11 L11 TYPE: bullnose end mill DIAMETER: 4.76mm CORNER RADIUS: 0.38mm LENGTH: 30mm FLUTES: 2 DESCRIPTION: Spallamento VENDOR: Sandvik PRODUCT: 2S342-0476-038-PA 1730	