

Setup Sheet for Program 1001

JOB DESCRIPTION: AutoSetup 1

DOCUMENT PATH: Toolpath-FINITO Fori

Setup

WCS: #0

STOCK:

DX: 160mm

DY: 95mm

DZ: 35mm

PART:

DX: 150mm

DY: 84.87mm

DZ: 25mm

STOCK LOWER IN WCS #0:

X: -80mm

Y: -47.5mm

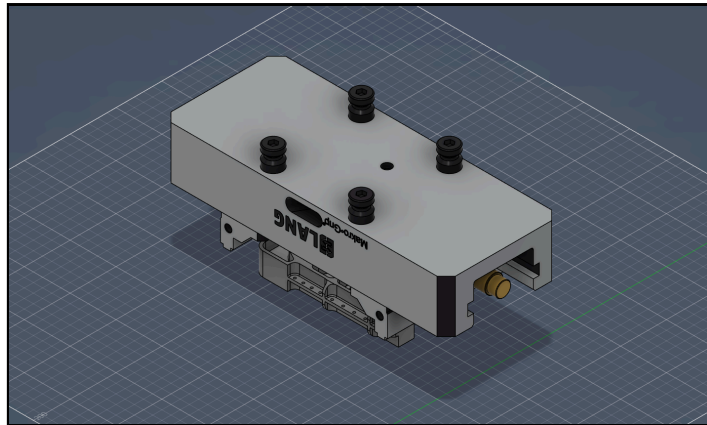
Z: -35mm

STOCK UPPER IN WCS #0:

X: 80mm

Y: 47.5mm

Z: 0mm



Total

NUMBER OF OPERATIONS: 15

NUMBER OF TOOLS: 12

TOOLS: T13000 T17000 T17006 T17013 T19000 T19006 T19007 T22003 T22011 T22012 T22013 T22014

MAXIMUM Z: 6.05mm

MINIMUM Z: -30.25mm

MAXIMUM FEEDRATE: 2470mm/min

MAXIMUM SPINDLE SPEED: 8000rpm

CUTTING DISTANCE: 28100.69mm

RAPID DISTANCE: 20265.28mm

ESTIMATED CYCLE TIME: 43m:42s

Tools

T13000 D13000 L13000

TYPE: face mill

DIAMETER: 40mm

CORNER RADIUS: 0.8mm

TAPER ANGLE: 45°

LENGTH: 40mm

FLUTES: 4

DESCRIPTION: Sgrossatura

VENDOR: Sandvik

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

MINIMUM Z: -4.5mm

MAXIMUM FEED: 2390.004mm/min

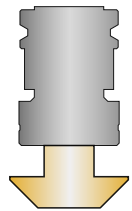
MAXIMUM SPINDLE SPEED: 1500rpm

CUTTING DISTANCE: 3585.66mm

RAPID DISTANCE: 291.14mm

ESTIMATED CYCLE TIME: 1m:35s (3.6%)

HOLDER: BT40 - B4C4-1000



T17000 D17000 L17000

TYPE: flat end mill

DIAMETER: 40mm

LENGTH: 100mm

FLUTES: 4

DESCRIPTION: CoroMill490 Sgrossatura

VENDOR: Sandvik

PRODUCT: [490-040A32-14H](#)

MINIMUM Z: -30.25mm

MAXIMUM FEED: 2470mm/min

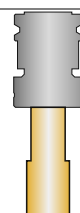
MAXIMUM SPINDLE SPEED: 1880rpm

CUTTING DISTANCE: 7196.44mm

RAPID DISTANCE: 6651.85mm

ESTIMATED CYCLE TIME: 4m:15s (9.7%)

HOLDER: BT40 - B4C4-1000



T17006 D17006 L17006

TYPE: drill

DIAMETER: 2.5mm

TIP ANGLE: 140°

LENGTH: 38mm

FLUTES: 2

DESCRIPTION: CoroDrill 862 Foripiccoli

VENDOR: Sandvik

PRODUCT: [862.1-2500-225A0-GM X2BL](#)

MINIMUM Z: -19.58mm

MAXIMUM FEED: 113mm/min

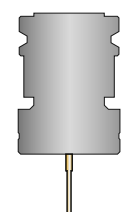
MAXIMUM SPINDLE SPEED: 4010rpm

CUTTING DISTANCE: 602.7mm

RAPID DISTANCE: 1157.43mm

ESTIMATED CYCLE TIME: 5m:34s (12.7%)

HOLDER: BT40 - B4C4-1000



T17013 D17013 L17013

TYPE: flat end mill

DIAMETER: 4mm

LENGTH: 30mm

FLUTES: 3

DESCRIPTION: CoroMill Plura FinituraTascheLateral

VENDOR: Sandvik

PRODUCT: [R216.23-04050CAK11P.1620](#)

MINIMUM Z: -16mm

MAXIMUM FEED: 2330mm/min

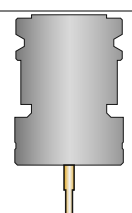
MAXIMUM SPINDLE SPEED: 8000rpm

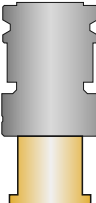
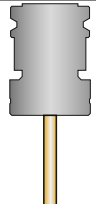
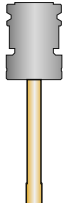





CUTTING DISTANCE: 2433.55mm

RAPID DISTANCE: 998.24mm

ESTIMATED CYCLE TIME: 1m:45s (4%)

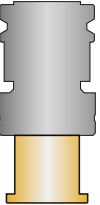
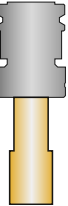



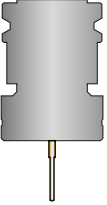
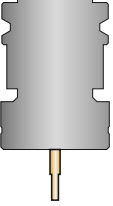
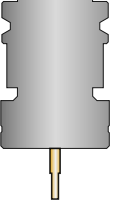
HOLDER: BT40 - B4C4-1000





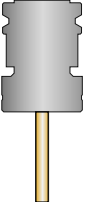
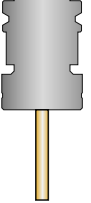


T19000 D19000 L19000 TYPE: face mill DIAMETER: 54.08mm CORNER RADIUS: 0.8mm LENGTH: 45mm FLUTES: 4 DESCRIPTION: Fresa CoroMill 345 per spianatura VENDOR: sandvik PRODUCT: 345-040Q22-13M	MINIMUM Z: -5mm MAXIMUM FEED: 1600.002mm/min MAXIMUM SPINDLE SPEED: 1600rpm CUTTING DISTANCE: 763.09mm RAPID DISTANCE: 5.18mm ESTIMATED CYCLE TIME: 29s (1.1%)	HOLDER: BT40 - B4C4-1000 
T19006 D19006 L19006 TYPE: flat end mill DIAMETER: 10mm LENGTH: 72mm FLUTES: 4 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-1000-050-XD 1730	MINIMUM Z: -30.25mm MAXIMUM FEED: 451mm/min MAXIMUM SPINDLE SPEED: 2230rpm CUTTING DISTANCE: 1499.2mm RAPID DISTANCE: 2279.51mm ESTIMATED CYCLE TIME: 3m:50s (8.8%)	HOLDER: BT40 - B4C4-1000 
T19007 D19007 L19007 TYPE: flat end mill DIAMETER: 18mm LENGTH: 145mm FLUTES: 2 DESCRIPTION: Fresa CoroMill 390 per spallamenti VENDOR: sandvik PRODUCT: R390-018A16L-11L	MINIMUM Z: -30.25mm MAXIMUM FEED: 651mm/min MAXIMUM SPINDLE SPEED: 4070rpm CUTTING DISTANCE: 2266.24mm RAPID DISTANCE: 4150.67mm ESTIMATED CYCLE TIME: 5m:37s (12.9%)	HOLDER: BT40 - B4C4-1000 
T22003 D22003 L22003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.2mm LENGTH: 45mm FLUTES: 5 DESCRIPTION: Sgrossatura tasche 1 PRODUCT: 1K325-0800-XB 1730	MINIMUM Z: -16mm MAXIMUM FEED: 2170mm/min MAXIMUM SPINDLE SPEED: 2170rpm CUTTING DISTANCE: 7219.48mm RAPID DISTANCE: 2494.03mm ESTIMATED CYCLE TIME: 12m:54s (29.5%)	
T22011 D22011 L22011 TYPE: flat end mill DIAMETER: 4mm LENGTH: 40mm FLUTES: 5 DESCRIPTION: Fresa per sgrossatura (tasca piccola) e per finitura totale tasche PRODUCT: 1K334-0400-050-XC 1730	MINIMUM Z: -16mm MAXIMUM FEED: 2106.67mm/min MAXIMUM SPINDLE SPEED: 7190rpm CUTTING DISTANCE: 1204.52mm RAPID DISTANCE: 1429.99mm ESTIMATED CYCLE TIME: 2m:1s (4.6%)	
T22012 D22012 L22012 TYPE: flat end mill DIAMETER: 32mm LENGTH: 100mm FLUTES: 4 DESCRIPTION: fresa per elicoidale VENDOR: mitsubishi PRODUCT: AQXR324SA32S con inserto QOMT1651R-M2 con grado MP6130	MINIMUM Z: -30.1mm MAXIMUM FEED: 250mm/min MAXIMUM SPINDLE SPEED: 1393rpm CUTTING DISTANCE: 491.42mm RAPID DISTANCE: 34.12mm ESTIMATED CYCLE TIME: 1m:58s (4.5%)	
T22013 D22013 L22013 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 1mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: 54_finitura_fondo_tondo VENDOR: mitsubishi PRODUCT: MPMHVRBD0800R100	MINIMUM Z: -16mm MAXIMUM FEED: 1999.2mm/min MAXIMUM SPINDLE SPEED: 6000rpm CUTTING DISTANCE: 459.45mm RAPID DISTANCE: 710.18mm ESTIMATED CYCLE TIME: 31s (1.2%)	
T22014 D22014 L22014 TYPE: ball end mill DIAMETER: 8mm CORNER RADIUS: 4mm LENGTH: 20mm FLUTES: 4 DESCRIPTION: nervatura tonda VENDOR: mitsubishi PRODUCT: fresa a punta tonda VQ4SVBR04000	MINIMUM Z: -16.29mm MAXIMUM FEED: 1900.001mm/min MAXIMUM SPINDLE SPEED: 8000rpm CUTTING DISTANCE: 378.96mm RAPID DISTANCE: 62.93mm ESTIMATED CYCLE TIME: 13s (0.5%)	

Operations

Operation 1/15 DESCRIPTION: 1 Face STRATEGY: Facing WCS: #0 TOLERANCE: 0.03mm MAXIMUM STEPDOWN: 1.02mm MAXIMUM STEPOVER: 41.8mm	MAXIMUM Z: 6.05mm MINIMUM Z: -4.5mm MAXIMUM SPINDLE SPEED: 1500rpm MAXIMUM FEEDRATE: 2390.004mm/min CUTTING DISTANCE: 3585.66mm RAPID DISTANCE: 291.14mm ESTIMATED CYCLE TIME: 1m:35s (3.6%) COOLANT: Flood	T13000 D13000 L13000 TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 0.8mm TAPER ANGLE: 45° LENGTH: 40mm FLUTES: 4 DESCRIPTION: Sgrossatura VENDOR: Sandvik PRODUCT: 345-040Q22-13L	
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<p>Operation 2/15</p> <p>DESCRIPTION: 2 Face</p> <p>STRATEGY: Facing</p> <p>WCS: #0</p> <p>TOLERANCE: 0.03mm</p> <p>MAXIMUM STEPOVER: 36.74mm</p>	<p>MAXIMUM Z: 3.05mm</p> <p>MINIMUM Z: -5mm</p> <p>MAXIMUM SPINDLE SPEED: 1600rpm</p> <p>MAXIMUM FEEDRATE: 1600.002mm/min</p> <p>CUTTING DISTANCE: 763.09mm</p> <p>RAPID DISTANCE: 5.18mm</p> <p>ESTIMATED CYCLE TIME: 29s (1.1%)</p> <p>COOLANT: Flood</p>	<p>T19000 D19000 L19000</p> <p>TYPE: face mill</p> <p>DIAMETER: 54.08mm</p> <p>CORNER RADIUS: 0.8mm</p> <p>LENGTH: 45mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: Fresa CoroMill 345 per spianatura</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 345-040Q22-13M</p>	
<p>Operation 3/15</p> <p>DESCRIPTION: 3 Adaptive Clearing</p> <p>STRATEGY: Adaptive</p> <p>WCS: #0</p> <p>TOLERANCE: 0.05mm</p> <p>STOCK TO LEAVE: 0.25mm</p> <p>MAXIMUM STEPDOWN: 7.5mm</p> <p>OPTIMAL LOAD: 16mm</p> <p>LOAD DEVIATION: 1.6mm</p>	<p>MAXIMUM Z: 0.51mm</p> <p>MINIMUM Z: -30.25mm</p> <p>MAXIMUM SPINDLE SPEED: 1880rpm</p> <p>MAXIMUM FEEDRATE: 2470mm/min</p> <p>CUTTING DISTANCE: 7196.44mm</p> <p>RAPID DISTANCE: 6651.85mm</p> <p>ESTIMATED CYCLE TIME: 4m:15s (9.7%)</p> <p>COOLANT: Air</p>	<p>T17000 D17000 L17000</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 40mm</p> <p>LENGTH: 100mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill490 Sgrossatura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 490-040A32-14H</p>	
<p>Operation 4/15</p> <p>DESCRIPTION: 4 Adaptive Clearing</p> <p>STRATEGY: Adaptive</p> <p>WCS: #0</p> <p>TOLERANCE: 0.05mm</p> <p>STOCK TO LEAVE: 0.25mm</p> <p>MAXIMUM STEPDOWN: 10.8mm</p> <p>OPTIMAL LOAD: 2.4mm</p> <p>LOAD DEVIATION: 0.24mm</p>	<p>MAXIMUM Z: 0.51mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 2170rpm</p> <p>MAXIMUM FEEDRATE: 2170mm/min</p> <p>CUTTING DISTANCE: 7219.48mm</p> <p>RAPID DISTANCE: 2494.03mm</p> <p>ESTIMATED CYCLE TIME: 12m:54s (29.5%)</p> <p>COOLANT: Flood</p>	<p>T22003 D22003 L22003</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 0.2mm</p> <p>LENGTH: 45mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Sgrossatura tasche 1</p> <p>PRODUCT: 1K325-0800-XB 1730</p>	
<p>Operation 5/15</p> <p>DESCRIPTION: 5 Adaptive Clearing</p> <p>STRATEGY: Adaptive</p> <p>WCS: #0</p> <p>TOLERANCE: 0.05mm</p> <p>STOCK TO LEAVE: 0.25mm</p> <p>MAXIMUM STEPDOWN: 7.5mm</p> <p>OPTIMAL LOAD: 7.2mm</p> <p>LOAD DEVIATION: 0.72mm</p>	<p>MAXIMUM Z: 0.51mm</p> <p>MINIMUM Z: -30.25mm</p> <p>MAXIMUM SPINDLE SPEED: 4070rpm</p> <p>MAXIMUM FEEDRATE: 651mm/min</p> <p>CUTTING DISTANCE: 2266.24mm</p> <p>RAPID DISTANCE: 4150.67mm</p> <p>ESTIMATED CYCLE TIME: 5m:37s (12.9%)</p> <p>COOLANT: Flood</p>	<p>T19007 D19007 L19007</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 18mm</p> <p>LENGTH: 145mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: Fresa CoroMill 390 per spallamenti</p> <p>VENDOR: sandvik</p> <p>PRODUCT: R390-018A16L-11L</p>	
<p>Operation 6/15</p> <p>DESCRIPTION: 6 Adaptive Clearing</p> <p>STRATEGY: Adaptive</p> <p>WCS: #0</p> <p>TOLERANCE: 0.05mm</p> <p>STOCK TO LEAVE: 0.25mm</p> <p>MAXIMUM STEPDOWN: 8.25mm</p> <p>OPTIMAL LOAD: 1.6mm</p> <p>LOAD DEVIATION: 0.16mm</p>	<p>MAXIMUM Z: 0.51mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 7190rpm</p> <p>MAXIMUM FEEDRATE: 2106.67mm/min</p> <p>CUTTING DISTANCE: 1204.52mm</p> <p>RAPID DISTANCE: 1429.99mm</p> <p>ESTIMATED CYCLE TIME: 2m:1s (4.6%)</p> <p>COOLANT: Flood</p>	<p>T22011 D22011 L22011</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa per sgrossatura (tasca piccola) e per finitura totale tasche</p> <p>PRODUCT: 1K334-0400-050-XC 1730</p>	
<p>Operation 7/15</p> <p>DESCRIPTION: 7 Drill</p> <p>STRATEGY: Drilling</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p>	<p>MAXIMUM Z: 3.05mm</p> <p>MINIMUM Z: -19.58mm</p> <p>MAXIMUM SPINDLE SPEED: 4010rpm</p> <p>MAXIMUM FEEDRATE: 113mm/min</p> <p>CUTTING DISTANCE: 602.7mm</p> <p>RAPID DISTANCE: 1157.43mm</p> <p>ESTIMATED CYCLE TIME: 5m:34s (12.7%)</p> <p>COOLANT: Flood</p>	<p>T17006 D17006 L17006</p> <p>TYPE: drill</p> <p>DIAMETER: 2.5mm</p> <p>TIP ANGLE: 140°</p> <p>LENGTH: 38mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: CoroDrill 862 Foripiccoli</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 862.1-2500-225A0-GM X2BL</p>	
<p>Operation 8/15</p> <p>DESCRIPTION: 8 Flat</p> <p>WCS: #0</p> <p>TOLERANCE: 0.03mm</p> <p>STOCK TO LEAVE: 0.13mm/0mm</p> <p>MAXIMUM STEPOVER: 2.8mm</p>	<p>MAXIMUM Z: 0.51mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8000rpm</p> <p>MAXIMUM FEEDRATE: 2330mm/min</p> <p>CUTTING DISTANCE: 1195.79mm</p> <p>RAPID DISTANCE: 448.7mm</p> <p>ESTIMATED CYCLE TIME: 37s (1.4%)</p> <p>COOLANT: Flood</p>	<p>T17013 D17013 L17013</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4mm</p> <p>LENGTH: 30mm</p> <p>FLUTES: 3</p> <p>DESCRIPTION: CoroMill Plura FinituraTascheLateral</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: R216.23-04050CAK11P 1620</p>	
<p>Operation 9/15</p> <p>DESCRIPTION: 9 2D Contour</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0mm</p> <p>STOCK TO LEAVE: 0mm/0.03mm</p> <p>MAXIMUM STEPDOWN: 9.9mm</p> <p>MAXIMUM STEPOVER: 3.8mm</p>	<p>MAXIMUM Z: 3.05mm</p> <p>MINIMUM Z: -15.97mm</p> <p>MAXIMUM SPINDLE SPEED: 8000rpm</p> <p>MAXIMUM FEEDRATE: 2330mm/min</p> <p>CUTTING DISTANCE: 1237.76mm</p> <p>RAPID DISTANCE: 549.54mm</p> <p>ESTIMATED CYCLE TIME: 1m:8s (2.6%)</p> <p>COOLANT: Flood</p>	<p>T17013 D17013 L17013</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4mm</p> <p>LENGTH: 30mm</p> <p>FLUTES: 3</p> <p>DESCRIPTION: CoroMill Plura FinituraTascheLateral</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: R216.23-04050CAK11P 1620</p>	

<p>Operation 10/15</p> <p>DESCRIPTION: 10 Flat</p> <p>WCS: #0</p> <p>TOLERANCE: 0.03mm</p> <p>STOCK TO LEAVE: 0.13mm/0mm</p> <p>MAXIMUM STEPOVER: 4.2mm</p>	<p>MAXIMUM Z: 0.51mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 6000rpm</p> <p>MAXIMUM FEEDRATE: 1999.2mm/min</p> <p>CUTTING DISTANCE: 303.39mm</p> <p>RAPID DISTANCE: 525.4mm</p> <p>ESTIMATED CYCLE TIME: 17s (0.6%)</p> <p>COOLANT: Flood</p>	<p>T22013 D22013 L22013</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: 54_finitura_fondo_tondo</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: MPMHVRBD0800R100</p>	
<p>Operation 11/15</p> <p>DESCRIPTION: 11 2D Contour</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0mm</p> <p>STOCK TO LEAVE: 0mm/0.03mm</p> <p>MAXIMUM STEPOVER: 5.7mm</p>	<p>MAXIMUM Z: 3.05mm</p> <p>MINIMUM Z: -15.97mm</p> <p>MAXIMUM SPINDLE SPEED: 6000rpm</p> <p>MAXIMUM FEEDRATE: 1999.2mm/min</p> <p>CUTTING DISTANCE: 156.05mm</p> <p>RAPID DISTANCE: 184.78mm</p> <p>ESTIMATED CYCLE TIME: 14s (0.5%)</p> <p>COOLANT: Flood</p>	<p>T22013 D22013 L22013</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: 54_finitura_fondo_tondo</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: MPMHVRBD0800R100</p>	
<p>Operation 12/15</p> <p>DESCRIPTION: 12 Bore</p> <p>STRATEGY: Bore</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p>	<p>MAXIMUM Z: 0.51mm</p> <p>MINIMUM Z: -30.1mm</p> <p>MAXIMUM SPINDLE SPEED: 1393rpm</p> <p>MAXIMUM FEEDRATE: 250mm/min</p> <p>CUTTING DISTANCE: 491.42mm</p> <p>RAPID DISTANCE: 34.12mm</p> <p>ESTIMATED CYCLE TIME: 1m:58s (4.5%)</p> <p>COOLANT: Flood</p>	<p>T22012 D22012 L22012</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 32mm</p> <p>LENGTH: 100mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: fresa per elicoidale</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: AQXR324SA32S con inserto QOMT1651R-M2 con grado MP6130</p>	
<p>Operation 13/15</p> <p>DESCRIPTION: 13 Scallop</p> <p>STRATEGY: Scallop</p> <p>WCS: #0</p> <p>TOLERANCE: 0.03mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPOVER: 0.64mm</p>	<p>MAXIMUM Z: 0.51mm</p> <p>MINIMUM Z: -16.29mm</p> <p>MAXIMUM SPINDLE SPEED: 8000rpm</p> <p>MAXIMUM FEEDRATE: 1900.001mm/min</p> <p>CUTTING DISTANCE: 378.96mm</p> <p>RAPID DISTANCE: 62.93mm</p> <p>ESTIMATED CYCLE TIME: 13s (0.5%)</p> <p>COOLANT: Flood</p>	<p>T22014 D22014 L22014</p> <p>TYPE: ball end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 4mm</p> <p>LENGTH: 20mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: nervatura tonda</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: fresa a punta tonda VQ4SVBR04000</p>	
<p>Operation 14/15</p> <p>DESCRIPTION: 14 Adaptive Clearing</p> <p>STRATEGY: Adaptive</p> <p>WCS: #0</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.25mm/0mm</p> <p>MAXIMUM STEPDOWN: 16.5mm</p> <p>OPTIMAL LOAD: 4mm</p> <p>LOAD DEVIATION: 0.4mm</p>	<p>MAXIMUM Z: 0.51mm</p> <p>MINIMUM Z: -30.25mm</p> <p>MAXIMUM SPINDLE SPEED: 2230rpm</p> <p>MAXIMUM FEEDRATE: 451mm/min</p> <p>CUTTING DISTANCE: 523.83mm</p> <p>RAPID DISTANCE: 2210.2mm</p> <p>ESTIMATED CYCLE TIME: 1m:36s (3.7%)</p> <p>COOLANT: Flood</p>	<p>T19006 D19006 L19006</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 10mm</p> <p>LENGTH: 72mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 1K335-1000-050-XD 1730</p>	
<p>Operation 15/15</p> <p>DESCRIPTION: 15 2D Contour</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 22mm</p> <p>MAXIMUM STEPOVER: 9.5mm</p>	<p>MAXIMUM Z: 3.05mm</p> <p>MINIMUM Z: -30.13mm</p> <p>MAXIMUM SPINDLE SPEED: 2230rpm</p> <p>MAXIMUM FEEDRATE: 451mm/min</p> <p>CUTTING DISTANCE: 975.37mm</p> <p>RAPID DISTANCE: 69.3mm</p> <p>ESTIMATED CYCLE TIME: 2m:13s (5.1%)</p> <p>COOLANT: Flood</p>	<p>T19006 D19006 L19006</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 10mm</p> <p>LENGTH: 72mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 1K335-1000-050-XD 1730</p>	

Setup Sheet for Program 1002

JOB DESCRIPTION: AutoSetup 2

DOCUMENT PATH: Toolpath-FINITO Fori

Setup

WCS: #0

STOCK:

DX: 160mm

DY: 95mm

DZ: 35mm

PART:

DX: 150mm

DY: 84.87mm

DZ: 25mm

STOCK LOWER IN WCS #0:

X: -80mm

Y: -47.5mm

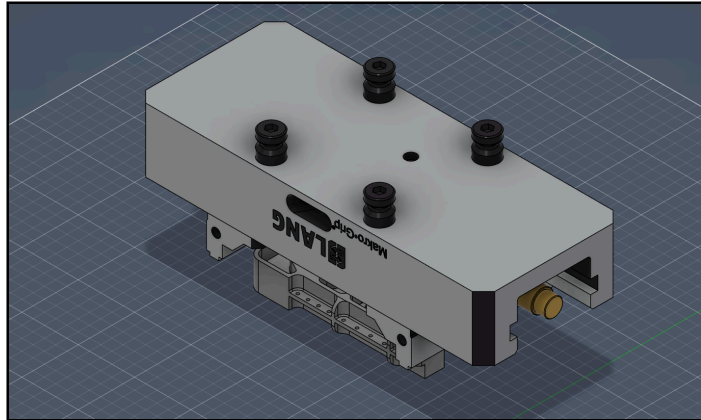
Z: -35mm

STOCK UPPER IN WCS #0:

X: 80mm

Y: 47.5mm

Z: 0mm



Total

NUMBER OF OPERATIONS: 9

NUMBER OF TOOLS: 7

TOOLS: T13000 T17013 T19000 T22003 T22011 T22013 T22014

MAXIMUM Z: 6.05mm

MINIMUM Z: -16.29mm

MAXIMUM FEEDRATE: 2390.004mm/min

MAXIMUM SPINDLE SPEED: 8000rpm

CUTTING DISTANCE: 14860.52mm

RAPID DISTANCE: 6298.6mm

ESTIMATED CYCLE TIME: 19m:17s

Tools

T13000 D13000 L13000

TYPE: face mill

DIAMETER: 40mm

CORNER RADIUS: 0.8mm

TAPER ANGLE: 45°

LENGTH: 40mm

FLUTES: 4

DESCRIPTION: Sgrossatura

VENDOR: Sandvik

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

MINIMUM Z: -4.5mm

MAXIMUM FEED: 2390.004mm/min

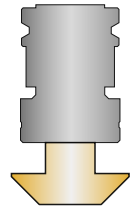
MAXIMUM SPINDLE SPEED: 1500rpm

CUTTING DISTANCE: 3585.66mm

RAPID DISTANCE: 291.14mm

ESTIMATED CYCLE TIME: 1m:35s (8.2%)

HOLDER: BT40 - B4C4-1000



T17013 D17013 L17013

TYPE: flat end mill

DIAMETER: 4mm

LENGTH: 30mm

FLUTES: 3

DESCRIPTION: CoroMill Plura FinituraTascheLaterali

VENDOR: Sandvik

PRODUCT: [R216.23-04050CAK11P 1620](#)

MINIMUM Z: -16mm

MAXIMUM FEED: 2330mm/min

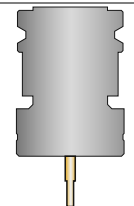
MAXIMUM SPINDLE SPEED: 8000rpm

CUTTING DISTANCE: 2435.69mm

RAPID DISTANCE: 1007.4mm

ESTIMATED CYCLE TIME: 1m:45s (9.1%)

HOLDER: BT40 - B4C4-1000



T19000 D19000 L19000

TYPE: face mill

DIAMETER: 54.08mm

CORNER RADIUS: 0.8mm

LENGTH: 45mm

FLUTES: 4

DESCRIPTION: Fresa CoroMill 345 per spianatura

VENDOR: sandvik

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

MINIMUM Z: -5mm

MAXIMUM FEED: 1600.002mm/min

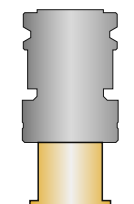
MAXIMUM SPINDLE SPEED: 1600rpm

CUTTING DISTANCE: 761.78mm

RAPID DISTANCE: 5.18mm

ESTIMATED CYCLE TIME: 29s (2.5%)

HOLDER: BT40 - B4C4-1000



T22003 D22003 L22003

TYPE: bullnose end mill

DIAMETER: 8mm

CORNER RADIUS: 0.2mm

LENGTH: 45mm

FLUTES: 5

DESCRIPTION: Sgrossatura tasche 1

PRODUCT: [1K325-0800-XB 1730](#)

MINIMUM Z: -15.75mm

MAXIMUM FEED: 2170mm/min

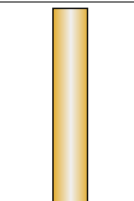
MAXIMUM SPINDLE SPEED: 2170rpm




CUTTING DISTANCE: 6050.69mm

RAPID DISTANCE: 2935.78mm

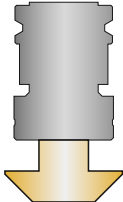
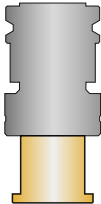


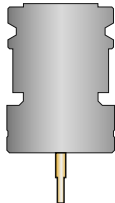
ESTIMATED CYCLE TIME: 11m:0s (57.1%)

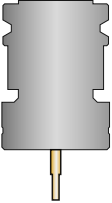


HOLDER: BT40 - B4C4-1000



T22011 D22011 L22011 TYPE: flat end mill DIAMETER: 4mm LENGTH: 40mm FLUTES: 5 DESCRIPTION: Fresa per sgrossatura (tasca piccola) e per finitura totale tasche PRODUCT: 1K334-0400-050-XC 1730	MINIMUM Z: -15.75mm MAXIMUM FEED: 2106.67mm/min MAXIMUM SPINDLE SPEED: 7190rpm CUTTING DISTANCE: 1216.13mm RAPID DISTANCE: 1368.07mm ESTIMATED CYCLE TIME: 2m:1s (10.4%)	
T22013 D22013 L22013 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 1mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: 54_finitura_fondo_tondo VENDOR: mitsubishi PRODUCT: MPMHVRBD0800R100	MINIMUM Z: -16mm MAXIMUM FEED: 1999.2mm/min MAXIMUM SPINDLE SPEED: 6000rpm CUTTING DISTANCE: 434.29mm RAPID DISTANCE: 628.51mm ESTIMATED CYCLE TIME: 29s (2.5%)	
T22014 D22014 L22014 TYPE: ball end mill DIAMETER: 8mm CORNER RADIUS: 4mm LENGTH: 20mm FLUTES: 4 DESCRIPTION: nervatura tonda VENDOR: mitsubishi PRODUCT: fresa a punta tonda VQ4SVBR04000	MINIMUM Z: -16.29mm MAXIMUM FEED: 1900.001mm/min MAXIMUM SPINDLE SPEED: 8000rpm CUTTING DISTANCE: 376.28mm RAPID DISTANCE: 62.53mm ESTIMATED CYCLE TIME: 13s (1.1%)	

Operations

Operation 1/9 DESCRIPTION: 1 Face (2) STRATEGY: Facing WCS: #0 TOLERANCE: 0.03mm MAXIMUM STEPDOWN: 1.02mm MAXIMUM STEPOVER: 41.8mm	MAXIMUM Z: 6.05mm MINIMUM Z: -4.5mm MAXIMUM SPINDLE SPEED: 1500rpm MAXIMUM FEEDRATE: 2390.004mm/min CUTTING DISTANCE: 3585.66mm RAPID DISTANCE: 291.14mm ESTIMATED CYCLE TIME: 1m:35s (8.2%) COOLANT: Flood	T13000 D13000 L13000 TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 0.8mm TAPER ANGLE: 45° LENGTH: 40mm FLUTES: 4 DESCRIPTION: Sgrossatura VENDOR: Sandvik PRODUCT: 345-040Q22-13L	
Operation 2/9 DESCRIPTION: 2 Face (2) STRATEGY: Facing WCS: #0 TOLERANCE: 0.03mm MAXIMUM STEPOVER: 36.74mm	MAXIMUM Z: 3.05mm MINIMUM Z: -5mm MAXIMUM SPINDLE SPEED: 1600rpm MAXIMUM FEEDRATE: 1600.002mm/min CUTTING DISTANCE: 761.78mm RAPID DISTANCE: 5.18mm ESTIMATED CYCLE TIME: 29s (2.5%) COOLANT: Flood	T19000 D19000 L19000 TYPE: face mill DIAMETER: 54.08mm CORNER RADIUS: 0.8mm LENGTH: 45mm FLUTES: 4 DESCRIPTION: Fresa CoroMill 345 per spianatura VENDOR: sandvik PRODUCT: 345-040Q22-13M	
Operation 3/9 DESCRIPTION: 3 Adaptive Clearing (2) STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.05mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 10.8mm OPTIMAL LOAD: 2.4mm LOAD DEVIATION: 0.24mm	MAXIMUM Z: 0.51mm MINIMUM Z: -15.75mm MAXIMUM SPINDLE SPEED: 2170rpm MAXIMUM FEEDRATE: 2170mm/min CUTTING DISTANCE: 6050.69mm RAPID DISTANCE: 2935.78mm ESTIMATED CYCLE TIME: 11m:0s (57.1%) COOLANT: Flood	T22003 D22003 L22003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.2mm LENGTH: 45mm FLUTES: 5 DESCRIPTION: Sgrossatura tasche 1 PRODUCT: 1K325-0800-XB 1730	
Operation 4/9 DESCRIPTION: 4 Adaptive Clearing (2) STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.05mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 8.25mm OPTIMAL LOAD: 1.6mm LOAD DEVIATION: 0.16mm	MAXIMUM Z: 0.51mm MINIMUM Z: -15.75mm MAXIMUM SPINDLE SPEED: 7190rpm MAXIMUM FEEDRATE: 2106.67mm/min CUTTING DISTANCE: 1216.13mm RAPID DISTANCE: 1368.07mm ESTIMATED CYCLE TIME: 2m:1s (10.4%) COOLANT: Flood	T22011 D22011 L22011 TYPE: flat end mill DIAMETER: 4mm LENGTH: 40mm FLUTES: 5 DESCRIPTION: Fresa per sgrossatura (tasca piccola) e per finitura totale tasche PRODUCT: 1K334-0400-050-XC 1730	
Operation 5/9 DESCRIPTION: 5 Flat WCS: #0 TOLERANCE: 0.03mm STOCK TO LEAVE: 0.13mm/0mm MAXIMUM STEPOVER: 2.8mm	MAXIMUM Z: 0.51mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8000rpm MAXIMUM FEEDRATE: 2330mm/min CUTTING DISTANCE: 1197.93mm RAPID DISTANCE: 476.91mm ESTIMATED CYCLE TIME: 38s (3.3%) COOLANT: Flood	T17013 D17013 L17013 TYPE: flat end mill DIAMETER: 4mm LENGTH: 30mm FLUTES: 3 DESCRIPTION: CoroMill Plura FinituraTascheLaterali VENDOR: Sandvik PRODUCT: R216.23-04050CAK11P 1620	

Operation 6/9 DESCRIPTION: 6 2D Contour STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0mm STOCK TO LEAVE: 0mm/0.03mm MAXIMUM STEPDOWN: 9.9mm MAXIMUM STEPOVER: 3.8mm	MAXIMUM Z: 3.05mm MINIMUM Z: -15.97mm MAXIMUM SPINDLE SPEED: 8000rpm MAXIMUM FEEDRATE: 2330mm/min CUTTING DISTANCE: 1237.76mm RAPID DISTANCE: 530.49mm ESTIMATED CYCLE TIME: 1m:8s (5.9%) COOLANT: Flood	T17013 D17013 L17013 TYPE: flat end mill DIAMETER: 4mm LENGTH: 30mm FLUTES: 3 DESCRIPTION: CoroMill Plura FinituraTascheLaterali VENDOR: Sandvik PRODUCT: R216.23-04050CAK11P 1620	
Operation 7/9 DESCRIPTION: 7 Flat WCS: #0 TOLERANCE: 0.03mm STOCK TO LEAVE: 0.13mm/0mm MAXIMUM STEPOVER: 4.2mm	MAXIMUM Z: 0.51mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 6000rpm MAXIMUM FEEDRATE: 1999.2mm/min CUTTING DISTANCE: 278.24mm RAPID DISTANCE: 416.01mm ESTIMATED CYCLE TIME: 14s (1.2%) COOLANT: Flood	T22013 D22013 L22013 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 1mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: 54_finitura_fondo_tondo VENDOR: mitsubishi PRODUCT: MPMHVRBD0800R100	
Operation 8/9 DESCRIPTION: 8 2D Contour STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0mm STOCK TO LEAVE: 0mm/0.03mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM Z: 3.05mm MINIMUM Z: -15.97mm MAXIMUM SPINDLE SPEED: 6000rpm MAXIMUM FEEDRATE: 1999.2mm/min CUTTING DISTANCE: 156.05mm RAPID DISTANCE: 212.5mm ESTIMATED CYCLE TIME: 15s (1.3%) COOLANT: Flood	T22013 D22013 L22013 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 1mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: 54_finitura_fondo_tondo VENDOR: mitsubishi PRODUCT: MPMHVRBD0800R100	
Operation 9/9 DESCRIPTION: 9 Scallop STRATEGY: Scallop WCS: #0 TOLERANCE: 0.03mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.64mm	MAXIMUM Z: 0.51mm MINIMUM Z: -16.29mm MAXIMUM SPINDLE SPEED: 8000rpm MAXIMUM FEEDRATE: 1900.001mm/min CUTTING DISTANCE: 376.28mm RAPID DISTANCE: 62.53mm ESTIMATED CYCLE TIME: 13s (1.1%) COOLANT: Flood	T22014 D22014 L22014 TYPE: ball end mill DIAMETER: 8mm CORNER RADIUS: 4mm LENGTH: 20mm FLUTES: 4 DESCRIPTION: nervatura tonda VENDOR: mitsubishi PRODUCT: fresa a punta tonda VQ4SVBR04000	