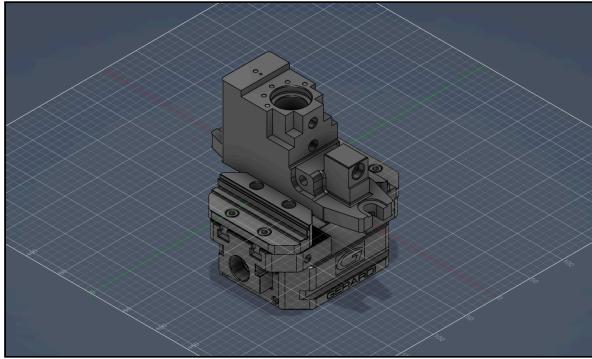
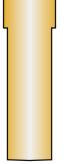
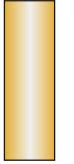


Setup Sheet for Program 1001

JOB DESCRIPTION: Setup1

DOCUMENT PATH: Modello Fusion Gruppo 2 v1

Setup		
WCS: #1 Stock: DX: 244mm DY: 85mm DZ: 120mm Part: DX: 234mm DY: 75mm DZ: 110mm Stock Lower in WCS #1: X: -244mm Y: 0mm Z: -120mm Stock Upper in WCS #1: X: 0mm Y: 85mm Z: 0mm		
Total		
NUMBER OF OPERATIONS: 17 NUMBER OF TOOLS: 14 TOOLS: T3 T4 T5 T11 T19 T31 T36 T37 T39 T44 T48 T51 T52 T53 MAXIMUM Z: 25mm MINIMUM Z: -70.59mm MAXIMUM FEEDRATE: 5000mm/min MAXIMUM SPINDLE SPEED: 8034rpm CUTTING DISTANCE: 6424.36mm RAPID DISTANCE: 2652.93mm ESTIMATED CYCLE TIME: 9m:56s		
Tools		
T3 D3 L3 TYPE: face mill DIAMETER: 60mm CORNER RADIUS: 0.3mm TAPER ANGLE: 35° LENGTH: 60mm FLUTES: 5 VENDOR: Sandvik PRODUCT: R365-063C6-S15M	MINIMUM Z: -4.4mm MAXIMUM FEED: 1633.991mm/min MAXIMUM SPINDLE SPEED: 1167rpm CUTTING DISTANCE: 1024.29mm RAPID DISTANCE: 0.4mm ESTIMATED CYCLE TIME: 38s (6.3%)	
T4 D4 L4 TYPE: flat end mill DIAMETER: 16mm LENGTH: 42mm FLUTES: 5 DESCRIPTION: Tasche VENDOR: Sandvik PRODUCT: 2N342-1600-PD	MINIMUM Z: -26mm MAXIMUM FEED: 986.736mm/min MAXIMUM SPINDLE SPEED: 4934rpm CUTTING DISTANCE: 790.09mm RAPID DISTANCE: 969.64mm ESTIMATED CYCLE TIME: 1m:16s (12.7%)	
T5 D5 L5 TYPE: flat end mill DIAMETER: 25mm LENGTH: 63mm FLUTES: 5 DESCRIPTION: Contornatura sotto VENDOR: Sandvik PRODUCT: 2N342-2500-PD	MINIMUM Z: -55mm MAXIMUM FEED: 1738.354mm/min MAXIMUM SPINDLE SPEED: 3132rpm CUTTING DISTANCE: 2771.85mm RAPID DISTANCE: 66.5mm ESTIMATED CYCLE TIME: 2m:26s (24.5%)	
T11 D11 L11 TYPE: drill DIAMETER: 34mm TIP ANGLE: 176° LENGTH: 130.37mm FLUTES: 2 DESCRIPTION: Pre foro 35 (H15 tolleranza) VENDOR: Sandvik PRODUCT: 880-D3400L40-03	MINIMUM Z: -70.59mm MAXIMUM FEED: 596.831mm/min MAXIMUM SPINDLE SPEED: 2387rpm CUTTING DISTANCE: 75.59mm RAPID DISTANCE: 115.59mm ESTIMATED CYCLE TIME: 9s (1.5%)	
T19 D19 L19 TYPE: face mill DIAMETER: 63mm CORNER RADIUS: 1mm TAPER ANGLE: 42° LENGTH: 50mm FLUTES: 5 DESCRIPTION: Finitura superiore S2 VENDOR: Sandvik PRODUCT: 745-063Q22-21H	MINIMUM Z: -5mm MAXIMUM FEED: 852.616mm/min MAXIMUM SPINDLE SPEED: 1137rpm CUTTING DISTANCE: 676.13mm RAPID DISTANCE: 27.4mm ESTIMATED CYCLE TIME: 48s (8%)	
T31 D31 L31 TYPE: flat end mill DIAMETER: 8mm LENGTH: 25.4mm FLUTES: 5 DESCRIPTION: tasche superiori 1 VENDOR: Sandvik PRODUCT: 2N342-0800-PD	MINIMUM Z: -25mm MAXIMUM FEED: 2954.314mm/min MAXIMUM SPINDLE SPEED: 7878rpm CUTTING DISTANCE: 319.53mm RAPID DISTANCE: 171.2mm ESTIMATED CYCLE TIME: 15s (2.6%)	

T36 D36 L36 TYPE: right hand tap DIAMETER: 4.2mm LENGTH: 30mm FLUTES: 3 DESCRIPTION: Maschio filetti M5 S1 VENDOR: Sandvik PRODUCT: T300-PM104DA-M5	MINIMUM Z: -20mm MAXIMUM FEED: 1624mm/min MAXIMUM SPINDLE SPEED: 2030rpm CUTTING DISTANCE: 60mm RAPID DISTANCE: 180mm ESTIMATED CYCLE TIME: 4s (0.7%)	
T37 D37 L37 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	MINIMUM Z: -32.25mm MAXIMUM FEED: 5000mm/min MAXIMUM SPINDLE SPEED: 5836rpm CUTTING DISTANCE: 287.37mm RAPID DISTANCE: 120.45mm ESTIMATED CYCLE TIME: 13s (2.1%)	
T39 D39 L39 TYPE: flat end mill DIAMETER: 12.7mm LENGTH: 37.1mm FLUTES: 5 DESCRIPTION: Spallamento fori VENDOR: Sandvik PRODUCT: 2N342-1270-PD	MINIMUM Z: -10mm MAXIMUM FEED: 864.7mm/min MAXIMUM SPINDLE SPEED: 7519rpm CUTTING DISTANCE: 110.02mm RAPID DISTANCE: 33.73mm ESTIMATED CYCLE TIME: 10s (1.6%)	
T44 D44 L44 TYPE: right hand tap DIAMETER: 5mm LENGTH: 50mm FLUTES: 3 DESCRIPTION: Filettatura foro M6x1 S2 VENDOR: Sandvik PRODUCT: T300-PM104DA-M6	MINIMUM Z: -42mm MAXIMUM FEED: 1440mm/min MAXIMUM SPINDLE SPEED: 1440rpm CUTTING DISTANCE: 29.5mm RAPID DISTANCE: 64.5mm ESTIMATED CYCLE TIME: 2s (0.3%)	
T48 D48 L48 TYPE: drill DIAMETER: 5mm TIP ANGLE: 147° LENGTH: 52mm FLUTES: 2 DESCRIPTION: Fori superiori 5mm VENDOR: Sandvik PRODUCT: 860.1-0500-037A1-PM	MINIMUM Z: -42mm MAXIMUM FEED: 2759.365mm/min MAXIMUM SPINDLE SPEED: 8021rpm CUTTING DISTANCE: 39mm RAPID DISTANCE: 47mm ESTIMATED CYCLE TIME: 1s (0.2%)	
T51 D51 L51 TYPE: drill DIAMETER: 4.2mm TIP ANGLE: 147° LENGTH: 30mm FLUTES: 2 DESCRIPTION: Prefori 4.2mm VENDOR: Sandvik PRODUCT: 860.1-0420-018A0-PM	MINIMUM Z: -20.62mm MAXIMUM FEED: 2490.396mm/min MAXIMUM SPINDLE SPEED: 8034rpm CUTTING DISTANCE: 31.24mm RAPID DISTANCE: 231.24mm ESTIMATED CYCLE TIME: 4s (0.6%)	
T52 D52 L52 TYPE: flat end mill DIAMETER: 10mm LENGTH: 36mm FLUTES: 4 DESCRIPTION: Tasca circolare S1 VENDOR: Sandvik PRODUCT: 1K344-1000-XD	MINIMUM Z: -32mm MAXIMUM FEED: 925.9mm/min MAXIMUM SPINDLE SPEED: 5730rpm CUTTING DISTANCE: 162.81mm RAPID DISTANCE: 574.35mm ESTIMATED CYCLE TIME: 17s (2.9%)	
T53 D53 L53 TYPE: drill DIAMETER: 4.5mm TIP ANGLE: 147° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Foro 4.5mm S1 profondo VENDOR: Sandvik PRODUCT: 860.1-0450-037A1-PM	MINIMUM Z: -50.92mm MAXIMUM FEED: 1238.933mm/min MAXIMUM SPINDLE SPEED: 7993rpm CUTTING DISTANCE: 46.92mm RAPID DISTANCE: 50.92mm ESTIMATED CYCLE TIME: 3s (0.5%)	

Operations

Operation 1/17 DESCRIPTION: spianatura inferiore (sgrossatura) STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 41.58mm	T3 D3 L3 TYPE: face mill DIAMETER: 60mm CORNER RADIUS: 0.3mm TAPER ANGLE: 35° MINIMUM Z: -4.4mm MAXIMUM SPINDLE SPEED: 1167rpm MAXIMUM FEEDRATE: 1633.991mm/min CUTTING DISTANCE: 1024.29mm RAPID DISTANCE: 0.4mm ESTIMATED CYCLE TIME: 38s (6.3%) COOLANT: Flood	
Operation 2/17 DESCRIPTION: spianatura inferiore (finitura) STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 42.7mm	T19 D19 L19 TYPE: face mill DIAMETER: 63mm CORNER RADIUS: 1mm TAPER ANGLE: 42° MINIMUM Z: -5mm MAXIMUM SPINDLE SPEED: 1137rpm MAXIMUM FEEDRATE: 852.616mm/min CUTTING DISTANCE: 676.13mm RAPID DISTANCE: 27.4mm ESTIMATED CYCLE TIME: 48s (8%) COOLANT: Flood	

Operation 3/17 DESCRIPTION: contornatura inferiore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 15mm MAXIMUM STEPOVER: 23.75mm	MAXIMUM Z: 8mm MINIMUM Z: -55mm MAXIMUM SPINDLE SPEED: 3132rpm MAXIMUM FEEDRATE: 1738.354mm/min CUTTING DISTANCE: 2771.85mm RAPID DISTANCE: 66.5mm ESTIMATED CYCLE TIME: 2m:26s (24.5%) COOLANT: Flood	T5 D5 L5 TYPE: flat end mill DIAMETER: 25mm LENGTH: 63mm FLUTES: 5 DESCRIPTION: Contornatura sotto VENDOR: Sandvik PRODUCT: 2N342-2500-PD	
Operation 4/17 DESCRIPTION: rifinitura contorno inferiore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 15mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM Z: 15mm MINIMUM Z: -25mm MAXIMUM SPINDLE SPEED: 7878rpm MAXIMUM FEEDRATE: 2954.314mm/min CUTTING DISTANCE: 319.53mm RAPID DISTANCE: 171.2mm ESTIMATED CYCLE TIME: 15s (2.6%) COOLANT: Flood	T31 D31 L31 TYPE: flat end mill DIAMETER: 8mm LENGTH: 25.4mm FLUTES: 5 DESCRIPTION: tasche superiori 1 VENDOR: Sandvik PRODUCT: 2N342-0800-PD	
Operation 5/17 DESCRIPTION: tasche inferiori 16mm STRATEGY: Slot WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 8mm	MAXIMUM Z: 10mm MINIMUM Z: -10mm MAXIMUM SPINDLE SPEED: 4934rpm MAXIMUM FEEDRATE: 986.736mm/min CUTTING DISTANCE: 209.31mm RAPID DISTANCE: 356.18mm ESTIMATED CYCLE TIME: 21s (3.6%) COOLANT: Flood	T4 D4 L4 TYPE: flat end mill DIAMETER: 16mm LENGTH: 42mm FLUTES: 5 DESCRIPTION: Tasche VENDOR: Sandvik PRODUCT: 2N342-1600-PD	
Operation 6/17 DESCRIPTION: tasche inferiori 17mm STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 9.6mm	MAXIMUM Z: 15mm MINIMUM Z: -26mm MAXIMUM SPINDLE SPEED: 4934rpm MAXIMUM FEEDRATE: 986.736mm/min CUTTING DISTANCE: 580.78mm RAPID DISTANCE: 613.45mm ESTIMATED CYCLE TIME: 54s (9.1%) COOLANT: Flood	T4 D4 L4 TYPE: flat end mill DIAMETER: 16mm LENGTH: 42mm FLUTES: 5 DESCRIPTION: Tasche VENDOR: Sandvik PRODUCT: 2N342-1600-PD	
Operation 7/17 DESCRIPTION: preforo 34x65 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM Z: 25mm MINIMUM Z: -70.59mm MAXIMUM SPINDLE SPEED: 2387rpm MAXIMUM FEEDRATE: 596.831mm/min CUTTING DISTANCE: 75.59mm RAPID DISTANCE: 115.59mm ESTIMATED CYCLE TIME: 9s (1.5%) COOLANT: Air through tool	T11 D11 L11 TYPE: drill DIAMETER: 34mm TIFF ANGLE: 176° LENGTH: 130.37mm FLUTES: 2 DESCRIPTION: Pre foro 35 (H15 tolleranza) VENDOR: Sandvik PRODUCT: 880-D3400L40-03	
Operation 8/17 DESCRIPTION: spallamento 40mm STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 12.06mm	MAXIMUM Z: 15mm MINIMUM Z: -10mm MAXIMUM SPINDLE SPEED: 7519rpm MAXIMUM FEEDRATE: 864.7mm/min CUTTING DISTANCE: 110.02mm RAPID DISTANCE: 33.73mm ESTIMATED CYCLE TIME: 10s (1.6%) COOLANT: Flood	T39 D39 L39 TYPE: flat end mill DIAMETER: 12.7mm LENGTH: 37.1mm FLUTES: 5 DESCRIPTION: Spallamento fori VENDOR: Sandvik PRODUCT: 2N342-1270-PD	
Operation 9/17 DESCRIPTION: foro 4.2x10 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM Z: 5mm MINIMUM Z: -20.62mm MAXIMUM SPINDLE SPEED: 8034rpm MAXIMUM FEEDRATE: 2490.396mm/min CUTTING DISTANCE: 31.24mm RAPID DISTANCE: 231.24mm ESTIMATED CYCLE TIME: 4s (0.6%) COOLANT: Flood	T51 D51 L51 TYPE: drill DIAMETER: 4.2mm TIFF ANGLE: 147° LENGTH: 30mm FLUTES: 2 DESCRIPTION: Prefori 4.2mm VENDOR: Sandvik PRODUCT: 860.1-0420-018A0-PM	
Operation 10/17 DESCRIPTION: filetto 4.2x10 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM Z: 0mm MINIMUM Z: -20mm MAXIMUM SPINDLE SPEED: 2030rpm MAXIMUM FEEDRATE: 1624mm/min CUTTING DISTANCE: 60mm RAPID DISTANCE: 180mm ESTIMATED CYCLE TIME: 4s (0.7%) COOLANT: Flood	T36 D36 L36 TYPE: right hand tap DIAMETER: 4.2mm LENGTH: 30mm FLUTES: 3 DESCRIPTION: Maschio filetti M5 S1 VENDOR: Sandvik PRODUCT: T300-PM104DA-M5	
Operation 11/17 DESCRIPTION: tasca circolare 12x27 STRATEGY: Circular WCS: #1 TOLERANCE: 0mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 1.93mm	MAXIMUM Z: 5mm MINIMUM Z: -32mm MAXIMUM SPINDLE SPEED: 5730rpm MAXIMUM FEEDRATE: 925.9mm/min CUTTING DISTANCE: 162.81mm RAPID DISTANCE: 574.35mm ESTIMATED CYCLE TIME: 17s (2.9%) COOLANT: Flood	T52 D52 L52 TYPE: flat end mill DIAMETER: 10mm LENGTH: 36mm FLUTES: 4 DESCRIPTION: Tasca circolare S1 VENDOR: Sandvik PRODUCT: 1K344-1000-XD	
Operation 12/17 DESCRIPTION: foro 4.5x18 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM Z: -2mm MINIMUM Z: -50.92mm MAXIMUM SPINDLE SPEED: 7993rpm MAXIMUM FEEDRATE: 1238.933mm/min CUTTING DISTANCE: 46.92mm RAPID DISTANCE: 50.92mm ESTIMATED CYCLE TIME: 3s (0.5%) COOLANT: Flood	T53 D53 L53 TYPE: drill DIAMETER: 4.5mm TIFF ANGLE: 147° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Foro 4.5mm S1 profondo VENDOR: Sandvik PRODUCT: 860.1-0450-037A1-PM	

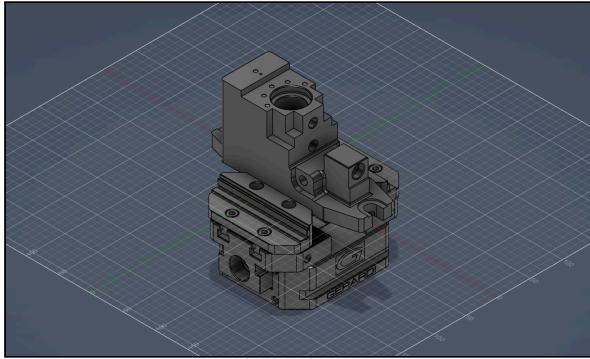
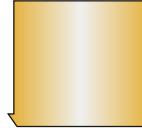
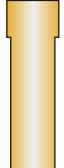
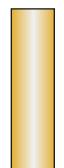
Operation 13/17 DESCRIPTION: foro 5x10 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM Z: 1mm MINIMUM Z: -42mm MAXIMUM SPINDLE SPEED: 8021rpm MAXIMUM FEEDRATE: 2759.365mm/min CUTTING DISTANCE: 39mm RAPID DISTANCE: 47mm ESTIMATED CYCLE TIME: 1s (0.2%) COOLANT: Flood	T48 D48 L48 TYPE: drill DIAMETER: 5mm TI P ANGLE: 147° LENGTH: 52mm FLUTES: 2 DESCRIPTION: Fori superiori 5mm VENDOR: Sandvik PRODUCT: 860.1-0500-037A1-PM	
Operation 14/17 DESCRIPTION: filetto 5x10 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM Z: 5mm MINIMUM Z: -42mm MAXIMUM SPINDLE SPEED: 1440rpm MAXIMUM FEEDRATE: 1440mm/min CUTTING DISTANCE: 29.5mm RAPID DISTANCE: 64.5mm ESTIMATED CYCLE TIME: 2s (0.3%) COOLANT: Flood	T44 D44 L44 TYPE: right hand tap DIAMETER: 5mm LENGTH: 50mm FLUTES: 3 DESCRIPTION: Filettatura foro M6x1 S2 VENDOR: Sandvik PRODUCT: T300-PM104DA-M6	
Operation 15/17 DESCRIPTION: smusso maggiore S1 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM Z: 15mm MINIMUM Z: -6mm MAXIMUM SPINDLE SPEED: 5836rpm MAXIMUM FEEDRATE: 1960.789mm/min CUTTING DISTANCE: 137.89mm RAPID DISTANCE: 30.4mm ESTIMATED CYCLE TIME: 6s (1%) COOLANT: Flood	T37 D37 L37 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	
Operation 16/17 DESCRIPTION: smusso minore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM Z: 15mm MINIMUM Z: -11mm MAXIMUM SPINDLE SPEED: 3550rpm MAXIMUM FEEDRATE: 5000mm/min CUTTING DISTANCE: 127.18mm RAPID DISTANCE: 35.4mm ESTIMATED CYCLE TIME: 5s (0.8%) COOLANT: Flood	T37 D37 L37 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	
Operation 17/17 DESCRIPTION: smusso foro 5x10 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM Z: -2mm MINIMUM Z: -32.25mm MAXIMUM SPINDLE SPEED: 5836rpm MAXIMUM FEEDRATE: 1960.789mm/min CUTTING DISTANCE: 22.3mm RAPID DISTANCE: 54.65mm ESTIMATED CYCLE TIME: 2s (0.3%) COOLANT: Flood	T37 D37 L37 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	

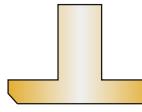
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Setup Sheet for Program 1002

JOB DESCRIPTION: Setup2

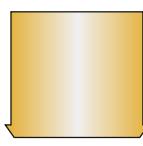
DOCUMENT PATH: Modello Fusion Gruppo 2 v1

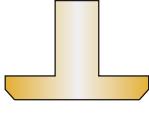
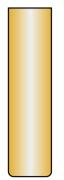
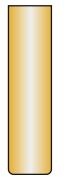
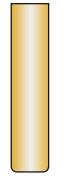
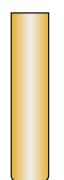
Setup	
<p>WCS: #1</p> <p>STOCK: DX: 244mm DY: 85mm DZ: 120mm</p> <p>PART: DX: 234mm DY: 75mm DZ: 110mm</p> <p>STOCK LOWER IN WCS #1: X: 0mm Y: 0mm Z: -120mm</p> <p>STOCK UPPER IN WCS #1: X: 244mm Y: 85mm Z: 0mm</p>	
Total	
<p>NUMBER OF OPERATIONS: 60</p> <p>NUMBER OF TOOLS: 25</p> <p>TOOLS: T3 T4 T5 T11 T15 T16 T19 T20 T22 T23 T24 T25 T26 T27 T28 T32 T37 T39 T41 T42 T44 T46 T47 T48 T50</p> <p>MAXIMUM FEEDRATE: 2992.988mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8021rpm</p> <p>CUTTING DISTANCE: 17172.9mm</p> <p>RAPID DISTANCE: 4867.4mm</p> <p>ESTIMATED CYCLE TIME: 27m:5s</p>	
Tools	
<p>T3 D3 L3</p> <p>TYPE: face mill DIAMETER: 60mm CORNER RADIUS: 0.3mm TAPER ANGLE: 35° LENGTH: 60mm FLUTES: 5 VENDOR: Sandvik PRODUCT: R365-063C6-S15M</p>	
<p>T4 D4 L4</p> <p>TYPE: flat end mill DIAMETER: 16mm LENGTH: 42mm FLUTES: 5 DESCRIPTION: Tasche VENDOR: Sandvik PRODUCT: 2N342-1600-PD</p>	
<p>T5 D5 L5</p> <p>TYPE: flat end mill DIAMETER: 25mm LENGTH: 63mm FLUTES: 5 DESCRIPTION: Contornatura sotto VENDOR: Sandvik PRODUCT: 2N342-2500-PD</p>	
<p>T11 D11 L11</p> <p>TYPE: drill DIAMETER: 34mm TIP ANGLE: 176° LENGTH: 130.37mm FLUTES: 2 DESCRIPTION: Pre foro 35 (H15 tolleranza) VENDOR: Sandvik PRODUCT: 880-D3400L40-03</p>	
<p>T15 D15 L15</p> <p>TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P</p>	
<p>T16 D16 L16</p> <p>TYPE: boring bar DIAMETER: 35mm LENGTH: 99mm FLUTES: 1 DESCRIPTION: barenatura 35 mm VENDOR: Sandvik PRODUCT: 825-45TC09-C3</p>	

T19 D19 L19 TYPE: face mill DIAMETER: 63mm CORNER RADIUS: 1mm TAPER ANGLE: 42° LENGTH: 50mm FLUTES: 5 DESCRIPTION: Finitura superiore S2 VENDOR: Sandvik PRODUCT: 745-063Q22-21H	MAXIMUM FEED: 1650mm/min MAXIMUM SPINDLE SPEED: 1500rpm CUTTING DISTANCE: 160.95mm RAPID DISTANCE: 17.4mm ESTIMATED CYCLE TIME: 6s (0.4%)	
T20 D20 L20 TYPE: flat end mill DIAMETER: 12mm LENGTH: 36mm FLUTES: 5 DESCRIPTION: Tasca piccola S2 in basso VENDOR: Sandvik PRODUCT: 2N342-1200-PD	MAXIMUM FEED: 798.954mm/min MAXIMUM SPINDLE SPEED: 6658rpm CUTTING DISTANCE: 141mm RAPID DISTANCE: 20.6mm ESTIMATED CYCLE TIME: 13s (0.8%)	
T22 D22 L22 TYPE: drill DIAMETER: 3mm TIP ANGLE: 140° LENGTH: 33mm FLUTES: 2 DESCRIPTION: Fori sup 3x8 mm VENDOR: Sandvik PRODUCT: 862.1-3000-270A0-GM	MAXIMUM FEED: 530.516mm/min MAXIMUM SPINDLE SPEED: 5305rpm CUTTING DISTANCE: 13mm RAPID DISTANCE: 23mm ESTIMATED CYCLE TIME: 2s (0.1%)	
T23 D23 L23 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 55mm FLUTES: 2 DESCRIPTION: Foratura laterale 12mm VENDOR: Sandvik PRODUCT: 860.1-1200-037A1-PM	MAXIMUM FEED: 2472.074mm/min MAXIMUM SPINDLE SPEED: 4536rpm CUTTING DISTANCE: 104.12mm RAPID DISTANCE: 182.12mm ESTIMATED CYCLE TIME: 5s (0.3%)	
T24 D24 L24 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 90mm FLUTES: 5 DESCRIPTION: Contornatura blocco sup S2 VENDOR: Sandvik PRODUCT: 1K365-2000-300-XD	MAXIMUM FEED: 1803.934mm/min MAXIMUM SPINDLE SPEED: 4631rpm CUTTING DISTANCE: 3430.68mm RAPID DISTANCE: 710.25mm ESTIMATED CYCLE TIME: 3m:4s (11.3%)	
T25 D25 L25 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 60mm FLUTES: 5 VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD	MAXIMUM FEED: 1509.983mm/min MAXIMUM SPINDLE SPEED: 4027rpm CUTTING DISTANCE: 1663.2mm RAPID DISTANCE: 226.5mm ESTIMATED CYCLE TIME: 1m:34s (5.8%)	
T26 D26 L26 TYPE: drill DIAMETER: 14mm TIP ANGLE: 147° LENGTH: 134mm FLUTES: 2 DESCRIPTION: Foro da 14mm VENDOR: Sandvik PRODUCT: 860.1-1400-115A1-PM	MAXIMUM FEED: 1627.2mm/min MAXIMUM SPINDLE SPEED: 2865rpm CUTTING DISTANCE: 25.03mm RAPID DISTANCE: 173.03mm ESTIMATED CYCLE TIME: 3s (0.2%)	
T27 D27 L27 TYPE: drill DIAMETER: 20mm TIP ANGLE: 147° LENGTH: 105mm FLUTES: 2 DESCRIPTION: Foro da 20x70 VENDOR: Sandvik PRODUCT: 860.1-2000-077A1-PM	MAXIMUM FEED: 1648.845mm/min MAXIMUM SPINDLE SPEED: 2355rpm CUTTING DISTANCE: 62.6mm RAPID DISTANCE: 80.6mm ESTIMATED CYCLE TIME: 3s (0.2%)	
T28 D28 L28 TYPE: drill DIAMETER: 16mm TIP ANGLE: 147° LENGTH: 90mm FLUTES: 2 DESCRIPTION: Foro da 14mm VENDOR: Sandvik PRODUCT: 860.1-1600-044A1-PM	MAXIMUM FEED: 1401.2mm/min MAXIMUM SPINDLE SPEED: 2467rpm CUTTING DISTANCE: 47.37mm RAPID DISTANCE: 73.37mm ESTIMATED CYCLE TIME: 3s (0.2%)	
T32 D32 L32 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	MAXIMUM FEED: 2992.988mm/min MAXIMUM SPINDLE SPEED: 7918rpm CUTTING DISTANCE: 1275.29mm RAPID DISTANCE: 751.02mm ESTIMATED CYCLE TIME: 1m:25s (5.2%)	

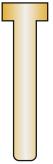
T37 D37 L37 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	MAXIMUM FEED: 1960.789mm/min MAXIMUM SPINDLE SPEED: 5836rpm CUTTING DISTANCE: 761.85mm RAPID DISTANCE: 335.28mm ESTIMATED CYCLE TIME: 41s (2.5%)	
T39 D39 L39 TYPE: flat end mill DIAMETER: 12.7mm LENGTH: 37.1mm FLUTES: 5 DESCRIPTION: Spallamento fori VENDOR: Sandvik PRODUCT: 2N342-1270-PD	MAXIMUM FEED: 864.7mm/min MAXIMUM SPINDLE SPEED: 7519rpm CUTTING DISTANCE: 181.81mm RAPID DISTANCE: 152.19mm ESTIMATED CYCLE TIME: 20s (1.2%)	
T41 D41 L41 TYPE: slot mill DIAMETER: 9.7mm CORNER RADIUS: 0.2mm LENGTH: 41.5mm FLUTES: 3 DESCRIPTION: Slot S2 VENDOR: Sandvik PRODUCT: 327R06-10 15002-GM	MAXIMUM FEED: 758.529mm/min MAXIMUM SPINDLE SPEED: 7548rpm CUTTING DISTANCE: 444.17mm RAPID DISTANCE: 128.77mm ESTIMATED CYCLE TIME: 37s (2.3%)	
T42 D42 L42 TYPE: slot mill DIAMETER: 10mm LENGTH: 40mm FLUTES: 7 DESCRIPTION: Prova 2 S2 contour	MAXIMUM FEED: 1000mm/min MAXIMUM SPINDLE SPEED: 5000rpm CUTTING DISTANCE: 79.4mm RAPID DISTANCE: 56.9mm ESTIMATED CYCLE TIME: 5s (0.3%)	
T44 D44 L44 TYPE: right hand tap DIAMETER: 5mm LENGTH: 50mm FLUTES: 3 DESCRIPTION: Filettatura foro M6x1 S2 VENDOR: Sandvik PRODUCT: T300-PM104DA-M6	MAXIMUM FEED: 1440mm/min MAXIMUM SPINDLE SPEED: 1440rpm CUTTING DISTANCE: 286.98mm RAPID DISTANCE: 160.56mm ESTIMATED CYCLE TIME: 14s (0.9%)	
T46 D46 L46 TYPE: drill DIAMETER: 18mm TIP ANGLE: 147° LENGTH: 80mm FLUTES: 2 DESCRIPTION: allargatura foro corpo centrale VENDOR: Sandvik PRODUCT: 860.1-1800-050A1-PM	MAXIMUM FEED: 1359.537mm/min MAXIMUM SPINDLE SPEED: 2193rpm CUTTING DISTANCE: 14.67mm RAPID DISTANCE: 36.67mm ESTIMATED CYCLE TIME: 1s (0.1%)	
T47 D47 L47 TYPE: bullnose end mill DIAMETER: 14mm CORNER RADIUS: 3mm LENGTH: 70mm FLUTES: 4 DESCRIPTION: Contour sm con raggi S2 VENDOR: Sandvik PRODUCT: R216.24-14050GAK26P	MAXIMUM FEED: 682.093mm/min MAXIMUM SPINDLE SPEED: 2274rpm CUTTING DISTANCE: 156.73mm RAPID DISTANCE: 63.6mm ESTIMATED CYCLE TIME: 19s (1.2%)	
T48 D48 L48 TYPE: drill DIAMETER: 5mm TIP ANGLE: 147° LENGTH: 52mm FLUTES: 2 DESCRIPTION: Fori superiori 5mm VENDOR: Sandvik PRODUCT: 860.1-0500-037A1-PM	MAXIMUM FEED: 2759.365mm/min MAXIMUM SPINDLE SPEED: 8021rpm CUTTING DISTANCE: 147.93mm RAPID DISTANCE: 427.52mm ESTIMATED CYCLE TIME: 8s (0.5%)	
T50 D50 L50 TYPE: bullnose end mill DIAMETER: 3.17mm CORNER RADIUS: 0.79mm LENGTH: 22mm FLUTES: 4 DESCRIPTION: tasche superiori 34 VENDOR: Sandvik PRODUCT: RA216.24-0830BAK02G	MAXIMUM FEED: 417.061mm/min MAXIMUM SPINDLE SPEED: 8020rpm CUTTING DISTANCE: 323.88mm RAPID DISTANCE: 191.66mm ESTIMATED CYCLE TIME: 51s (3.2%)	

Operations

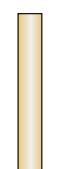
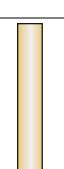
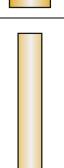
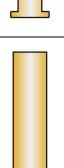
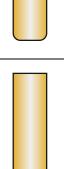
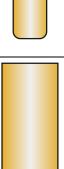
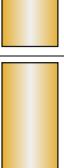
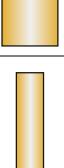
Operation 1/60 DESCRIPTION: spianatura superiore(sgrossatura) STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 41.58mm	MAXIMUM SPINDLE SPEED: 1080rpm MAXIMUM FEEDRATE: 1250mm/min CUTTING DISTANCE: 1027.79mm RAPID DISTANCE: 3.9mm ESTIMATED CYCLE TIME: 50s (3.1%) COOLANT: Flood	T3 D3 L3 TYPE: face mill DIAMETER: 60mm CORNER RADIUS: 0.3mm TAPER ANGLE: 35° LENGTH: 60mm FLUTES: 5 VENDOR: Sandvik PRODUCT: R365-063C6-S15M	
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Operation 2/60 DESCRIPTION: spianatura superiore(finitura) STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 42.7mm	MAXIMUM SPINDLE SPEED: 1500rpm MAXIMUM FEEDRATE: 1650mm/min CUTTING DISTANCE: 160.95mm RAPID DISTANCE: 17.4mm ESTIMATED CYCLE TIME: 6s (0.4%) COOLANT: Flood	T19 D19 L19 TYPE: face mill DIAMETER: 63mm CORNER RADIUS: 1mm TAPER ANGLE: 42° LENGTH: 50mm FLUTES: 5 DESCRIPTION: Finitura superiore S2 VENDOR: Sandvik PRODUCT: 745-063Q22-21H	
Operation 3/60 DESCRIPTION: spianatura superiore 2 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 11.2mm	MAXIMUM SPINDLE SPEED: 4934rpm MAXIMUM FEEDRATE: 986.736mm/min CUTTING DISTANCE: 1929.3mm RAPID DISTANCE: 22.5mm ESTIMATED CYCLE TIME: 1m:58s (7.3%) COOLANT: Flood	T4 D4 L4 TYPE: flat end mill DIAMETER: 16mm LENGTH: 42mm FLUTES: 5 DESCRIPTION: Tasche VENDOR: Sandvik PRODUCT: 2N342-1600-PD	
Operation 4/60 DESCRIPTION: spallamento posteriore STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPDOWN: 27mm MAXIMUM STEPOVER: 13.3mm	MAXIMUM SPINDLE SPEED: 2610rpm MAXIMUM FEEDRATE: 1017.955mm/min CUTTING DISTANCE: 1494.77mm RAPID DISTANCE: 303.42mm ESTIMATED CYCLE TIME: 1m:55s (7.1%) COOLANT: Flood	T15 D15 L15 TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P	
Operation 5/60 DESCRIPTION: spallamento posteriore piccolo STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 7.2mm	MAXIMUM SPINDLE SPEED: 5305rpm MAXIMUM FEEDRATE: 636.354mm/min CUTTING DISTANCE: 72mm RAPID DISTANCE: 7.8mm ESTIMATED CYCLE TIME: 8s (0.5%) COOLANT: Flood	T20 D20 L20 TYPE: flat end mill DIAMETER: 12mm LENGTH: 36mm FLUTES: 5 DESCRIPTION: Tasca piccola S2 in basso VENDOR: Sandvik PRODUCT: 2N342-1200-PD	
Operation 6/60 DESCRIPTION: spianatura superiore 3 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPDOWN: 27mm MAXIMUM STEPOVER: 13.3mm	MAXIMUM SPINDLE SPEED: 2610rpm MAXIMUM FEEDRATE: 1017.955mm/min CUTTING DISTANCE: 1858.47mm RAPID DISTANCE: 134.44mm ESTIMATED CYCLE TIME: 1m:56s (7.1%) COOLANT: Flood	T15 D15 L15 TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P	
Operation 7/60 DESCRIPTION: contornatura 1 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 23.75mm	MAXIMUM SPINDLE SPEED: 3132rpm MAXIMUM FEEDRATE: 1738.354mm/min CUTTING DISTANCE: 320.81mm RAPID DISTANCE: 20mm ESTIMATED CYCLE TIME: 13s (0.8%) COOLANT: Flood	T5 D5 L5 TYPE: flat end mill DIAMETER: 25mm LENGTH: 63mm FLUTES: 5 DESCRIPTION: Contornatura sotto VENDOR: Sandvik PRODUCT: 2N342-2500-PD	
Operation 8/60 DESCRIPTION: contornatura 2 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 11.5mm MAXIMUM STEPOVER: 13.3mm	MAXIMUM SPINDLE SPEED: 4631rpm MAXIMUM FEEDRATE: 1803.934mm/min CUTTING DISTANCE: 2855.04mm RAPID DISTANCE: 253.25mm ESTIMATED CYCLE TIME: 2m:11s (8.1%) COOLANT: Flood	T24 D24 L24 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 90mm FLUTES: 5 DESCRIPTION: Contornatura blocco sup S2 VENDOR: Sandvik PRODUCT: 1K365-2000-300-XD	
Operation 9/60 DESCRIPTION: rifinitura contornatura 2 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 40.5mm MAXIMUM STEPOVER: 13.3mm	MAXIMUM SPINDLE SPEED: 4631rpm MAXIMUM FEEDRATE: 1803.934mm/min CUTTING DISTANCE: 575.65mm RAPID DISTANCE: 457mm ESTIMATED CYCLE TIME: 53s (3.3%) COOLANT: Flood	T24 D24 L24 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 90mm FLUTES: 5 DESCRIPTION: Contornatura blocco sup S2 VENDOR: Sandvik PRODUCT: 1K365-2000-300-XD	
Operation 10/60 DESCRIPTION: spianatura 2.1 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPDOWN: 22mm MAXIMUM STEPOVER: 9.8mm	MAXIMUM SPINDLE SPEED: 4027rpm MAXIMUM FEEDRATE: 1509.983mm/min CUTTING DISTANCE: 240.54mm RAPID DISTANCE: 45mm ESTIMATED CYCLE TIME: 14s (0.8%) COOLANT: Flood	T25 D25 L25 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 60mm FLUTES: 5 DESCRIPTION: Contornatura blocco sup S2 VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD	
Operation 11/60 DESCRIPTION: contornatura 3 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 15mm MAXIMUM STEPOVER: 13.3mm	MAXIMUM SPINDLE SPEED: 4027rpm MAXIMUM FEEDRATE: 1509.983mm/min CUTTING DISTANCE: 1037.69mm RAPID DISTANCE: 87.5mm ESTIMATED CYCLE TIME: 53s (3.3%) COOLANT: Flood	T25 D25 L25 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 60mm FLUTES: 5 DESCRIPTION: Contornatura blocco sup S2 VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD	
Operation 12/60 DESCRIPTION: tasche superiori 1.1 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm/0.5mm MAXIMUM STEPDOWN: 11.5mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 203.97mm RAPID DISTANCE: 84.48mm ESTIMATED CYCLE TIME: 12s (0.7%) COOLANT: Flood	T32 D32 L32 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	

Operation 13/60 DESCRIPTION: tasche superiori 1.2 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm/0.1mm MAXIMUM STEP OVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 92.01mm RAPID DISTANCE: 47.1mm ESTIMATED CYCLE TIME: 7s (0.4%) COOLANT: Flood	T32 D32 L32 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 14/60 DESCRIPTION: tasche superiori 1.3 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm/0.5mm MAXIMUM STEP OVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 63.33mm RAPID DISTANCE: 35.7mm ESTIMATED CYCLE TIME: 4s (0.3%) COOLANT: Flood	T32 D32 L32 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 15/60 DESCRIPTION: tasche superiori 1.4 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm/0.1mm MAXIMUM STEP OVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 80.73mm RAPID DISTANCE: 36.1mm ESTIMATED CYCLE TIME: 5s (0.3%) COOLANT: Flood	T32 D32 L32 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 16/60 DESCRIPTION: tasche superiori 2 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEP OVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 175.7mm RAPID DISTANCE: 119.65mm ESTIMATED CYCLE TIME: 11s (0.7%) COOLANT: Flood	T32 D32 L32 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 17/60 DESCRIPTION: tasche superiori 3.1 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEP DOWN: 11.5mm MAXIMUM STEP OVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 132.76mm RAPID DISTANCE: 102.29mm ESTIMATED CYCLE TIME: 11s (0.7%) COOLANT: Flood	T32 D32 L32 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 18/60 DESCRIPTION: tasche superiori 3.2 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm/0.1mm MAXIMUM STEP OVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 60.21mm RAPID DISTANCE: 47.1mm ESTIMATED CYCLE TIME: 6s (0.4%) COOLANT: Flood	T32 D32 L32 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 19/60 DESCRIPTION: tasche superiori 3.3 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm/0.1mm MAXIMUM STEP DOWN: 11.5mm MAXIMUM STEP OVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 172.57mm RAPID DISTANCE: 113.8mm ESTIMATED CYCLE TIME: 12s (0.7%) COOLANT: Flood	T32 D32 L32 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 20/60 DESCRIPTION: tasche superiori 3.4 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm/0.1mm MAXIMUM STEP OVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 57.92mm RAPID DISTANCE: 36.1mm ESTIMATED CYCLE TIME: 4s (0.3%) COOLANT: Flood	T32 D32 L32 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 21/60 DESCRIPTION: tasche superiori 3.5 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm/0.1mm MAXIMUM STEP OVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 69.11mm RAPID DISTANCE: 36.1mm ESTIMATED CYCLE TIME: 4s (0.3%) COOLANT: Flood	T32 D32 L32 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 22/60 DESCRIPTION: tasche superiori 4 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEP OVER: 7.6mm	MAXIMUM SPINDLE SPEED: 7918rpm MAXIMUM FEEDRATE: 2992.988mm/min CUTTING DISTANCE: 166.98mm RAPID DISTANCE: 92.59mm ESTIMATED CYCLE TIME: 10s (0.6%) COOLANT: Flood	T32 D32 L32 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	
Operation 23/60 DESCRIPTION: tasche superiori 5 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEP OVER: 1.51mm	MAXIMUM SPINDLE SPEED: 8020rpm MAXIMUM FEEDRATE: 417.061mm/min CUTTING DISTANCE: 167.6mm RAPID DISTANCE: 96.27mm ESTIMATED CYCLE TIME: 26s (1.6%) COOLANT: Flood	T50 D50 L50 TYPE: bullnose end mill DIAMETER: 3.17mm CORNER RADIUS: 0.79mm LENGTH: 22mm FLUTES: 4 DESCRIPTION: tasche superiori 34 VENDOR: Sandvik PRODUCT: RA216.24-0830BAK02G	

Operation 24/60 DESCRIPTION: tasche superiori 6 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 1.51mm	MAXIMUM SPINDLE SPEED: 8020rpm MAXIMUM FEEDRATE: 417.061mm/min CUTTING DISTANCE: 156.27mm RAPID DISTANCE: 95.38mm ESTIMATED CYCLE TIME: 25s (1.5%) COOLANT: Flood	T50 D50 L50 TYPE: bullnose end mill DIAMETER: 3.17mm CORNER RADIUS: 0.79mm LENGTH: 22mm FLUTES: 4 DESCRIPTION: tasche superiori 34 VENDOR: Sandvik PRODUCT: RA216.24-0830BAK02G	
Operation 25/60 DESCRIPTION: contornatura 2.2 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 17.5mm	MAXIMUM SPINDLE SPEED: 3132rpm MAXIMUM FEEDRATE: 1738.354mm/min CUTTING DISTANCE: 135.61mm RAPID DISTANCE: 57.5mm ESTIMATED CYCLE TIME: 11s (0.7%) COOLANT: Flood	T5 D5 L5 TYPE: flat end mill DIAMETER: 25mm LENGTH: 63mm FLUTES: 5 DESCRIPTION: Contornatura sotto VENDOR: Sandvik PRODUCT: 2N342-2500-PD	
Operation 26/60 DESCRIPTION: contornatura 4 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 25mm MAXIMUM STEPOVER: 23.75mm	MAXIMUM SPINDLE SPEED: 3132rpm MAXIMUM FEEDRATE: 1738.354mm/min CUTTING DISTANCE: 392.96mm RAPID DISTANCE: 201mm ESTIMATED CYCLE TIME: 27s (1.7%) COOLANT: Flood	T5 D5 L5 TYPE: flat end mill DIAMETER: 25mm LENGTH: 63mm FLUTES: 5 DESCRIPTION: Contornatura sotto VENDOR: Sandvik PRODUCT: 2N342-2500-PD	
Operation 27/60 DESCRIPTION: spallamento anteriore piccolo STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 7.2mm	MAXIMUM SPINDLE SPEED: 6658rpm MAXIMUM FEEDRATE: 798.954mm/min CUTTING DISTANCE: 69mm RAPID DISTANCE: 12.8mm ESTIMATED CYCLE TIME: 6s (0.4%) COOLANT: Flood	T20 D20 L20 TYPE: flat end mill DIAMETER: 12mm LENGTH: 36mm FLUTES: 5 DESCRIPTION: Tasca piccola S2 in basso VENDOR: Sandvik PRODUCT: 2N342-1200-PD	
Operation 28/60 DESCRIPTION: spallamento faccia foro anteriore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 15.2mm	MAXIMUM SPINDLE SPEED: 5073rpm MAXIMUM FEEDRATE: 1014.359mm/min CUTTING DISTANCE: 70.65mm RAPID DISTANCE: 33.4mm ESTIMATED CYCLE TIME: 8s (0.5%) COOLANT: Flood	T4 D4 L4 TYPE: flat end mill DIAMETER: 16mm LENGTH: 42mm FLUTES: 5 DESCRIPTION: Tasche VENDOR: Sandvik PRODUCT: 2N342-1600-PD	
Operation 29/60 DESCRIPTION: contornatura corpo anteriore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 13.3mm	MAXIMUM SPINDLE SPEED: 4027rpm MAXIMUM FEEDRATE: 1509.983mm/min CUTTING DISTANCE: 180.98mm RAPID DISTANCE: 35mm ESTIMATED CYCLE TIME: 11s (0.7%) COOLANT: Flood	T25 D25 L25 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 60mm FLUTES: 5 DESCRIPTION: Sandvik PRODUCT: 1K335-2000-300-XD	
Operation 30/60 DESCRIPTION: rifinitura corpo anteriore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 13.3mm	MAXIMUM SPINDLE SPEED: 4027rpm MAXIMUM FEEDRATE: 1509.983mm/min CUTTING DISTANCE: 203.98mm RAPID DISTANCE: 59mm ESTIMATED CYCLE TIME: 16s (1%) COOLANT: Flood	T25 D25 L25 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 60mm FLUTES: 5 DESCRIPTION: Sandvik PRODUCT: 1K335-2000-300-XD	
Operation 31/60 DESCRIPTION: tasche laterali con foro 1 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 9.6mm	MAXIMUM SPINDLE SPEED: 4934rpm MAXIMUM FEEDRATE: 986.736mm/min CUTTING DISTANCE: 174.82mm RAPID DISTANCE: 34.9mm ESTIMATED CYCLE TIME: 13s (0.8%) COOLANT: Flood	T4 D4 L4 TYPE: flat end mill DIAMETER: 16mm LENGTH: 42mm FLUTES: 5 DESCRIPTION: Tasche VENDOR: Sandvik PRODUCT: 2N342-1600-PD	
Operation 32/60 DESCRIPTION: tasche laterali con foro 2 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 9.6mm	MAXIMUM SPINDLE SPEED: 4934rpm MAXIMUM FEEDRATE: 986.736mm/min CUTTING DISTANCE: 171.32mm RAPID DISTANCE: 39.9mm ESTIMATED CYCLE TIME: 12s (0.7%) COOLANT: Flood	T4 D4 L4 TYPE: flat end mill DIAMETER: 16mm LENGTH: 42mm FLUTES: 5 DESCRIPTION: Tasche VENDOR: Sandvik PRODUCT: 2N342-1600-PD	
Operation 33/60 DESCRIPTION: fori sup 5mm STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 8021rpm MAXIMUM FEEDRATE: 2759.365mm/min CUTTING DISTANCE: 147.93mm RAPID DISTANCE: 427.52mm ESTIMATED CYCLE TIME: 8s (0.5%) COOLANT: Flood	T48 D48 L48 TYPE: drill DIAMETER: 5mm Tip Angle: 147° LENGTH: 52mm FLUTES: 2 DESCRIPTION: Fori superiori 5mm VENDOR: Sandvik PRODUCT: 860.1-0500-037A1-PM	
Operation 34/60 DESCRIPTION: filetti 5x10 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1440rpm MAXIMUM FEEDRATE: 1440mm/min CUTTING DISTANCE: 286.98mm RAPID DISTANCE: 160.56mm ESTIMATED CYCLE TIME: 14s (0.9%) COOLANT: Flood	T44 D44 L44 TYPE: right hand tap DIAMETER: 5mm LENGTH: 50mm FLUTES: 3 DESCRIPTION: Filettatura foro M6x1 S2 VENDOR: Sandvik PRODUCT: T300-PM104DA-M6	

Operation 35/60 DESCRIPTION: foro sup 3x8mm STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 5305rpm MAXIMUM FEEDRATE: 530.516mm/min CUTTING DISTANCE: 13mm RAPID DISTANCE: 23mm ESTIMATED CYCLE TIME: 2s (0.1%) COOLANT: Flood	T22 D22 L22 TYPE: drill DIAMETER: 3mm TIP ANGLE: 140° LENGTH: 33mm FLUTES: 2 DESCRIPTION: Fori sup 3x8 mm VENDOR: Sandvik PRODUCT: 862.1-3000-270A0-GM	
Operation 36/60 DESCRIPTION: foro lato 12x37mm STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 4536rpm MAXIMUM FEEDRATE: 2472.074mm/min CUTTING DISTANCE: 39.78mm RAPID DISTANCE: 62.78mm ESTIMATED CYCLE TIME: 2s (0.1%) COOLANT: Flood	T23 D23 L23 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 55mm FLUTES: 2 DESCRIPTION: Foratura laterale 12mm VENDOR: Sandvik PRODUCT: 860.1-1200-037A1-PM	
Operation 37/60 DESCRIPTION: foro lato 12x37mm1 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 4536rpm MAXIMUM FEEDRATE: 2472.074mm/min CUTTING DISTANCE: 39.78mm RAPID DISTANCE: 62.78mm ESTIMATED CYCLE TIME: 2s (0.1%) COOLANT: Flood	T23 D23 L23 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 55mm FLUTES: 2 DESCRIPTION: Foratura laterale 12mm VENDOR: Sandvik PRODUCT: 860.1-1200-037A1-PM	
Operation 38/60 DESCRIPTION: foro anteriore 12x16,5mm STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 4536rpm MAXIMUM FEEDRATE: 2472.074mm/min CUTTING DISTANCE: 24.56mm RAPID DISTANCE: 56.56mm ESTIMATED CYCLE TIME: 1s (0.1%) COOLANT: Flood	T23 D23 L23 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 55mm FLUTES: 2 DESCRIPTION: Foratura laterale 12mm VENDOR: Sandvik PRODUCT: 860.1-1200-037A1-PM	
Operation 39/60 DESCRIPTION: foro posteriore 20x60mm STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 2355rpm MAXIMUM FEEDRATE: 1648.845mm/min CUTTING DISTANCE: 62.6mm RAPID DISTANCE: 80.6mm ESTIMATED CYCLE TIME: 3s (0.2%) COOLANT: Flood	T27 D27 L27 TYPE: drill DIAMETER: 20mm TIP ANGLE: 147° LENGTH: 105mm FLUTES: 2 DESCRIPTION: Foro da 20x70 VENDOR: Sandvik PRODUCT: 860.1-2000-077A1-PM	
Operation 40/60 DESCRIPTION: spallamento posteriore 35mm STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEP OVER: 12.06mm	MAXIMUM SPINDLE SPEED: 7519rpm MAXIMUM FEEDRATE: 864.7mm/min CUTTING DISTANCE: 89.31mm RAPID DISTANCE: 28.73mm ESTIMATED CYCLE TIME: 8s (0.5%) COOLANT: Flood	T39 D39 L39 TYPE: flat end mill DIAMETER: 12.7mm LENGTH: 37.1mm FLUTES: 5 DESCRIPTION: Spallamento fori VENDOR: Sandvik PRODUCT: 2N342-1270-PD	
Operation 41/60 DESCRIPTION: foro corpo ant 16x38mm STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 2467rpm MAXIMUM FEEDRATE: 1401.2mm/min CUTTING DISTANCE: 47.37mm RAPID DISTANCE: 73.37mm ESTIMATED CYCLE TIME: 3s (0.2%) COOLANT: Flood	T28 D28 L28 TYPE: drill DIAMETER: 16mm TIP ANGLE: 147° LENGTH: 90mm FLUTES: 2 DESCRIPTION: Foro da 14mm VENDOR: Sandvik PRODUCT: 860.1-1600-044A1-PM	
Operation 42/60 DESCRIPTION: allargamento corpo anteriore 18x8mm STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 2193rpm MAXIMUM FEEDRATE: 1359.537mm/min CUTTING DISTANCE: 14.67mm RAPID DISTANCE: 36.67mm ESTIMATED CYCLE TIME: 1s (0.1%) COOLANT: Flood	T46 D46 L46 TYPE: drill DIAMETER: 18mm TIP ANGLE: 147° LENGTH: 80mm FLUTES: 2 DESCRIPTION: allargatura foro corpo centrale VENDOR: Sandvik PRODUCT: 860.1-1800-050A1-PM	
Operation 43/60 DESCRIPTION: foro anteriore 14x16,5mm STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 2865rpm MAXIMUM FEEDRATE: 1627.2mm/min CUTTING DISTANCE: 25.03mm RAPID DISTANCE: 173.03mm ESTIMATED CYCLE TIME: 3s (0.2%) COOLANT: Flood	T26 D26 L26 TYPE: drill DIAMETER: 14mm TIP ANGLE: 147° LENGTH: 134mm FLUTES: 2 DESCRIPTION: Foro da 14mm VENDOR: Sandvik PRODUCT: 860.1-1400-115A1-PM	
Operation 44/60 DESCRIPTION: preforo 34x46 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 2387rpm MAXIMUM FEEDRATE: 596.831mm/min CUTTING DISTANCE: 61mm RAPID DISTANCE: 77mm ESTIMATED CYCLE TIME: 7s (0.4%) COOLANT: Air through tool	T11 D11 L11 TYPE: drill DIAMETER: 34mm TIP ANGLE: 176° LENGTH: 130.37mm FLUTES: 2 DESCRIPTION: Pre foro 35 (H15 tolleranza) VENDOR: Sandvik PRODUCT: 880-D3400L40-03	

Operation 45/60 DESCRIPTION: barenatura 35x92 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1400rpm MAXIMUM FEEDRATE: 333.333mm/min CUTTING DISTANCE: 97mm RAPID DISTANCE: 103mm ESTIMATED CYCLE TIME: 19s (1.2%) COOLANT: Flood	T16 D16 L16 TYPE: boring bar DIAMETER: 35mm LENGTH: 99mm FLUTES: 1 DESCRIPTION: barenatura 35 mm VENDOR: Sandvik PRODUCT: 825-45TC09-C3	
Operation 46/60 DESCRIPTION: spallamento superiore 45mm STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 15.2mm	MAXIMUM SPINDLE SPEED: 4934rpm MAXIMUM FEEDRATE: 986.736mm/min CUTTING DISTANCE: 117.76mm RAPID DISTANCE: 25.4mm ESTIMATED CYCLE TIME: 9s (0.6%) COOLANT: Flood	T4 D4 L4 TYPE: flat end mill DIAMETER: 16mm LENGTH: 42mm FLUTES: 5 DESCRIPTION: Tasche VENDOR: Sandvik PRODUCT: 2N342-1600-PD	
Operation 47/60 DESCRIPTION: slot spallamento superiore STRATEGY: Circular WCS: #1 STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 1mm	MAXIMUM SPINDLE SPEED: 7548rpm MAXIMUM FEEDRATE: 758.529mm/min CUTTING DISTANCE: 375.83mm RAPID DISTANCE: 78.77mm ESTIMATED CYCLE TIME: 31s (1.9%) COOLANT: Flood	T41 D41 L41 TYPE: slot mill DIAMETER: 9.7mm CORNER RADIUS: 0.2mm LENGTH: 41.5mm FLUTES: 3 DESCRIPTION: Slot S2 VENDOR: Sandvik PRODUCT: 327R06-10 15002-GM	
Operation 48/60 DESCRIPTION: slot corpo anteriore 1 STRATEGY: Circular WCS: #1 STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 1mm	MAXIMUM SPINDLE SPEED: 5000rpm MAXIMUM FEEDRATE: 1000mm/min CUTTING DISTANCE: 79.4mm RAPID DISTANCE: 56.9mm ESTIMATED CYCLE TIME: 5s (0.3%) COOLANT: Flood	T42 D42 L42 TYPE: slot mill DIAMETER: 10mm LENGTH: 40mm FLUTES: 7 DESCRIPTION: Prova 2 S2 contour	
Operation 49/60 DESCRIPTION: slot corpo anteriore 2 STRATEGY: Circular WCS: #1 STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 1mm	MAXIMUM SPINDLE SPEED: 7548rpm MAXIMUM FEEDRATE: 758.529mm/min CUTTING DISTANCE: 68.34mm RAPID DISTANCE: 50mm ESTIMATED CYCLE TIME: 6s (0.4%) COOLANT: Flood	T41 D41 L41 TYPE: slot mill DIAMETER: 9.7mm CORNER RADIUS: 0.2mm LENGTH: 41.5mm FLUTES: 3 DESCRIPTION: Slot S2 VENDOR: Sandvik PRODUCT: 327R06-10 15002-GM	
Operation 50/60 DESCRIPTION: contornatura sm con raggi sx STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 2274rpm MAXIMUM FEEDRATE: 682.093mm/min CUTTING DISTANCE: 75.35mm RAPID DISTANCE: 30.5mm ESTIMATED CYCLE TIME: 9s (0.6%) COOLANT: Flood	T47 D47 L47 TYPE: bullnose end mill DIAMETER: 14mm CORNER RADIUS: 3mm LENGTH: 70mm FLUTES: 4 DESCRIPTION: Contour sm con raggi S2 VENDOR: Sandvik PRODUCT: R216.24-14050GAK26P	
Operation 51/60 DESCRIPTION: contornatura sm con raggi dx STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 2274rpm MAXIMUM FEEDRATE: 682.093mm/min CUTTING DISTANCE: 81.38mm RAPID DISTANCE: 33.1mm ESTIMATED CYCLE TIME: 10s (0.6%) COOLANT: Flood	T47 D47 L47 TYPE: bullnose end mill DIAMETER: 14mm CORNER RADIUS: 3mm LENGTH: 70mm FLUTES: 4 DESCRIPTION: Contour sm con raggi S2 VENDOR: Sandvik PRODUCT: R216.24-14050GAK26P	
Operation 52/60 DESCRIPTION: finitura lato sx corpo anteriore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 12.06mm	MAXIMUM SPINDLE SPEED: 7519rpm MAXIMUM FEEDRATE: 864.7mm/min CUTTING DISTANCE: 45.25mm RAPID DISTANCE: 62.73mm ESTIMATED CYCLE TIME: 6s (0.4%) COOLANT: Flood	T39 D39 L39 TYPE: flat end mill DIAMETER: 12.7mm LENGTH: 37.1mm FLUTES: 5 DESCRIPTION: Spallamento fori VENDOR: Sandvik PRODUCT: 2N342-1270-PD	
Operation 53/60 DESCRIPTION: finitura lato dx corpo anteriore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 12.06mm	MAXIMUM SPINDLE SPEED: 7519rpm MAXIMUM FEEDRATE: 864.7mm/min CUTTING DISTANCE: 47.25mm RAPID DISTANCE: 60.73mm ESTIMATED CYCLE TIME: 6s (0.4%) COOLANT: Flood	T39 D39 L39 TYPE: flat end mill DIAMETER: 12.7mm LENGTH: 37.1mm FLUTES: 5 DESCRIPTION: Spallamento fori VENDOR: Sandvik PRODUCT: 2N342-1270-PD	
Operation 54/60 DESCRIPTION: smusso fori 5mm STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 5836rpm MAXIMUM FEEDRATE: 1960.789mm/min CUTTING DISTANCE: 161.79mm RAPID DISTANCE: 224.88mm ESTIMATED CYCLE TIME: 16s (1%) COOLANT: Flood	T37 D37 L37 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	
Operation 55/60 DESCRIPTION: smusso corpo anteriore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 5836rpm MAXIMUM FEEDRATE: 1960.789mm/min CUTTING DISTANCE: 147.51mm RAPID DISTANCE: 11.4mm ESTIMATED CYCLE TIME: 5s (0.3%) COOLANT: Flood	T37 D37 L37 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	

Operation 56/60 DESCRIPTION: smusso spallamento superiore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 5836rpm MAXIMUM FEEDRATE: 1960.789mm/min CUTTING DISTANCE: 161.6mm RAPID DISTANCE: 38.4mm ESTIMATED CYCLE TIME: 8s (0.5%) COOLANT: Flood	T37 D37 L37 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	
Operation 57/60 DESCRIPTION: smusso foro superiore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 5836rpm MAXIMUM FEEDRATE: 1960.789mm/min CUTTING DISTANCE: 117.18mm RAPID DISTANCE: 27.4mm ESTIMATED CYCLE TIME: 5s (0.3%) COOLANT: Flood	T37 D37 L37 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	
Operation 58/60 DESCRIPTION: smusso spallamento posteriore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 5836rpm MAXIMUM FEEDRATE: 1960.789mm/min CUTTING DISTANCE: 70.06mm RAPID DISTANCE: 13.4mm ESTIMATED CYCLE TIME: 3s (0.2%) COOLANT: Flood	T37 D37 L37 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	
Operation 59/60 DESCRIPTION: smusso foro corpo anteriore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 5836rpm MAXIMUM FEEDRATE: 1960.789mm/min CUTTING DISTANCE: 61.78mm RAPID DISTANCE: 11.4mm ESTIMATED CYCLE TIME: 3s (0.2%) COOLANT: Flood	T37 D37 L37 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	
Operation 60/60 DESCRIPTION: smusso foro anteriore STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 5836rpm MAXIMUM FEEDRATE: 1960.789mm/min CUTTING DISTANCE: 41.93mm RAPID DISTANCE: 8.4mm ESTIMATED CYCLE TIME: 2s (0.1%) COOLANT: Flood	T37 D37 L37 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45° interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	

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