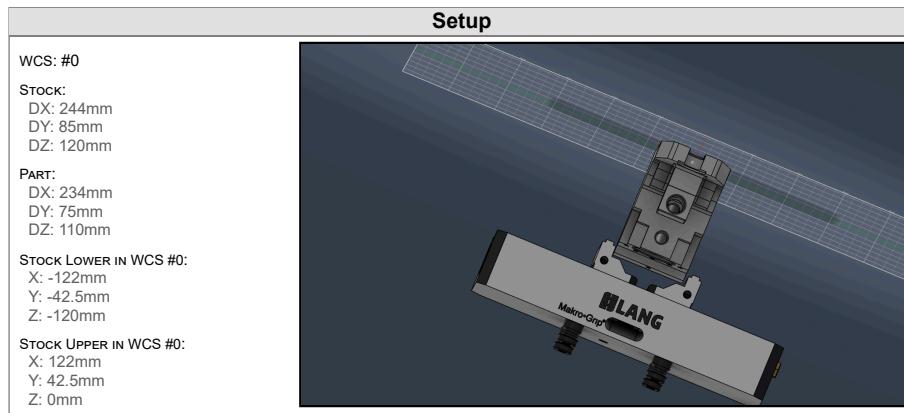


Setup Sheet for Program 1001

JOB DESCRIPTION: AutoSetup 1
 DOCUMENT PATH: 0NC01_DFM_01 v2



Total

NUMBER OF OPERATIONS: 63
NUMBER OF TOOLS: 12
TOOLS: T10001 T10002 T10003 T10007 T10013 T10014 T10109 T10110 T10112 T10113 T10118 T10120
MAXIMUM FEEDRATE: 5184mm/min
MAXIMUM SPINDLE SPEED: 8100rpm
CUTTING DISTANCE: 75487.6mm
RAPID DISTANCE: 75414.23mm
ESTIMATED CYCLE TIME: 1h:12m:38s

Tools

T10001 D10001 L10001	TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730	MAXIMUM FEED: 5184mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 34695.48mm RAPID DISTANCE: 36232.04mm ESTIMATED CYCLE TIME: 15m:24s (21.2%)	HOLDER: BT40 - B4C4-1000
T10002 D10002 L10002	TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: 1K334-1000-100-XD 1730	MAXIMUM FEED: 3012.053mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 8134.05mm RAPID DISTANCE: 7456.83mm ESTIMATED CYCLE TIME: 8m:56s (12.3%)	HOLDER: BT40 - B4C4-1000
T10003 D10003 L10003	TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730	MAXIMUM FEED: 1780mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 20564.11mm RAPID DISTANCE: 17566.19mm ESTIMATED CYCLE TIME: 30m:33s (42.1%)	HOLDER: BT40 - B4C4-1000
T10007 D10007 L10007	TYPE: drill DIAMETER: 4.5mm TIP ANGLE: 118° LENGTH: 55mm FLUTES: 2 DESCRIPTION: Punta a forare M4.5 H8 VENDOR: Mitsubishi PRODUCT: VSDD0450	MAXIMUM FEED: 532.47mm/min MAXIMUM SPINDLE SPEED: 5145rpm CUTTING DISTANCE: 53.96mm RAPID DISTANCE: 83.96mm ESTIMATED CYCLE TIME: 7s (0.2%)	HOLDER: BT40 - B4C4-1000
T10013 D10013 L10013	TYPE: chamfer mill DIAMETER: 12mm TAPER ANGLE: 45° LENGTH: 50mm FLUTES: 6 DESCRIPTION: Fresa per smussature VENDOR: Sandvik PRODUCT: 1C050-0300-045-XB 1620	MAXIMUM FEED: 2916mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 372.91mm RAPID DISTANCE: 195.03mm ESTIMATED CYCLE TIME: 12s (0.3%)	HOLDER: BT40 - B4C4-1000
T10014 D10014 L10014	TYPE: drill DIAMETER: 4.2mm TIP ANGLE: 118° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Punta a forare M4.2 H8 VENDOR: Mitsubishi PRODUCT: VSDD0420	MAXIMUM FEED: 534.567mm/min MAXIMUM SPINDLE SPEED: 5534rpm CUTTING DISTANCE: 42.52mm RAPID DISTANCE: 252.52mm ESTIMATED CYCLE TIME: 8s (0.2%)	HOLDER: BT40 - B4C4-1000

T10109 D10109 L10109 TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 1.2mm LENGTH: 60mm FLUTES: 3 DESCRIPTION: Fresa per lavorazione grossa tasca centrale VENDOR: Sandvik PRODUCT: R390-040C4-18M060	MAXIMUM FEED: 2864.789mm/min MAXIMUM SPINDLE SPEED: 4775rpm CUTTING DISTANCE: 1926.11mm RAPID DISTANCE: 51.75mm ESTIMATED CYCLE TIME: 48s (1.1%)	HOLDER: BT40 - B4C4-1000	
T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730	MAXIMUM FEED: 4458.366mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 6039.58mm RAPID DISTANCE: 5151.09mm ESTIMATED CYCLE TIME: 6m:23s (8.8%)	HOLDER: BT40 - B4C4-1000	
T10112 D10112 L10112 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216.24-10050CCK22P 1620	MAXIMUM FEED: 3057.303mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 3228.05mm RAPID DISTANCE: 7873.97mm ESTIMATED CYCLE TIME: 3m:28s (4.8%)	HOLDER: BT40 - B4C4-1000	
T10113 D10113 L10113 TYPE: drill DIAMETER: 20mm TIP ANGLE: 147° LENGTH: 110mm FLUTES: 2 DESCRIPTION: Punta a forare M20 H8 VENDOR: Sandvik PRODUCT: 860.1-2000-077A1-PM P1BM	MAXIMUM FEED: 576.357mm/min MAXIMUM SPINDLE SPEED: 1253rpm CUTTING DISTANCE: 97.56mm RAPID DISTANCE: 127.56mm ESTIMATED CYCLE TIME: 12s (0.3%)	HOLDER: BT40 - B4C4-1000	
T10118 D10118 L10118 TYPE: drill DIAMETER: 14mm TIP ANGLE: 147° LENGTH: 150mm FLUTES: 2 DESCRIPTION: Punta a forare M14 H8 VENDOR: Sandvik PRODUCT: 860.1-1400-115A1-PM P1BM	MAXIMUM FEED: 535.928mm/min MAXIMUM SPINDLE SPEED: 1664rpm CUTTING DISTANCE: 128.11mm RAPID DISTANCE: 158.11mm ESTIMATED CYCLE TIME: 16s (0.4%)	HOLDER: BT40 - B4C4-1000	
T10120 D10120 L10120 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 120mm FLUTES: 2 DESCRIPTION: Punta a forare M12 H8 VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM	MAXIMUM FEED: 535.906mm/min MAXIMUM SPINDLE SPEED: 1942rpm CUTTING DISTANCE: 205.17mm RAPID DISTANCE: 265.17mm ESTIMATED CYCLE TIME: 26s (0.6%)	HOLDER: BT40 - B4C4-1000	

Operations

Operation 1/63 DESCRIPTION: Roughing STRATEGY: Facing WCS: #0 TOLERANCE: 0.01mm MAXIMUM STEPDOWN: 14.63mm MAXIMUM STEPOVER: 30mm	MAXIMUM SPINDLE SPEED: 3795rpm MAXIMUM FEEDRATE: 2277.197mm/min CUTTING DISTANCE: 962.99mm RAPID DISTANCE: 25.75mm ESTIMATED CYCLE TIME: 26s (0.6%) COOLANT: Flood	T10109 D10109 L10109 TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 1.2mm LENGTH: 60mm FLUTES: 3 DESCRIPTION: Fresa per lavorazione grossa tasca centrale VENDOR: Sandvik PRODUCT: R390-040C4-18M060
Operation 2/63 DESCRIPTION: Finishing STRATEGY: Facing WCS: #0 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 36mm	MAXIMUM SPINDLE SPEED: 4775rpm MAXIMUM FEEDRATE: 2864.789mm/min CUTTING DISTANCE: 963.12mm RAPID DISTANCE: 26mm ESTIMATED CYCLE TIME: 21s (0.5%) COOLANT: Flood	T10109 D10109 L10109 TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 1.2mm LENGTH: 60mm FLUTES: 3 DESCRIPTION: Fresa per lavorazione grossa tasca centrale VENDOR: Sandvik PRODUCT: R390-040C4-18M060
Operation 3/63 DESCRIPTION: Roughing STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 19.95mm OPTIMAL LOAD: 6.75mm LOAD DEVIATION: 0.68mm NOTES:	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4876.077mm/min CUTTING DISTANCE: 10472.93mm RAPID DISTANCE: 10819.7mm ESTIMATED CYCLE TIME: 4m:19s (5.9%) COOLANT: Flood	T10001 D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730

This roughing operation may lead to collisions with the shaft or holder, due to a known limitation in Fusion. Enabling Shaft & Holder might help but results vary. Please check the See details in <https://clouddnc.atlassian.net/wiki/x/AYCREg>

Operation 4/63	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4876.077mm/min CUTTING DISTANCE: 10752.4mm RAPID DISTANCE: 11550.94mm ESTIMATED CYCLE TIME: 4m:33s (6.3%) COOLANT: Flood	T10001 D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730
This roughing operation may lead to collisions with the shaft or holder, due to a known limitation in Fusion. Enabling Shaft & Holder might help but results vary. Please check the See details in https://cloudnc.atlassian.net/wiki/x/AYCREg		
Operation 5/63	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4876.077mm/min CUTTING DISTANCE: 3650.83mm RAPID DISTANCE: 3881.27mm ESTIMATED CYCLE TIME: 2m:16s (3.1%) COOLANT: Flood	T10001 D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730
Operation 6/63	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4876.077mm/min CUTTING DISTANCE: 3610.65mm RAPID DISTANCE: 5125.61mm ESTIMATED CYCLE TIME: 2m:0s (2.7%) COOLANT: Flood	T10001 D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730
Operation 7/63	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4876.077mm/min CUTTING DISTANCE: 2213.21mm RAPID DISTANCE: 4200.78mm ESTIMATED CYCLE TIME: 1m:18s (1.8%) COOLANT: Flood	T10001 D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730
Operation 8/63	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4458.366mm/min CUTTING DISTANCE: 3065.92mm RAPID DISTANCE: 2234.17mm ESTIMATED CYCLE TIME: 4m:24s (6%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 9/63	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3012.053mm/min CUTTING DISTANCE: 2528.9mm RAPID DISTANCE: 1442.3mm ESTIMATED CYCLE TIME: 1m:8s (1.6%) COOLANT: Flood	T10002 D10002 L10002 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: 1K334-1000-100-XD 1730
Operation 10/63	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3012.053mm/min CUTTING DISTANCE: 2838.92mm RAPID DISTANCE: 2003.48mm ESTIMATED CYCLE TIME: 4m:55s (6.8%) COOLANT: Flood	T10002 D10002 L10002 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: 1K334-1000-100-XD 1730
Operation 11/63	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3012.053mm/min CUTTING DISTANCE: 582.14mm RAPID DISTANCE: 1154.04mm ESTIMATED CYCLE TIME: 36s (0.8%) COOLANT: Flood	T10002 D10002 L10002 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: 1K334-1000-100-XD 1730
Operation 12/63	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3012.053mm/min CUTTING DISTANCE: 583.22mm RAPID DISTANCE: 1286.93mm ESTIMATED CYCLE TIME: 38s (0.9%) COOLANT: Flood	T10002 D10002 L10002 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: 1K334-1000-100-XD 1730

Operation 13/63 DESCRIPTION: Roughing10 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 2.2mm OPTIMAL LOAD: 7.5mm LOAD DEVIATION: 0.75mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3012.053mm/min CUTTING DISTANCE: 413.19mm RAPID DISTANCE: 404.44mm ESTIMATED CYCLE TIME: 39s (0.9%) COOLANT: Flood	T10002 D10002 L10002 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: 1K334-1000-100-XD 1730
Operation 14/63 DESCRIPTION: Roughing11 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.55mm OPTIMAL LOAD: 7.5mm LOAD DEVIATION: 0.75mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3057.303mm/min CUTTING DISTANCE: 2376.89mm RAPID DISTANCE: 6627.84mm ESTIMATED CYCLE TIME: 2m:40s (3.7%) COOLANT: Flood	T10112 D10112 L10112 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216.24-10050CCK22P 1620
Operation 15/63 DESCRIPTION: Roughing12 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.8mm OPTIMAL LOAD: 5.7mm LOAD DEVIATION: 0.57mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1704.805mm/min CUTTING DISTANCE: 3893.75mm RAPID DISTANCE: 1599.75mm ESTIMATED CYCLE TIME: 10m:55s (15%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 16/63 DESCRIPTION: Roughing13 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.8mm OPTIMAL LOAD: 5.7mm LOAD DEVIATION: 0.57mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1704.805mm/min CUTTING DISTANCE: 96.02mm RAPID DISTANCE: 240.42mm ESTIMATED CYCLE TIME: 6s (0.1%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 17/63 DESCRIPTION: Roughing14 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.8mm OPTIMAL LOAD: 5.7mm LOAD DEVIATION: 0.57mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1704.805mm/min CUTTING DISTANCE: 95.56mm RAPID DISTANCE: 244.55mm ESTIMATED CYCLE TIME: 6s (0.1%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 18/63 DESCRIPTION: Flat WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 9.8mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3240mm/min CUTTING DISTANCE: 165.96mm RAPID DISTANCE: 332.76mm ESTIMATED CYCLE TIME: 8s (0.2%) COOLANT: Flood	T10001 D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730
Operation 19/63 DESCRIPTION: Flat1 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 95.21mm RAPID DISTANCE: 105.96mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 20/63 DESCRIPTION: Flat2 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 1088.65mm RAPID DISTANCE: 1090.59mm ESTIMATED CYCLE TIME: 36s (0.8%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
NOTES: This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 21/63 DESCRIPTION: Flat3 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 95.32mm RAPID DISTANCE: 109.66mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 22/63 DESCRIPTION: Flat4 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 1084.93mm RAPID DISTANCE: 893.04mm ESTIMATED CYCLE TIME: 33s (0.8%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730

NOTES:

This flat finishing operation may not fully finish the surface. Please check the simulation.

Operation 23/63 DESCRIPTION: Flat5 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 178.27mm RAPID DISTANCE: 359.53mm ESTIMATED CYCLE TIME: 10s (0.2%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 24/63 DESCRIPTION: Flat6 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 7mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1620mm/min CUTTING DISTANCE: 275.52mm RAPID DISTANCE: 317.28mm ESTIMATED CYCLE TIME: 15s (0.4%) COOLANT: Flood	T10002 D10002 L10002 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: 1K334-1000-100-XD 1730
Operation 25/63 DESCRIPTION: Flat7 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 7mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1620mm/min CUTTING DISTANCE: 137mm RAPID DISTANCE: 96.55mm ESTIMATED CYCLE TIME: 7s (0.2%) COOLANT: Flood	T10002 D10002 L10002 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: 1K334-1000-100-XD 1730
Operation 26/63 DESCRIPTION: Flat8 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 6.86mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1620mm/min CUTTING DISTANCE: 377.92mm RAPID DISTANCE: 597.37mm ESTIMATED CYCLE TIME: 22s (0.5%) COOLANT: Flood	T10112 D10112 L10112 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216.24-10050CCK22P 1620
NOTES: This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 27/63 DESCRIPTION: Flat9 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 6.86mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1620mm/min CUTTING DISTANCE: 377.93mm RAPID DISTANCE: 536.03mm ESTIMATED CYCLE TIME: 21s (0.5%) COOLANT: Flood	T10112 D10112 L10112 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216.24-10050CCK22P 1620
NOTES: This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 28/63 DESCRIPTION: Flat10 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 4.9mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 1435.89mm RAPID DISTANCE: 3230.48mm ESTIMATED CYCLE TIME: 1m:47s (2.5%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 29/63 DESCRIPTION: Wall STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 16mm MAXIMUM STEPOVER: 6.65mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 120.01mm RAPID DISTANCE: 107.21mm ESTIMATED CYCLE TIME: 12s (0.3%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 30/63 DESCRIPTION: Wall1 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 16mm MAXIMUM STEPOVER: 6.65mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 120.01mm RAPID DISTANCE: 107.21mm ESTIMATED CYCLE TIME: 12s (0.3%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 31/63 DESCRIPTION: Wall2 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 16mm MAXIMUM STEPOVER: 6.65mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 108.62mm RAPID DISTANCE: 253.9mm ESTIMATED CYCLE TIME: 14s (0.3%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730

Operation 32/63 DESCRIPTION: Wall3 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 70mm MAXIMUM STEPOVER: 19mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2001.934mm/min CUTTING DISTANCE: 62.14mm RAPID DISTANCE: 36.25mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 33/63 DESCRIPTION: Wall4 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 70mm MAXIMUM STEPOVER: 19mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2001.934mm/min CUTTING DISTANCE: 52.82mm RAPID DISTANCE: 87.75mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 34/63 DESCRIPTION: Wall5 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 70mm MAXIMUM STEPOVER: 19mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2001.934mm/min CUTTING DISTANCE: 62.14mm RAPID DISTANCE: 36.25mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 35/63 DESCRIPTION: Wall6 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 70mm MAXIMUM STEPOVER: 19mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2001.934mm/min CUTTING DISTANCE: 254.18mm RAPID DISTANCE: 197.9mm ESTIMATED CYCLE TIME: 20s (0.5%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 36/63 DESCRIPTION: Wall7 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 38mm MAXIMUM STEPOVER: 13.3mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5184mm/min CUTTING DISTANCE: 110.97mm RAPID DISTANCE: 58.99mm ESTIMATED CYCLE TIME: 3s (0.1%) COOLANT: Flood	T10001 D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730
Operation 37/63 DESCRIPTION: Wall8 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 22mm MAXIMUM STEPOVER: 9.5mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2592mm/min CUTTING DISTANCE: 108.8mm RAPID DISTANCE: 36.23mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	T10002 D10002 L10002 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: 1K334-1000-100-XD 1730
Operation 38/63 DESCRIPTION: Wall9 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 22mm MAXIMUM STEPOVER: 9.5mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2592mm/min CUTTING DISTANCE: 188.43mm RAPID DISTANCE: 263.76mm ESTIMATED CYCLE TIME: 10s (0.2%) COOLANT: Flood	T10002 D10002 L10002 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: 1K334-1000-100-XD 1730
Operation 39/63 DESCRIPTION: Wall10 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 22mm MAXIMUM STEPOVER: 9.5mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2592mm/min CUTTING DISTANCE: 346.23mm RAPID DISTANCE: 261.87mm ESTIMATED CYCLE TIME: 16s (0.4%) COOLANT: Flood	T10002 D10002 L10002 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: 1K334-1000-100-XD 1730
Operation 40/63 DESCRIPTION: Wall11 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 22mm MAXIMUM STEPOVER: 9.5mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2592mm/min CUTTING DISTANCE: 90.57mm RAPID DISTANCE: 88.75mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	T10002 D10002 L10002 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: 1K334-1000-100-XD 1730
Operation 41/63 DESCRIPTION: Wall12 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 22mm MAXIMUM STEPOVER: 9.5mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2592mm/min CUTTING DISTANCE: 41.12mm RAPID DISTANCE: 101.2mm ESTIMATED CYCLE TIME: 3s (0.1%) COOLANT: Flood	T10002 D10002 L10002 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: 1K334-1000-100-XD 1730
Operation 42/63 DESCRIPTION: Wall13 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 11mm MAXIMUM STEPOVER: 9.31mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1265mm/min CUTTING DISTANCE: 95.3mm RAPID DISTANCE: 112.73mm ESTIMATED CYCLE TIME: 6s (0.1%) COOLANT: Flood	T10112 D10112 L10112 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216_24-10050CCK22P 1620

Operation 43/63 DESCRIPTION: Holermaking STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1942rpm MAXIMUM FEEDRATE: 535.906mm/min CUTTING DISTANCE: 127.12mm RAPID DISTANCE: 157.12mm ESTIMATED CYCLE TIME: 16s (0.4%) COOLANT: Flood	T10120 D10120 L10120 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 120mm FLUTES: 2 DESCRIPTION: Punta a forare M12 H8 VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM
Operation 44/63 DESCRIPTION: Holermaking1 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1942rpm MAXIMUM FEEDRATE: 535.906mm/min CUTTING DISTANCE: 78.05mm RAPID DISTANCE: 108.05mm ESTIMATED CYCLE TIME: 10s (0.2%) COOLANT: Flood	T10120 D10120 L10120 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 120mm FLUTES: 2 DESCRIPTION: Punta a forare M12 H8 VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM
Operation 45/63 DESCRIPTION: Holermaking2 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1253rpm MAXIMUM FEEDRATE: 576.357mm/min CUTTING DISTANCE: 97.56mm RAPID DISTANCE: 127.56mm ESTIMATED CYCLE TIME: 12s (0.3%) COOLANT: Flood	T10113 D10113 L10113 TYPE: drill DIAMETER: 20mm TIP ANGLE: 147° LENGTH: 110mm FLUTES: 2 DESCRIPTION: Punta a forare M20 H8 VENDOR: Sandvik PRODUCT: 860.1-2000-077A1-PM P1BM
Operation 46/63 DESCRIPTION: Holermaking3 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 5534rpm MAXIMUM FEEDRATE: 534.567mm/min CUTTING DISTANCE: 42.52mm RAPID DISTANCE: 252.52mm ESTIMATED CYCLE TIME: 8s (0.2%) COOLANT: Flood	T10014 D10014 L10014 TYPE: drill DIAMETER: 4.2mm TIP ANGLE: 118° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Punta a forare M4.2 H8 VENDOR: Mitsubishi PRODUCT: VSDD0420
Operation 47/63 DESCRIPTION: Holermaking4 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 5145rpm MAXIMUM FEEDRATE: 532.47mm/min CUTTING DISTANCE: 53.96mm RAPID DISTANCE: 83.96mm ESTIMATED CYCLE TIME: 7s (0.2%) COOLANT: Flood	T10007 D10007 L10007 TYPE: drill DIAMETER: 4.5mm TIP ANGLE: 118° LENGTH: 55mm FLUTES: 2 DESCRIPTION: Punta a forare M4.5 H8 VENDOR: Mitsubishi PRODUCT: VSDD0450
Operation 48/63 DESCRIPTION: Holermaking5 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1664rpm MAXIMUM FEEDRATE: 535.928mm/min CUTTING DISTANCE: 128.11mm RAPID DISTANCE: 158.11mm ESTIMATED CYCLE TIME: 16s (0.4%) COOLANT: Flood	T10118 D10118 L10118 TYPE: drill DIAMETER: 14mm TIP ANGLE: 147° LENGTH: 150mm FLUTES: 2 DESCRIPTION: Punta a forare M14 H8 VENDOR: Sandvik PRODUCT: 860.1-1400-115A1-PM P1BM
Operation 49/63 DESCRIPTION: Freeform STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.49mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5184mm/min CUTTING DISTANCE: 32.98mm RAPID DISTANCE: 46.54mm ESTIMATED CYCLE TIME: 1s (0%) COOLANT: Flood	T10001 D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730
Operation 50/63 DESCRIPTION: Freeform1 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.25mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5184mm/min CUTTING DISTANCE: 1762.99mm RAPID DISTANCE: 49.83mm ESTIMATED CYCLE TIME: 21s (0.5%) COOLANT: Flood	T10001 D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730
Operation 51/63 DESCRIPTION: Freeform3 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.25mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5184mm/min CUTTING DISTANCE: 93.78mm RAPID DISTANCE: 66.18mm ESTIMATED CYCLE TIME: 3s (0.1%) COOLANT: Flood	T10001 D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730
Operation 52/63 DESCRIPTION: Freeform4 STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.49mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5184mm/min CUTTING DISTANCE: 32.98mm RAPID DISTANCE: 46.54mm ESTIMATED CYCLE TIME: 1s (0%) COOLANT: Flood	T10001 D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730

Operation 53/63 DESCRIPTION: Freeform5 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.25mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5184mm/min CUTTING DISTANCE: 1795.78mm RAPID DISTANCE: 52.9mm ESTIMATED CYCLE TIME: 22s (0.5%) COOLANT: Flood	T10001 D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730
Operation 54/63 DESCRIPTION: Freeform6 STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.2mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 1173.42mm RAPID DISTANCE: 1589.49mm ESTIMATED CYCLE TIME: 1m:49s (2.5%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 55/63 DESCRIPTION: Freeform7 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.1mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 909.73mm RAPID DISTANCE: 173.93mm ESTIMATED CYCLE TIME: 56s (1.3%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 56/63 DESCRIPTION: Freeform8 STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.2mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 5521.18mm RAPID DISTANCE: 7777.93mm ESTIMATED CYCLE TIME: 6m:54s (9.5%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 57/63 DESCRIPTION: Freeform9 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.1mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 5210.08mm RAPID DISTANCE: 242.01mm ESTIMATED CYCLE TIME: 5m:3s (7%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 58/63 DESCRIPTION: Freeform10 STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.2mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 964.29mm RAPID DISTANCE: 1825.03mm ESTIMATED CYCLE TIME: 1m:19s (1.8%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 59/63 DESCRIPTION: Freeform11 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.1mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 915.53mm RAPID DISTANCE: 174.28mm ESTIMATED CYCLE TIME: 57s (1.3%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 60/63 DESCRIPTION: Chamfering WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2916mm/min CUTTING DISTANCE: 81.76mm RAPID DISTANCE: 62.38mm ESTIMATED CYCLE TIME: 3s (0.1%) COOLANT: Flood	T10013 D10013 L10013 TYPE: chamfer mill DIAMETER: 12mm TAPER ANGLE: 45° LENGTH: 50mm FLUTES: 6 DESCRIPTION: Fresa per smussature VENDOR: Sandvik PRODUCT: 1C050-0300-045-XB 1620
Operation 61/63 DESCRIPTION: Chamfering1 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2916mm/min CUTTING DISTANCE: 75.48mm RAPID DISTANCE: 62.38mm ESTIMATED CYCLE TIME: 3s (0.1%) COOLANT: Flood	T10013 D10013 L10013 TYPE: chamfer mill DIAMETER: 12mm TAPER ANGLE: 45° LENGTH: 50mm FLUTES: 6 DESCRIPTION: Fresa per smussature VENDOR: Sandvik PRODUCT: 1C050-0300-045-XB 1620
Operation 62/63 DESCRIPTION: Chamfering2 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2916mm/min CUTTING DISTANCE: 114.59mm RAPID DISTANCE: 32.38mm ESTIMATED CYCLE TIME: 3s (0.1%) COOLANT: Flood	T10013 D10013 L10013 TYPE: chamfer mill DIAMETER: 12mm TAPER ANGLE: 45° LENGTH: 50mm FLUTES: 6 DESCRIPTION: Fresa per smussature VENDOR: Sandvik PRODUCT: 1C050-0300-045-XB 1620

Operation 63/63
DESCRIPTION: Chamfering3
WCS: #0
TOLERANCE: 0.01mm
STOCK TO LEAVE: 0mm

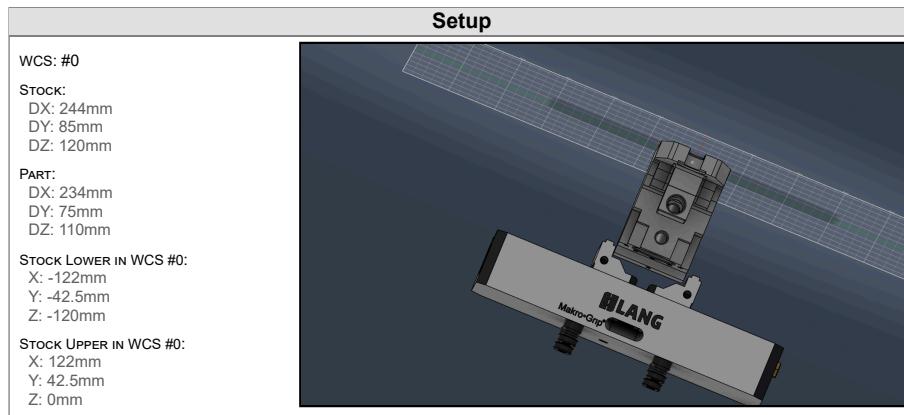
MAXIMUM SPINDLE SPEED: 8100rpm
MAXIMUM FEEDRATE: 2916mm/min
CUTTING DISTANCE: 101.08mm
RAPID DISTANCE: 37.9mm
ESTIMATED CYCLE TIME: 3s (0.1%)
COOLANT: Flood

T10013 D10013 L10013
TYPE: chamfer mill
DIAMETER: 12mm
TAPER ANGLE: 45°
LENGTH: 50mm
FLUTES: 6
DESCRIPTION: Fresa per smussature
VENDOR: Sandvik
PRODUCT: [1C050-0300-045-XB 1620](#)

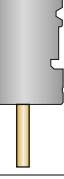
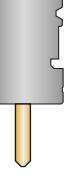
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Setup Sheet for Program 1002

JOB DESCRIPTION: AutoSetup 2
 DOCUMENT PATH: 0NC01_DFM_01 v2



Total	
NUMBER OF OPERATIONS: 26	
NUMBER OF TOOLS: 9	
TOOLS: T10001 T10002 T10003 T10006 T10013 T10110 T10112 T10114 T10120	
MAXIMUM FEEDRATE: 5184mm/min	
MAXIMUM SPINDLE SPEED: 8100rpm	
CUTTING DISTANCE: 25797.25mm	
RAPID DISTANCE: 46740.63mm	
ESTIMATED CYCLE TIME: 21m:45s	

Tools		
T10001 D10001 L10001		
TYPE: bullnose end mill	MAXIMUM FEED: 5184mm/min	HOLDER: BT40 - B4C4-1000
DIAMETER: 20mm	MAXIMUM SPINDLE SPEED: 8100rpm	
CORNER RADIUS: 3mm	CUTTING DISTANCE: 19864.48mm	
LENGTH: 80mm	RAPID DISTANCE: 30917.28mm	
FLUTES: 4	ESTIMATED CYCLE TIME: 11m:44s (53.9%)	
DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate		
VENDOR: Sandvik		
PRODUCT: 1K335-2000-300-XD 1730		
T10002 D10002 L10002		
TYPE: flat end mill	MAXIMUM FEED: 3012.053mm/min	HOLDER: BT40 - B4C4-1000
DIAMETER: 10mm	MAXIMUM SPINDLE SPEED: 8100rpm	
LENGTH: 50mm	CUTTING DISTANCE: 777.88mm	
FLUTES: 4	RAPID DISTANCE: 2065.13mm	
DESCRIPTION: Fresa integrale per tasche piccole	ESTIMATED CYCLE TIME: 40s (3.1%)	
VENDOR: Sandvik		
PRODUCT: 1K334-1000-100-XD 1730		
T10003 D10003 L10003		
TYPE: bullnose end mill	MAXIMUM FEED: 1704.805mm/min	HOLDER: BT40 - B4C4-1000
DIAMETER: 8mm	MAXIMUM SPINDLE SPEED: 8100rpm	
CORNER RADIUS: 0.5mm	CUTTING DISTANCE: 734.08mm	
LENGTH: 55mm	RAPID DISTANCE: 3340.57mm	
FLUTES: 4	ESTIMATED CYCLE TIME: 1m:6s (5.1%)	
DESCRIPTION: Fresa integrale per finitura raggi		
VENDOR: Sandvik		
PRODUCT: 1K377-0800-050-XD 1730		
T10006 D10006 L10006		
TYPE: drill	MAXIMUM FEED: 532.782mm/min	HOLDER: BT40 - B4C4-1000
DIAMETER: 5mm	MAXIMUM SPINDLE SPEED: 4633rpm	
TIP ANGLE: 118°	CUTTING DISTANCE: 194.01mm	
LENGTH: 70mm	RAPID DISTANCE: 393.02mm	
FLUTES: 2	ESTIMATED CYCLE TIME: 27s (2%)	
DESCRIPTION: Punta a forare M5 H8		
VENDOR: Mitsubishi		
PRODUCT: VSDD0500		
T10013 D10013 L10013		
TYPE: chamfer mill	MAXIMUM FEED: 2916mm/min	HOLDER: BT40 - B4C4-1000
DIAMETER: 12mm	MAXIMUM SPINDLE SPEED: 8100rpm	
TAPER ANGLE: 45°	CUTTING DISTANCE: 471.81mm	
LENGTH: 50mm	RAPID DISTANCE: 292.63mm	
FLUTES: 6	ESTIMATED CYCLE TIME: 15s (1.1%)	
DESCRIPTION: Fresa per smussature		
VENDOR: Sandvik		
PRODUCT: 1C050-0300-045-XB 1620		
T10110 D10110 L10110		
TYPE: flat end mill	MAXIMUM FEED: 4458.366mm/min	HOLDER: BT40 - B4C4-1000
DIAMETER: 20mm	MAXIMUM SPINDLE SPEED: 8100rpm	
LENGTH: 110mm	CUTTING DISTANCE: 3342.78mm	
FLUTES: 5	RAPID DISTANCE: 9219.4mm	
DESCRIPTION: Fresa integrale per particolari lunghi	ESTIMATED CYCLE TIME: 3m:29s (16%)	
VENDOR: Sandvik		
PRODUCT: 1K365-2000-XD 1730		

T10112 D10112 L10112

TYPE: bullnose end mill

DIAMETER: 10mm

CORNER RADIUS: 0.1mm

LENGTH: 80mm

FLUTES: 4

DESCRIPTION: Fresa integrale per tasche piccole distanti

VENDOR: Sandvik

PRODUCT: [R216.24-10050CCK22P 1620](#)

MAXIMUM FEED: 1620mm/min

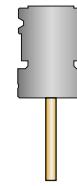
MAXIMUM SPINDLE SPEED: 8100rpm

CUTTING DISTANCE: 271.19mm

RAPID DISTANCE: 311.57mm

ESTIMATED CYCLE TIME: 17s (1.3%)

HOLDER: BT40 - B4C4-1000

**T10114 D10114 L10114**

TYPE: drill

DIAMETER: 3mm

TIP ANGLE: 118°

LENGTH: 50mm

FLUTES: 2

DESCRIPTION: Punta a forare M3 H8

VENDOR: Mitsubishi

PRODUCT: VSDD0300

MAXIMUM FEED: 528.409mm/min

MAXIMUM SPINDLE SPEED: 7658rpm

CUTTING DISTANCE: 13.9mm

RAPID DISTANCE: 43.9mm

ESTIMATED CYCLE TIME: 2s (0.2%)

HOLDER: BT40 - B4C4-1000

**T10120 D10120 L10120**

TYPE: drill

DIAMETER: 12mm

TIP ANGLE: 147°

LENGTH: 120mm

FLUTES: 2

DESCRIPTION: Punta a forare M12 H8

VENDOR: Sandvik

PRODUCT: [860.1-1200-098A1-PM P1BM](#)

MAXIMUM FEED: 535.906mm/min

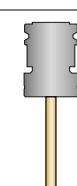
MAXIMUM SPINDLE SPEED: 1942rpm

CUTTING DISTANCE: 127.12mm

RAPID DISTANCE: 157.12mm

ESTIMATED CYCLE TIME: 16s (1.2%)

HOLDER: BT40 - B4C4-1000

**Operations**

Operation 1/26

DESCRIPTION: Roughing

STRATEGY: Adaptive

WCS: #0

TOLERANCE: 0.1mm

STOCK TO LEAVE: 0.25mm

MAXIMUM STEPDOWN: 19.95mm

OPTIMAL LOAD: 6.75mm

LOAD DEVIATION: 0.68mm

NOTES:

This roughing operation may lead to collisions with the shaft or holder, due to a known limitation in Fusion. Enabling Shaft & Holder might help but results vary. Please check the See details in <https://clouddnc.atlassian.net/wiki/x/AYCREG>

Operation 2/26

DESCRIPTION: Roughing1

STRATEGY: Adaptive

WCS: #0

TOLERANCE: 0.1mm

STOCK TO LEAVE: 0.25mm

MAXIMUM STEPDOWN: 19.95mm

OPTIMAL LOAD: 6.75mm

LOAD DEVIATION: 0.68mm

MAXIMUM SPINDLE SPEED: 8100rpm

MAXIMUM FEEDRATE: 4876.077mm/min

CUTTING DISTANCE: 19048.48mm

RAPID DISTANCE: 29528.42mm

ESTIMATED CYCLE TIME: 11m:13s (51.5%)

COOLANT: Flood

T10001 D10001 L10001

TYPE: bullnose end mill

DIAMETER: 20mm

CORNER RADIUS: 3mm

LENGTH: 80mm

FLUTES: 4

DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate

VENDOR: Sandvik

PRODUCT: [1K335-2000-300-XD 1730](#)**T10001 D10001 L10001**

TYPE: bullnose end mill

DIAMETER: 20mm

CORNER RADIUS: 3mm

LENGTH: 80mm

FLUTES: 4

DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate

VENDOR: Sandvik

PRODUCT: [1K335-2000-300-XD 1730](#)

Operation 3/26

DESCRIPTION: Roughing2

STRATEGY: Adaptive

WCS: #0

TOLERANCE: 0.1mm

STOCK TO LEAVE: 0.25mm

MAXIMUM STEPDOWN: 19.95mm

OPTIMAL LOAD: 6.75mm

LOAD DEVIATION: 0.68mm

MAXIMUM SPINDLE SPEED: 8100rpm

MAXIMUM FEEDRATE: 4876.077mm/min

CUTTING DISTANCE: 243.38mm

RAPID DISTANCE: 151.9mm

ESTIMATED CYCLE TIME: 5s (0.4%)

COOLANT: Flood

T10001 D10001 L10001

TYPE: bullnose end mill

DIAMETER: 20mm

CORNER RADIUS: 3mm

LENGTH: 80mm

FLUTES: 4

DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate

VENDOR: Sandvik

PRODUCT: [1K335-2000-300-XD 1730](#)

Operation 4/26

DESCRIPTION: Roughing3

STRATEGY: Adaptive

WCS: #0

TOLERANCE: 0.1mm

STOCK TO LEAVE: 0.25mm

MAXIMUM STEPDOWN: 19.95mm

OPTIMAL LOAD: 6.75mm

LOAD DEVIATION: 1.5mm

NOTES:

MAXIMUM SPINDLE SPEED: 8100rpm

MAXIMUM FEEDRATE: 4458.366mm/min

CUTTING DISTANCE: 336.61mm

RAPID DISTANCE: 1805.51mm

ESTIMATED CYCLE TIME: 26s (2%)

COOLANT: Flood

T10110 D10110 L10110

TYPE: flat end mill

DIAMETER: 20mm

LENGTH: 110mm

FLUTES: 5

DESCRIPTION: Fresa integrale per particolari lunghi

VENDOR: Sandvik

PRODUCT: [1K365-2000-XD 1730](#)

Operation 5/26

DESCRIPTION: Roughing4

STRATEGY: Adaptive

WCS: #0

TOLERANCE: 0.1mm

STOCK TO LEAVE: 0.25mm

MAXIMUM STEPDOWN: 3.5mm

OPTIMAL LOAD: 15mm

LOAD DEVIATION: 1.5mm

MAXIMUM SPINDLE SPEED: 8100rpm

MAXIMUM FEEDRATE: 4458.366mm/min

CUTTING DISTANCE: 130.47mm

RAPID DISTANCE: 455.25mm

ESTIMATED CYCLE TIME: 7s (0.6%)

COOLANT: Flood

T10110 D10110 L10110

TYPE: flat end mill

DIAMETER: 20mm

LENGTH: 110mm

FLUTES: 5

DESCRIPTION: Fresa integrale per particolari lunghi

VENDOR: Sandvik

PRODUCT: [1K365-2000-XD 1730](#)

Operation 6/26

DESCRIPTION: Roughing5

STRATEGY: Adaptive

WCS: #0

TOLERANCE: 0.1mm

STOCK TO LEAVE: 0.25mm

MAXIMUM STEPDOWN: 2.2mm

OPTIMAL LOAD: 7.5mm

LOAD DEVIATION: 0.75mm

MAXIMUM SPINDLE SPEED: 8100rpm

MAXIMUM FEEDRATE: 3012.053mm/min

CUTTING DISTANCE: 777.88mm

RAPID DISTANCE: 2065.13mm

ESTIMATED CYCLE TIME: 40s (3.1%)

COOLANT: Flood

T10002 D10002 L10002

TYPE: flat end mill

DIAMETER: 10mm

LENGTH: 50mm

FLUTES: 4

DESCRIPTION: Fresa integrale per tasche piccole

VENDOR: Sandvik

PRODUCT: [1K334-1000-100-XD 1730](#)

NOTES:

This roughing operation may lead to collisions with the shaft or holder, due to a known limitation in Fusion. Enabling Shaft & Holder might help but results vary. Please check the See details in <https://cloudnc.atlassian.net/wiki/x/AYCREg>

Operation 7/26

DESCRIPTION: Roughing6
STRATEGY: Adaptive
WCS: #0
TOLERANCE: 0.1mm
STOCK TO LEAVE: 0.25mm
MAXIMUM STEPDOWN: 0.8mm
OPTIMAL LOAD: 5.7mm
LOAD DEVIATION: 0.57mm

MAXIMUM SPINDLE SPEED: 8100rpm
MAXIMUM FEEDRATE: 1704.805mm/min
CUTTING DISTANCE: 202.74mm
RAPID DISTANCE: 594.4mm
ESTIMATED CYCLE TIME: 14s (1.1%)
COOLANT: Flood

T10003 D10003 L10003

TYPE: bullnose end mill
DIAMETER: 8mm
CORNER RADIUS: 0.5mm
LENGTH: 55mm
FLUTES: 4
DESCRIPTION: Fresa integrale per finitura raggi
VENDOR: Sandvik
PRODUCT: [1K377-0800-050-XD 1730](#)

Operation 8/26

DESCRIPTION: Roughing7
STRATEGY: Adaptive
WCS: #0
TOLERANCE: 0.1mm
STOCK TO LEAVE: 0.25mm
MAXIMUM STEPDOWN: 0.8mm
OPTIMAL LOAD: 5.7mm
LOAD DEVIATION: 0.57mm

MAXIMUM SPINDLE SPEED: 8100rpm
MAXIMUM FEEDRATE: 1704.805mm/min
CUTTING DISTANCE: 229.22mm
RAPID DISTANCE: 576.08mm
ESTIMATED CYCLE TIME: 15s (1.1%)
COOLANT: Flood

T10003 D10003 L10003

TYPE: bullnose end mill
DIAMETER: 8mm
CORNER RADIUS: 0.5mm
LENGTH: 55mm
FLUTES: 4
DESCRIPTION: Fresa integrale per finitura raggi
VENDOR: Sandvik
PRODUCT: [1K377-0800-050-XD 1730](#)

Operation 9/26

DESCRIPTION: Roughing8
STRATEGY: Adaptive
WCS: #0
TOLERANCE: 0.1mm
STOCK TO LEAVE: 0.25mm
MAXIMUM STEPDOWN: 0.8mm
OPTIMAL LOAD: 5.7mm
LOAD DEVIATION: 0.57mm

MAXIMUM SPINDLE SPEED: 8100rpm
MAXIMUM FEEDRATE: 1704.805mm/min
CUTTING DISTANCE: 302.13mm
RAPID DISTANCE: 2170.09mm
ESTIMATED CYCLE TIME: 37s (2.8%)
COOLANT: Flood

T10003 D10003 L10003

TYPE: bullnose end mill
DIAMETER: 8mm
CORNER RADIUS: 0.5mm
LENGTH: 55mm
FLUTES: 4
DESCRIPTION: Fresa integrale per finitura raggi
VENDOR: Sandvik
PRODUCT: [1K377-0800-050-XD 1730](#)

NOTES:

This roughing operation may lead to collisions with the shaft or holder, due to a known limitation in Fusion. Enabling Shaft & Holder might help but results vary. Please check the See details in <https://cloudnc.atlassian.net/wiki/x/AYCREg>

Operation 10/26

DESCRIPTION: Flat
WCS: #0
TOLERANCE: 0.01mm
STOCK TO LEAVE: 0.27mm/0mm
MAXIMUM STEPOVER: 14mm

MAXIMUM SPINDLE SPEED: 8100rpm
MAXIMUM FEEDRATE: 4050mm/min
CUTTING DISTANCE: 1207.48mm
RAPID DISTANCE: 1717.17mm
ESTIMATED CYCLE TIME: 48s (3.7%)
COOLANT: Flood

T10110 D10110 L10110

TYPE: flat end mill
DIAMETER: 20mm
LENGTH: 110mm
FLUTES: 5
DESCRIPTION: Fresa integrale per particolari lunghi
VENDOR: Sandvik
PRODUCT: [1K365-2000-XD 1730](#)

Operation 11/26

DESCRIPTION: Flat1
WCS: #0
TOLERANCE: 0.01mm
STOCK TO LEAVE: 0.27mm/0mm
MAXIMUM STEPOVER: 14mm

MAXIMUM SPINDLE SPEED: 8100rpm
MAXIMUM FEEDRATE: 4050mm/min
CUTTING DISTANCE: 535.86mm
RAPID DISTANCE: 2035.16mm
ESTIMATED CYCLE TIME: 43s (3.3%)
COOLANT: Flood

T10110 D10110 L10110

TYPE: flat end mill
DIAMETER: 20mm
LENGTH: 110mm
FLUTES: 5
DESCRIPTION: Fresa integrale per particolari lunghi
VENDOR: Sandvik
PRODUCT: [1K365-2000-XD 1730](#)

NOTES:

This flat finishing operation may not fully finish the surface. Please check the simulation.

Operation 12/26

DESCRIPTION: Flat2
WCS: #0
TOLERANCE: 0.01mm
STOCK TO LEAVE: 0.27mm/0mm
MAXIMUM STEPOVER: 14mm

MAXIMUM SPINDLE SPEED: 8100rpm
MAXIMUM FEEDRATE: 4050mm/min
CUTTING DISTANCE: 255.25mm
RAPID DISTANCE: 1759.23mm
ESTIMATED CYCLE TIME: 30s (2.3%)
COOLANT: Flood

T10110 D10110 L10110

TYPE: flat end mill
DIAMETER: 20mm
LENGTH: 110mm
FLUTES: 5
DESCRIPTION: Fresa integrale per particolari lunghi
VENDOR: Sandvik
PRODUCT: [1K365-2000-XD 1730](#)

NOTES:

This flat finishing operation may not fully finish the surface. Please check the simulation.

Operation 13/26

DESCRIPTION: Flat3
WCS: #0
TOLERANCE: 0.01mm
STOCK TO LEAVE: 0.27mm/0mm
MAXIMUM STEPOVER: 14mm

MAXIMUM SPINDLE SPEED: 8100rpm
MAXIMUM FEEDRATE: 4050mm/min
CUTTING DISTANCE: 202.28mm
RAPID DISTANCE: 298.96mm
ESTIMATED CYCLE TIME: 10s (0.8%)
COOLANT: Flood

T10110 D10110 L10110

TYPE: flat end mill
DIAMETER: 20mm
LENGTH: 110mm
FLUTES: 5
DESCRIPTION: Fresa integrale per particolari lunghi
VENDOR: Sandvik
PRODUCT: [1K365-2000-XD 1730](#)

NOTES:

This flat finishing operation may not fully finish the surface. Please check the simulation.

Operation 14/26

DESCRIPTION: Flat4
WCS: #0
TOLERANCE: 0.01mm
STOCK TO LEAVE: 0.27mm/0mm
MAXIMUM STEPOVER: 14mm

MAXIMUM SPINDLE SPEED: 8100rpm
MAXIMUM FEEDRATE: 4050mm/min
CUTTING DISTANCE: 201.34mm
RAPID DISTANCE: 299.93mm
ESTIMATED CYCLE TIME: 10s (0.8%)
COOLANT: Flood

T10110 D10110 L10110

TYPE: flat end mill
DIAMETER: 20mm
LENGTH: 110mm
FLUTES: 5
DESCRIPTION: Fresa integrale per particolari lunghi
VENDOR: Sandvik
PRODUCT: [1K365-2000-XD 1730](#)

NOTES:

This flat finishing operation may not fully finish the surface. Please check the simulation.

Operation 15/26	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3240mm/min CUTTING DISTANCE: 324.75mm RAPID DISTANCE: 947.61mm ESTIMATED CYCLE TIME: 18s (1.4%) COOLANT: Flood	T10001 D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730
Operation 16/26	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1620mm/min CUTTING DISTANCE: 122.29mm RAPID DISTANCE: 72.55mm ESTIMATED CYCLE TIME: 5s (0.4%) COOLANT: Flood	T10112 D10112 L10112 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216.24-10050CCK22P 1620
Notes:	This flat finishing operation may not fully finish the surface. Please check the simulation.	
Operation 17/26	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2001.934mm/min CUTTING DISTANCE: 103.82mm RAPID DISTANCE: 37.75mm ESTIMATED CYCLE TIME: 5s (0.4%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 18/26	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2001.934mm/min CUTTING DISTANCE: 100.81mm RAPID DISTANCE: 55.2mm ESTIMATED CYCLE TIME: 5s (0.4%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 19/26	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2001.934mm/min CUTTING DISTANCE: 151.82mm RAPID DISTANCE: 101.75mm ESTIMATED CYCLE TIME: 10s (0.8%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 20/26	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2001.934mm/min CUTTING DISTANCE: 117.05mm RAPID DISTANCE: 653.5mm ESTIMATED CYCLE TIME: 14s (1.1%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 21/26	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5184mm/min CUTTING DISTANCE: 72.58mm RAPID DISTANCE: 141.99mm ESTIMATED CYCLE TIME: 4s (0.3%) COOLANT: Flood	T10001 D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730
Operation 22/26	MAXIMUM SPINDLE SPEED: 1942rpm MAXIMUM FEEDRATE: 535.906mm/min CUTTING DISTANCE: 127.12mm RAPID DISTANCE: 157.12mm ESTIMATED CYCLE TIME: 16s (1.2%) COOLANT: Flood	T10120 D10120 L10120 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 120mm FLUTES: 2 DESCRIPTION: Punta a forare M12 H8 VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM
Operation 23/26	MAXIMUM SPINDLE SPEED: 4633rpm MAXIMUM FEEDRATE: 532.782mm/min CUTTING DISTANCE: 194.01mm RAPID DISTANCE: 393.02mm ESTIMATED CYCLE TIME: 27s (2%) COOLANT: Flood	T10006 D10006 L10006 TYPE: drill DIAMETER: 5mm TIP ANGLE: 118° LENGTH: 70mm FLUTES: 2 DESCRIPTION: Punta a forare M5 H8 VENDOR: Mitsubishi PRODUCT: VSDD0500
Operation 24/26	MAXIMUM SPINDLE SPEED: 7658rpm MAXIMUM FEEDRATE: 528.409mm/min CUTTING DISTANCE: 13.9mm RAPID DISTANCE: 43.9mm ESTIMATED CYCLE TIME: 2s (0.2%) COOLANT: Flood	T10114 D10114 L10114 TYPE: drill DIAMETER: 3mm TIP ANGLE: 118° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Punta a forare M3 H8 VENDOR: Mitsubishi PRODUCT: VSDD0300

Operation 25/26
DESCRIPTION: Freeform
STRATEGY: Contour
WCS: #0
TOLERANCE: 0.01mm
STOCK TO LEAVE: 0mm
MAXIMUM STEPDOWN: 0.08mm

MAXIMUM SPINDLE SPEED: 8100rpm
MAXIMUM FEEDRATE: 1265mm/min
CUTTING DISTANCE: 148.9mm
RAPID DISTANCE: 239.02mm
ESTIMATED CYCLE TIME: 11s (0.9%)
COOLANT: Flood

T10112 D10112 L10112
TYPE: bullnose end mill
DIAMETER: 10mm
CORNER RADIUS: 0.1mm
LENGTH: 80mm
FLUTES: 4
DESCRIPTION: Fresa integrale per tasche piccole distanti
VENDOR: Sandvik
PRODUCT: [R216.24-10050CCK22P_1620](#)

Operation 26/26
DESCRIPTION: Chamfering1
WCS: #0
TOLERANCE: 0.01mm
STOCK TO LEAVE: 0mm

MAXIMUM SPINDLE SPEED: 8100rpm
MAXIMUM FEEDRATE: 2916mm/min
CUTTING DISTANCE: 471.81mm
RAPID DISTANCE: 292.63mm
ESTIMATED CYCLE TIME: 15s (1.1%)
COOLANT: Flood

T10013 D10013 L10013
TYPE: chamfer mill
DIAMETER: 12mm
TAPER ANGLE: 45°
LENGTH: 50mm
FLUTES: 6
DESCRIPTION: Fresa per smussature
VENDOR: Sandvik
PRODUCT: [1C050-0300-045-XB_1620](#)

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