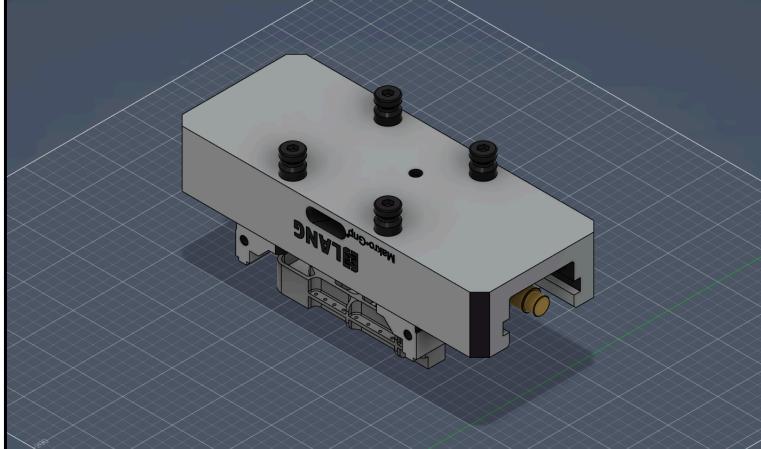


Setup Sheet for Program 1001

JOB DESCRIPTION: AutoSetup 1

DOCUMENT PATH: X_NC02-FORI_EDIT_12100709 v4

Setup	
<p>WCS: #0</p> <p>STOCK: DX: 160mm DY: 95mm DZ: 35mm</p> <p>PART: DX: 150mm DY: 84.87mm DZ: 25mm</p> <p>STOCK LOWER IN WCS #0: X: -80mm Y: -47.5mm Z: -35mm</p> <p>STOCK UPPER IN WCS #0: X: 80mm Y: 47.5mm Z: 0mm</p>	

Total	
NUMBER OF OPERATIONS: 21	
NUMBER OF TOOLS: 12	
TOOLS: T17002 T17003 T17007 T17009 T19004 T19010 T20001 T20002 T20008 T20009 T22007 T22014	
MAXIMUM Z: 15mm	
MINIMUM Z: -30.5mm	
MAXIMUM FEEDRATE: 4307.336mm/min	
MAXIMUM SPINDLE SPEED: 8100rpm	
CUTTING DISTANCE: 28493.96mm	
RAPID DISTANCE: 19180.76mm	
ESTIMATED CYCLE TIME: 28m:53s	

Tools			
T17002 D17002 L17002	TYPE: flat end mill DIAMETER: 2.5mm LENGTH: 21mm FLUTES: 2 DESCRIPTION: CoroMill Plura Tascapiccola VENDOR: Sandvik PRODUCT: 1P250-0250-XA 1630	MINIMUM Z: -15.75mm MAXIMUM FEED: 304.409mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 1886.88mm RAPID DISTANCE: 405.51mm ESTIMATED CYCLE TIME: 6m:17s (21.7%)	HOLDER: BT40 - B4C4-1000
T17003 D17003 L17003	TYPE: flat end mill DIAMETER: 5mm LENGTH: 21mm FLUTES: 4 DESCRIPTION: CoroMill Dura Tasche VENDOR: Sandvik PRODUCT: 2P342-0500-PA 1730	MINIMUM Z: -15.75mm MAXIMUM FEED: 1863.488mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 3654.73mm RAPID DISTANCE: 1201.93mm ESTIMATED CYCLE TIME: 4m:20s (15%)	HOLDER: BT40 - B4C4-1000
T17007 D17007 L17007	TYPE: flat end mill DIAMETER: 25mm LENGTH: 60mm FLUTES: 2 DESCRIPTION: CoroMill 390 Finituraforogrande VENDOR: Sandvik PRODUCT: R390-025A25-17L	MINIMUM Z: -30.5mm MAXIMUM FEED: 3055.775mm/min MAXIMUM SPINDLE SPEED: 7639rpm CUTTING DISTANCE: 1257.85mm RAPID DISTANCE: 59.5mm ESTIMATED CYCLE TIME: 26s (1.5%)	HOLDER: BT40 - B4C4-1000
T17009 D17009 L17009	TYPE: flat end mill DIAMETER: 12mm LENGTH: 60mm FLUTES: 4 DESCRIPTION: CoroMill Dura Finituracontornatura VENDOR: Sandvik PRODUCT: 1K334-1200-XB 1730	MINIMUM Z: -30.2mm MAXIMUM FEED: 3110.4mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 528.63mm RAPID DISTANCE: 112.55mm ESTIMATED CYCLE TIME: 20s (1.2%)	HOLDER: BT40 - B4C4-1000

T19004 D19004 L19004

TYPE: flat end mill

DIAMETER: 4mm

LENGTH: 54mm

FLUTES: 5

DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale

VENDOR: sandvik

PRODUCT: [1K335-0400-020-XC 1730](#)

MINIMUM Z: -15.75mm

MAXIMUM FEED: 1722.935mm/min

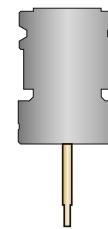
MAXIMUM SPINDLE SPEED: 8100rpm

CUTTING DISTANCE: 1897.4mm

RAPID DISTANCE: 1615.37mm

ESTIMATED CYCLE TIME: 1m:39s (5.7%)

HOLDER: BT40 - B4C4-1000

**T19010 D19010 L19010**

TYPE: bullnose end mill

DIAMETER: 6mm

CORNER RADIUS: 1mm

LENGTH: 57mm

FLUTES: 5

DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale

VENDOR: sandvik

PRODUCT: [1K335-0600-100-XD 1730](#)

MINIMUM Z: -16mm

MAXIMUM FEED: 2584.402mm/min

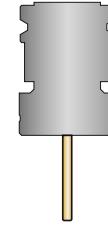
MAXIMUM SPINDLE SPEED: 8100rpm

CUTTING DISTANCE: 807.99mm

RAPID DISTANCE: 1107.48mm

ESTIMATED CYCLE TIME: 57s (3.3%)

HOLDER: BT40 - B4C4-1000

**T20001 D20001 L20001**

TYPE: flat end mill

DIAMETER: 8mm

LENGTH: 40mm

FLUTES: 4

DESCRIPTION: sgrossature tasche

VENDOR: sandvik

PRODUCT: [2P342-0800-PA 1730](#)

MINIMUM Z: -16mm

MAXIMUM FEED: 2756.695mm/min

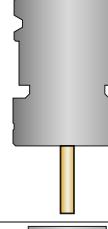
MAXIMUM SPINDLE SPEED: 8100rpm

CUTTING DISTANCE: 2326.38mm

RAPID DISTANCE: 1863.58mm

ESTIMATED CYCLE TIME: 1m:28s (5.1%)

HOLDER: BT40 - B4C4-1000

**T20002 D20002 L20002**

TYPE: flat end mill

DIAMETER: 4.5mm

LENGTH: 35mm

FLUTES: 4

DESCRIPTION: SGROSSATURA TASCHE PICCOLE

VENDOR: SANDVIK

PRODUCT: [1P240-0450-XA 1630](#)

MINIMUM Z: -16mm

MAXIMUM FEED: 1550.641mm/min

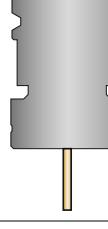
MAXIMUM SPINDLE SPEED: 8100rpm

CUTTING DISTANCE: 1060.68mm

RAPID DISTANCE: 663.72mm

ESTIMATED CYCLE TIME: 1m:19s (4.6%)

HOLDER: BT40 - B4C4-1000

**T20008 D20008 L20008**

TYPE: face mill

DIAMETER: 25mm

CORNER RADIUS: 1.6mm

LENGTH: 50mm

FLUTES: 2

DESCRIPTION: SPALLAMENTO

VENDOR: SANDVIK

PRODUCT: [R390-025A25-17L](#)

MINIMUM Z: -5mm

MAXIMUM FEED: 3055.775mm/min

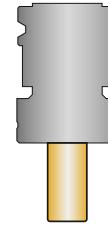
MAXIMUM SPINDLE SPEED: 7639rpm

CUTTING DISTANCE: 2316.34mm

RAPID DISTANCE: 54.75mm

ESTIMATED CYCLE TIME: 1m:1s (3.5%)

HOLDER: BT40 - B4C4-1000

**T20009 D20009 L20009**

TYPE: bullnose end mill

DIAMETER: 10mm

CORNER RADIUS: 0.5mm

LENGTH: 50mm

FLUTES: 5

DESCRIPTION: FORO GRANDE

VENDOR: SANVIK

PRODUCT: [1K335-1000-050-XD 1730](#)

MINIMUM Z: -30.2mm

MAXIMUM FEED: 4307.336mm/min

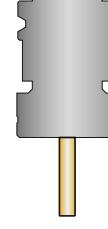
MAXIMUM SPINDLE SPEED: 8100rpm

CUTTING DISTANCE: 10853.89mm

RAPID DISTANCE: 10127.33mm

ESTIMATED CYCLE TIME: 4m:39s (16.1%)

HOLDER: BT40 - B4C4-1000

**T22007 D22007 L22007**

TYPE: drill

DIAMETER: 2.5mm

TIP ANGLE: 140°

LENGTH: 40mm

FLUTES: 2

DESCRIPTION: Punta per fori piccoli

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

MINIMUM Z: -20.91mm

MAXIMUM FEED: 465.75mm/min

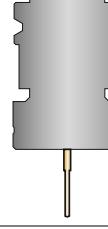
MAXIMUM SPINDLE SPEED: 8100rpm

CUTTING DISTANCE: 627.3mm

RAPID DISTANCE: 1311.37mm

ESTIMATED CYCLE TIME: 1m:37s (5.6%)

HOLDER: BT40 - B4C4-1000

**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: -15.82mm

MAXIMUM FEED: 1900mm/min

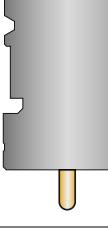
MAXIMUM SPINDLE SPEED: 8100rpm

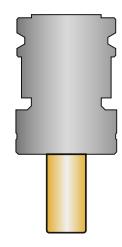
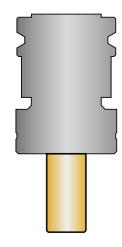
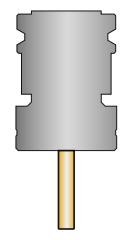
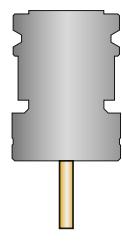
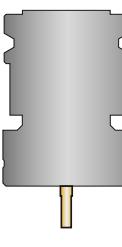
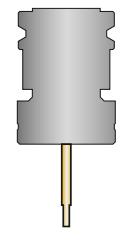
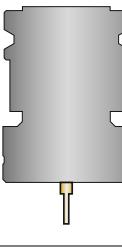
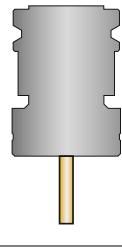
CUTTING DISTANCE: 1275.89mm

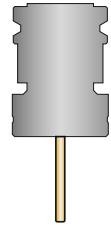
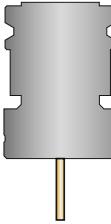
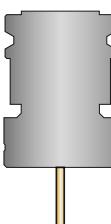
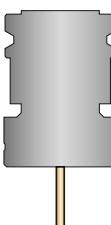
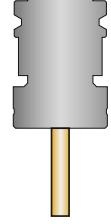
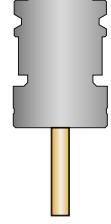
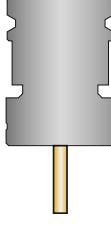
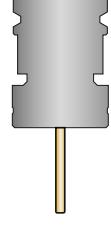
RAPID DISTANCE: 657.67mm

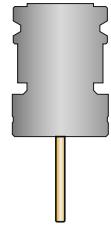
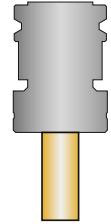
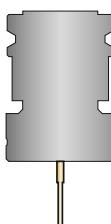
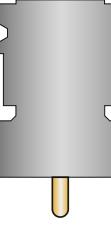
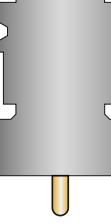
ESTIMATED CYCLE TIME: 1m:6s (3.8%)

HOLDER: BT40 - B4C4-1000

**Operations**

<p>Operation 1/21</p> <p>DESCRIPTION: Roughing</p> <p>STRATEGY: Facing</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>MAXIMUM STEPDOWN: 15.7mm</p> <p>MAXIMUM STEPOVER: 18.75mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -4.75mm</p> <p>MAXIMUM SPINDLE SPEED: 7639rpm</p> <p>MAXIMUM FEEDRATE: 3055.775mm/min</p> <p>CUTTING DISTANCE: 1253.14mm</p> <p>RAPID DISTANCE: 27.25mm</p> <p>ESTIMATED CYCLE TIME: 26s (1.5%)</p> <p>COOLANT: Flood</p>	<p>T20008 D20008 L20008</p> <p>TYPE: face mill</p> <p>DIAMETER: 25mm</p> <p>CORNER RADIUS: 1.6mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: SPALLAMENTO</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: R390-025A25-17L</p>	
<p>Operation 2/21</p> <p>DESCRIPTION: Finishing</p> <p>STRATEGY: Facing</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>MAXIMUM STEPOVER: 22.5mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -5mm</p> <p>MAXIMUM SPINDLE SPEED: 7639rpm</p> <p>MAXIMUM FEEDRATE: 2896.62mm/min</p> <p>CUTTING DISTANCE: 1063.2mm</p> <p>RAPID DISTANCE: 27.5mm</p> <p>ESTIMATED CYCLE TIME: 35s (2%)</p> <p>COOLANT: Flood</p>	<p>T20008 D20008 L20008</p> <p>TYPE: face mill</p> <p>DIAMETER: 25mm</p> <p>CORNER RADIUS: 1.6mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: SPALLAMENTO</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: R390-025A25-17L</p>	
<p>Operation 3/21</p> <p>DESCRIPTION: Roughing</p> <p>STRATEGY: Adaptive</p> <p>WCS: #0</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.25mm</p> <p>MAXIMUM STEPDOWN: 5.15mm</p> <p>OPTIMAL LOAD: 9.5mm</p> <p>LOAD DEVIATION: 0.25mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -30.2mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 4307.336mm/min</p> <p>CUTTING DISTANCE: 10853.89mm</p> <p>RAPID DISTANCE: 10127.33mm</p> <p>ESTIMATED CYCLE TIME: 4m:39s (16.1%)</p> <p>COOLANT: Flood</p>	<p>T20009 D20009 L20009</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 10mm</p> <p>CORNER RADIUS: 0.5mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: FORO GRANDE</p> <p>VENDOR: SANVIK</p> <p>PRODUCT: 1K335-1000-050-XD 1730</p>	
<p>Operation 4/21</p> <p>DESCRIPTION: Roughing1</p> <p>STRATEGY: Adaptive</p> <p>WCS: #0</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.25mm</p> <p>MAXIMUM STEPDOWN: 5.38mm</p> <p>OPTIMAL LOAD: 7.6mm</p> <p>LOAD DEVIATION: 0.2mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -15.75mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 2756.695mm/min</p> <p>CUTTING DISTANCE: 1757.83mm</p> <p>RAPID DISTANCE: 1423.61mm</p> <p>ESTIMATED CYCLE TIME: 57s (3.3%)</p> <p>COOLANT: Flood</p>	<p>T20001 D20001 L20001</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 8mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: sgrossature tasche</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 2P342-0800-PA 1730</p>	
<p>Operation 5/21</p> <p>DESCRIPTION: Roughing2</p> <p>STRATEGY: Adaptive</p> <p>WCS: #0</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.25mm</p> <p>MAXIMUM STEPDOWN: 4.95mm</p> <p>OPTIMAL LOAD: 1.13mm</p> <p>LOAD DEVIATION: 0.11mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -15.75mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1863.488mm/min</p> <p>CUTTING DISTANCE: 3654.73mm</p> <p>RAPID DISTANCE: 1201.93mm</p> <p>ESTIMATED CYCLE TIME: 4m:20s (15%)</p> <p>COOLANT: Flood</p>	<p>T17003 D17003 L17003</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 5mm</p> <p>LENGTH: 21mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura Tasche</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 2P342-0500-PA 1730</p>	
<p>Operation 6/21</p> <p>DESCRIPTION: Roughing3</p> <p>STRATEGY: Adaptive</p> <p>WCS: #0</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.25mm</p> <p>MAXIMUM STEPDOWN: 0.74mm</p> <p>OPTIMAL LOAD: 3.8mm</p> <p>LOAD DEVIATION: 0.1mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -15.75mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1722.935mm/min</p> <p>CUTTING DISTANCE: 1897.4mm</p> <p>RAPID DISTANCE: 1615.37mm</p> <p>ESTIMATED CYCLE TIME: 1m:39s (5.7%)</p> <p>COOLANT: Flood</p>	<p>T19004 D19004 L19004</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4mm</p> <p>LENGTH: 54mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 1K335-0400-020-XC 1730</p>	
<p>Operation 7/21</p> <p>DESCRIPTION: Roughing4</p> <p>STRATEGY: Adaptive</p> <p>WCS: #0</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.25mm</p> <p>MAXIMUM STEPDOWN: 5mm</p> <p>OPTIMAL LOAD: 0.09mm</p> <p>LOAD DEVIATION: 0.01mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -15.75mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 304.409mm/min</p> <p>CUTTING DISTANCE: 1886.88mm</p> <p>RAPID DISTANCE: 405.51mm</p> <p>ESTIMATED CYCLE TIME: 6m:17s (21.7%)</p> <p>COOLANT: Flood</p>	<p>T17002 D17002 L17002</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 2.5mm</p> <p>LENGTH: 21mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: CoroMill Plura Tascapiccola</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1P250-0250-XA 1630</p>	
<p>Operation 8/21</p> <p>DESCRIPTION: Flat</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0.27mm/0mm</p> <p>MAXIMUM STEPOVER: 5.6mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 2370.136mm/min</p> <p>CUTTING DISTANCE: 292.12mm</p> <p>RAPID DISTANCE: 251.5mm</p> <p>ESTIMATED CYCLE TIME: 12s (0.7%)</p> <p>COOLANT: Flood</p>	<p>T20001 D20001 L20001</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 8mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: sgrossature tasche</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 2P342-0800-PA 1730</p>	

Operation 9/21 DESCRIPTION: Flat1 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 2.8mm	MAXIMUM Z: 15mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2584.402mm/min CUTTING DISTANCE: 332.8mm RAPID DISTANCE: 655.39mm ESTIMATED CYCLE TIME: 19s (1.1%) COOLANT: Flood	T19010 D19010 L19010 TYPE: bullnose end mill DIAMETER: 6mm CORNER RADIUS: 1mm LENGTH: 57mm FLUTES: 5 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-0600-100-XD 1730	
Operation 10/21 DESCRIPTION: Flat2 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 3.15mm	MAXIMUM Z: 15mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1550.641mm/min CUTTING DISTANCE: 462.08mm RAPID DISTANCE: 407.79mm ESTIMATED CYCLE TIME: 24s (1.4%) COOLANT: Flood	T20002 D20002 L20002 TYPE: flat end mill DIAMETER: 4.5mm LENGTH: 35mm FLUTES: 4 DESCRIPTION: SGROSSATURA TASCHE PICCOLE VENDOR: SANDVIK PRODUCT: 1P240-0450-XA 1630	
Operation 11/21 DESCRIPTION: Wall STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8.73mm MAXIMUM STEPOVER: 4.28mm	MAXIMUM Z: 11.9mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 808.957mm/min CUTTING DISTANCE: 331.93mm RAPID DISTANCE: 62.19mm ESTIMATED CYCLE TIME: 28s (1.6%) COOLANT: Flood	T20002 D20002 L20002 TYPE: flat end mill DIAMETER: 4.5mm LENGTH: 35mm FLUTES: 4 DESCRIPTION: SGROSSATURA TASCHE PICCOLE VENDOR: SANDVIK PRODUCT: 1P240-0450-XA 1630	
Operation 12/21 DESCRIPTION: Wall1 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8.73mm MAXIMUM STEPOVER: 4.28mm	MAXIMUM Z: 11.9mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 808.957mm/min CUTTING DISTANCE: 266.66mm RAPID DISTANCE: 193.74mm ESTIMATED CYCLE TIME: 27s (1.6%) COOLANT: Flood	T20002 D20002 L20002 TYPE: flat end mill DIAMETER: 4.5mm LENGTH: 35mm FLUTES: 4 DESCRIPTION: SGROSSATURA TASCHE PICCOLE VENDOR: SANDVIK PRODUCT: 1P240-0450-XA 1630	
Operation 13/21 DESCRIPTION: Wall2 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 26mm MAXIMUM STEPOVER: 11.4mm	MAXIMUM Z: 12mm MINIMUM Z: -30mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3110.4mm/min CUTTING DISTANCE: 45.46mm RAPID DISTANCE: 55.55mm ESTIMATED CYCLE TIME: 6s (0.3%) COOLANT: Flood	T17009 D17009 L17009 TYPE: flat end mill DIAMETER: 12mm LENGTH: 60mm FLUTES: 4 DESCRIPTION: CoroMill Dura Finituracontornatura VENDOR: Sandvik PRODUCT: 1K334-1200-XB 1730	
Operation 14/21 DESCRIPTION: Wall3 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 26mm MAXIMUM STEPOVER: 11.4mm	MAXIMUM Z: 12mm MINIMUM Z: -30.2mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3110.4mm/min CUTTING DISTANCE: 483.17mm RAPID DISTANCE: 57mm ESTIMATED CYCLE TIME: 14s (0.8%) COOLANT: Flood	T17009 D17009 L17009 TYPE: flat end mill DIAMETER: 12mm LENGTH: 60mm FLUTES: 4 DESCRIPTION: CoroMill Dura Finituracontornatura VENDOR: Sandvik PRODUCT: 1K334-1200-XB 1730	
Operation 15/21 DESCRIPTION: Wall4 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 17.5mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM Z: 12mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1620mm/min CUTTING DISTANCE: 276.42mm RAPID DISTANCE: 188.46mm ESTIMATED CYCLE TIME: 19s (1.1%) COOLANT: Flood	T20001 D20001 L20001 TYPE: flat end mill DIAMETER: 8mm LENGTH: 40mm FLUTES: 4 DESCRIPTION: sgrossature tasche VENDOR: sandvik PRODUCT: 2P342-0800-PA 1730	
Operation 16/21 DESCRIPTION: Wall5 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 4.87mm MAXIMUM STEPOVER: 3.8mm	MAXIMUM Z: 12mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1525.299mm/min CUTTING DISTANCE: 165.57mm RAPID DISTANCE: 134.29mm ESTIMATED CYCLE TIME: 13s (0.7%) COOLANT: Flood	T19010 D19010 L19010 TYPE: bullnose end mill DIAMETER: 6mm CORNER RADIUS: 1mm LENGTH: 57mm FLUTES: 5 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-0600-100-XD 1730	

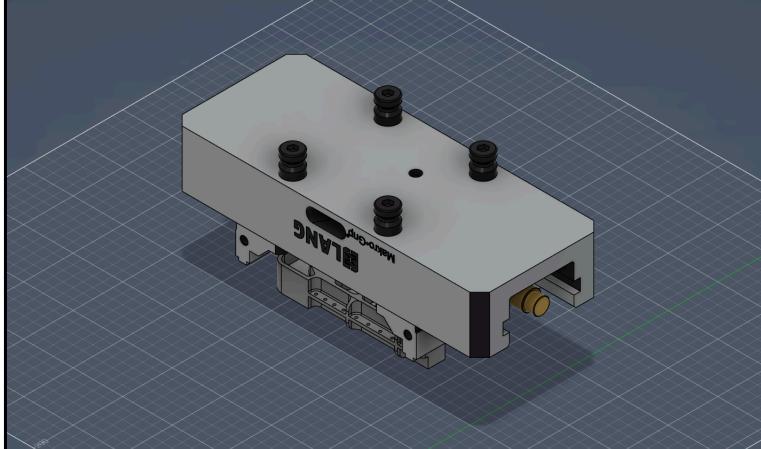
Operation 17/21 DESCRIPTION: Wall6 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 4.87mm MAXIMUM STEPOVER: 3.8mm	MAXIMUM Z: 12mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1525.299mm/min CUTTING DISTANCE: 309.62mm RAPID DISTANCE: 317.81mm ESTIMATED CYCLE TIME: 25s (1.5%) COOLANT: Flood	T19010 D19010 L19010 TYPE: bullnose end mill DIAMETER: 6mm CORNER RADIUS: 1mm LENGTH: 57mm FLUTES: 5 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-0600-100-XD 1730	
Operation 18/21 DESCRIPTION: Holesmaking STRATEGY: Bore WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM Z: 15mm MINIMUM Z: -30.5mm MAXIMUM SPINDLE SPEED: 7639rpm MAXIMUM FEEDRATE: 3055.775mm/min CUTTING DISTANCE: 1257.85mm RAPID DISTANCE: 59.5mm ESTIMATED CYCLE TIME: 26s (1.5%) COOLANT: Flood	T17007 D17007 L17007 TYPE: flat end mill DIAMETER: 25mm LENGTH: 60mm FLUTES: 2 DESCRIPTION: CoroMill 390 Finituraforogrande VENDOR: Sandvik PRODUCT: R390-025A25-17L	
Operation 19/21 DESCRIPTION: Holesmaking1 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM Z: 15mm MINIMUM Z: -20.91mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 465.75mm/min CUTTING DISTANCE: 627.3mm RAPID DISTANCE: 1311.37mm ESTIMATED CYCLE TIME: 1m:37s (5.6%) COOLANT: Flood	T22007 D22007 L22007 TYPE: drill DIAMETER: 2.5mm TIP ANGLE: 140° LENGTH: 40mm FLUTES: 2 DESCRIPTION: Punta per fori piccoli VENDOR: sandvik PRODUCT: 862.1-2500-225A0-GM X2BL	
Operation 20/21 DESCRIPTION: Freeform STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.56mm	MAXIMUM Z: 15mm MINIMUM Z: -15.82mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1900mm/min CUTTING DISTANCE: 853.68mm RAPID DISTANCE: 557.9mm ESTIMATED CYCLE TIME: 45s (2.6%) 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	
Operation 21/21 DESCRIPTION: Freeform1 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.28mm	MAXIMUM Z: 15mm MINIMUM Z: -7.08mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1900mm/min CUTTING DISTANCE: 422.21mm RAPID DISTANCE: 99.77mm ESTIMATED CYCLE TIME: 21s (1.2%) 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	

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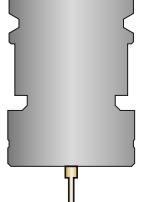
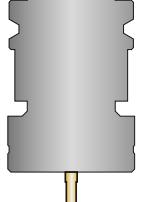
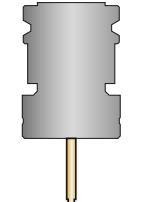
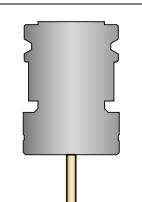
Setup Sheet for Program 1002

JOB DESCRIPTION: AutoSetup 2

DOCUMENT PATH: X_NC02-FORI_EDIT_12100709 v4

Setup	
<p>WCS: #0</p> <p>STOCK: DX: 160mm DY: 95mm DZ: 35mm</p> <p>PART: DX: 150mm DY: 84.87mm DZ: 25mm</p> <p>STOCK LOWER IN WCS #0: X: -80mm Y: -47.5mm Z: -35mm</p> <p>STOCK UPPER IN WCS #0: X: 80mm Y: 47.5mm Z: 0mm</p>	

Total	
<p>NUMBER OF OPERATIONS: 16</p> <p>NUMBER OF TOOLS: 7</p> <p>TOOLS: T17002 T17003 T19004 T19010 T20001 T20002 T22014</p> <p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM FEEDRATE: 2756.695mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>CUTTING DISTANCE: 26547.45mm</p> <p>RAPID DISTANCE: 13970.18mm</p> <p>ESTIMATED CYCLE TIME: 30m:40s</p>	

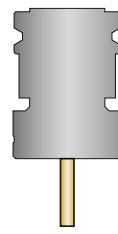
Tools			
T17002 D17002 L17002	TYPE: flat end mill	MINIMUM Z: -15.75mm	HOLDER: BT40 - B4C4-1000
	DIAMETER: 2.5mm	MAXIMUM FEED: 304.409mm/min	
	LENGTH: 21mm	MAXIMUM SPINDLE SPEED: 8100rpm	
	FLUTES: 2	CUTTING DISTANCE: 2464.1mm	
	DESCRIPTION: CoroMill Plura Tascapiccola	RAPID DISTANCE: 662.68mm	
	VENDOR: Sandvik	ESTIMATED CYCLE TIME: 8m:14s (26.8%)	
	PRODUCT: 1P250-0250-XA 1630		
T17003 D17003 L17003	TYPE: flat end mill	MINIMUM Z: -15.75mm	HOLDER: BT40 - B4C4-1000
	DIAMETER: 5mm	MAXIMUM FEED: 1863.488mm/min	
	LENGTH: 21mm	MAXIMUM SPINDLE SPEED: 8100rpm	
	FLUTES: 4	CUTTING DISTANCE: 5366.8mm	
	DESCRIPTION: CoroMill Dura Tasche	RAPID DISTANCE: 1635.91mm	
	VENDOR: Sandvik	ESTIMATED CYCLE TIME: 7m:31s (24.5%)	
	PRODUCT: 2P342-0500-PA 1730		
T19004 D19004 L19004	TYPE: flat end mill	MINIMUM Z: -15.75mm	HOLDER: BT40 - B4C4-1000
	DIAMETER: 4mm	MAXIMUM FEED: 1722.935mm/min	
	LENGTH: 54mm	MAXIMUM SPINDLE SPEED: 8100rpm	
	FLUTES: 5	CUTTING DISTANCE: 1892.61mm	
	DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale	RAPID DISTANCE: 1567.63mm	
	VENDOR: sandvik	ESTIMATED CYCLE TIME: 1m:37s (5.3%)	
	PRODUCT: 1K335-0400-020-XC 1730		
T19010 D19010 L19010	TYPE: bullnose end mill	MINIMUM Z: -16mm	HOLDER: BT40 - B4C4-1000
	DIAMETER: 6mm	MAXIMUM FEED: 2584.402mm/min	
	CORNER RADIUS: 1mm	MAXIMUM SPINDLE SPEED: 8100rpm	
	LENGTH: 57mm	CUTTING DISTANCE: 1079.78mm	
	FLUTES: 5	RAPID DISTANCE: 1577.58mm	
	DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale	ESTIMATED CYCLE TIME: 1m:12s (3.9%)	
	VENDOR: sandvik		
	PRODUCT: 1K335-0600-100-XD 1730		

T20001 D20001 L20001

TYPE: flat end mill
DIAMETER: 8mm
LENGTH: 40mm
FLUTES: 4
DESCRIPTION: sgrossature tasche
VENDOR: sandvik
PRODUCT: [2P342-0800-PA 1730](#)

MINIMUM Z: -16mm
MAXIMUM FEED: 2756.695mm/min
MAXIMUM SPINDLE SPEED: 8100rpm
CUTTING DISTANCE: 13411.61mm
RAPID DISTANCE: 7281.46mm
ESTIMATED CYCLE TIME: 6m:58s (22.7%)

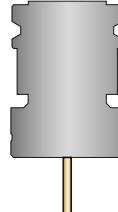
HOLDER: BT40 - B4C4-1000

**T20002** D20002 L20002

TYPE: flat end mill
DIAMETER: 4.5mm
LENGTH: 35mm
FLUTES: 4
DESCRIPTION: SGROSSATURA TASCHE PICCOLE
VENDOR: SANDVIK
PRODUCT: [1P240-0450-XA 1630](#)

MINIMUM Z: -16mm
MAXIMUM FEED: 1550.641mm/min
MAXIMUM SPINDLE SPEED: 8100rpm
CUTTING DISTANCE: 1061.95mm
RAPID DISTANCE: 588.42mm
ESTIMATED CYCLE TIME: 1m:19s (4.3%)

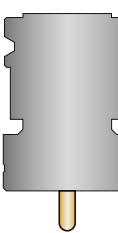
HOLDER: BT40 - B4C4-1000

**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: -15.82mm
MAXIMUM FEED: 1900mm/min
MAXIMUM SPINDLE SPEED: 8100rpm
CUTTING DISTANCE: 1270.6mm
RAPID DISTANCE: 656.51mm
ESTIMATED CYCLE TIME: 1m:5s (3.6%)

HOLDER: BT40 - B4C4-1000

**Operations**

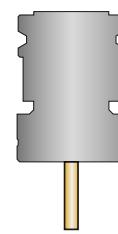
Operation 1/16

DESCRIPTION: Roughing
STRATEGY: Adaptive
WCS: #0
TOLERANCE: 0.1mm
STOCK TO LEAVE: 0.25mm
MAXIMUM STEPDOWN: 5.38mm
OPTIMAL LOAD: 7.6mm
LOAD DEVIATION: 0.2mm

MAXIMUM Z: 15mm
MINIMUM Z: -16mm
MAXIMUM SPINDLE SPEED: 8100rpm
MAXIMUM FEEDRATE: 2756.695mm/min
CUTTING DISTANCE: 11499mm
RAPID DISTANCE: 6647.99mm
ESTIMATED CYCLE TIME: 5m:49s (19%)
COOLANT: Flood

T20001 D20001 L20001

TYPE: flat end mill
DIAMETER: 8mm
LENGTH: 40mm
FLUTES: 4
DESCRIPTION: sgrossature tasche
VENDOR: sandvik
PRODUCT: [2P342-0800-PA 1730](#)



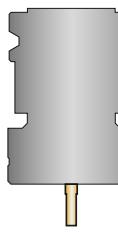
Operation 2/16

DESCRIPTION: Roughing1
STRATEGY: Adaptive
WCS: #0
TOLERANCE: 0.1mm
STOCK TO LEAVE: 0.25mm
MAXIMUM STEPDOWN: 4.95mm
OPTIMAL LOAD: 1.13mm
LOAD DEVIATION: 0.11mm

MAXIMUM Z: 15mm
MINIMUM Z: -15.75mm
MAXIMUM SPINDLE SPEED: 8100rpm
MAXIMUM FEEDRATE: 1863.488mm/min
CUTTING DISTANCE: 5366.8mm
RAPID DISTANCE: 1635.91mm
ESTIMATED CYCLE TIME: 7m:31s (24.5%)
COOLANT: Flood

T17003 D17003 L17003

TYPE: flat end mill
DIAMETER: 5mm
LENGTH: 21mm
FLUTES: 4
DESCRIPTION: CoroMill Dura Tasche
VENDOR: Sandvik
PRODUCT: [2P342-0500-PA 1730](#)



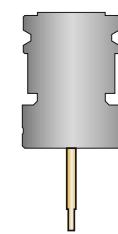
Operation 3/16

DESCRIPTION: Roughing2
STRATEGY: Adaptive
WCS: #0
TOLERANCE: 0.1mm
STOCK TO LEAVE: 0.25mm
MAXIMUM STEPDOWN: 0.74mm
OPTIMAL LOAD: 3.8mm
LOAD DEVIATION: 0.1mm

MAXIMUM Z: 15mm
MINIMUM Z: -15.75mm
MAXIMUM SPINDLE SPEED: 8100rpm
MAXIMUM FEEDRATE: 1722.935mm/min
CUTTING DISTANCE: 1892.61mm
RAPID DISTANCE: 1567.63mm
ESTIMATED CYCLE TIME: 1m:37s (5.3%)
COOLANT: Flood

T19004 D19004 L19004

TYPE: flat end mill
DIAMETER: 4mm
LENGTH: 54mm
FLUTES: 5
DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale
VENDOR: sandvik
PRODUCT: [1K335-0400-020-XC 1730](#)



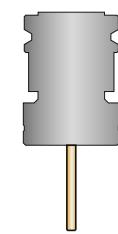
Operation 4/16

DESCRIPTION: Roughing3
STRATEGY: Adaptive
WCS: #0
TOLERANCE: 0.1mm
STOCK TO LEAVE: 0.25mm
MAXIMUM STEPDOWN: 0.67mm
OPTIMAL LOAD: 5mm
LOAD DEVIATION: 0.5mm

MAXIMUM Z: 15mm
MINIMUM Z: -8.75mm
MAXIMUM SPINDLE SPEED: 7945rpm
MAXIMUM FEEDRATE: 1679.133mm/min
CUTTING DISTANCE: 259.85mm
RAPID DISTANCE: 587.37mm
ESTIMATED CYCLE TIME: 16s (0.9%)
COOLANT: Flood

T19010 D19010 L19010

TYPE: bullnose end mill
DIAMETER: 6mm
CORNER RADIUS: 1mm
LENGTH: 57mm
FLUTES: 5
DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale
VENDOR: sandvik
PRODUCT: [1K335-0600-100-XD 1730](#)



Operation 5/16

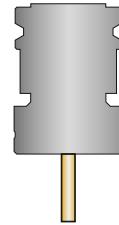
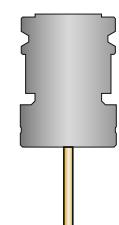
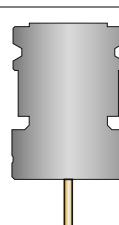
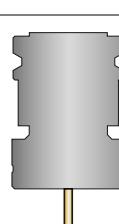
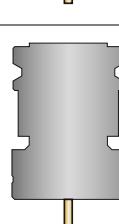
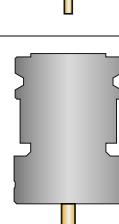
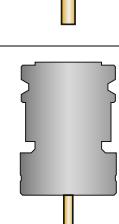
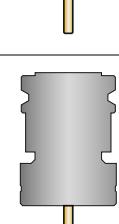
DESCRIPTION: Roughing4
STRATEGY: Adaptive
WCS: #0
TOLERANCE: 0.1mm
STOCK TO LEAVE: 0.25mm
MAXIMUM STEPDOWN: 5mm
OPTIMAL LOAD: 0.09mm
LOAD DEVIATION: 0.01mm

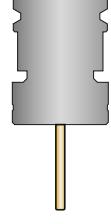
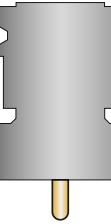
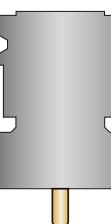
MAXIMUM Z: 15mm
MINIMUM Z: -15.75mm
MAXIMUM SPINDLE SPEED: 8100rpm
MAXIMUM FEEDRATE: 304.409mm/min
CUTTING DISTANCE: 2464.1mm
RAPID DISTANCE: 662.68mm
ESTIMATED CYCLE TIME: 8m:14s (26.8%)
COOLANT: Flood

T17002 D17002 L17002

TYPE: flat end mill
DIAMETER: 2.5mm
LENGTH: 21mm
FLUTES: 2
DESCRIPTION: CoroMill Plura Tascapiccola
VENDOR: Sandvik
PRODUCT: [1P250-0250-XA 1630](#)



Operation 6/16 DESCRIPTION: Flat WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 5.6mm	MAXIMUM Z: 15mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2370.136mm/min CUTTING DISTANCE: 1636.19mm RAPID DISTANCE: 389.74mm ESTIMATED CYCLE TIME: 49s (2.7%) COOLANT: Flood	T20001 D20001 L20001 TYPE: flat end mill DIAMETER: 8mm LENGTH: 40mm FLUTES: 4 DESCRIPTION: sgrossature tasche VENDOR: sandvik PRODUCT: 2P342-0800-PA 1730	
Operation 7/16 DESCRIPTION: Flat1 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 2.8mm	MAXIMUM Z: 15mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2584.402mm/min CUTTING DISTANCE: 344.74mm RAPID DISTANCE: 586.91mm ESTIMATED CYCLE TIME: 18s (1%) COOLANT: Flood	T19010 D19010 L19010 TYPE: bullnose end mill DIAMETER: 6mm CORNER RADIUS: 1mm LENGTH: 57mm FLUTES: 5 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-0600-100-XD 1730	
Operation 8/16 DESCRIPTION: Flat2 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 3.15mm	MAXIMUM Z: 15mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1550.641mm/min CUTTING DISTANCE: 463.35mm RAPID DISTANCE: 349.39mm ESTIMATED CYCLE TIME: 23s (1.3%) COOLANT: Flood	T20002 D20002 L20002 TYPE: flat end mill DIAMETER: 4.5mm LENGTH: 35mm FLUTES: 4 DESCRIPTION: SGROSSATURA TASCHE PICCOLE VENDOR: SANDVIK PRODUCT: 1P240-0450-XA 1630	
Operation 9/16 DESCRIPTION: Wall STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8.73mm MAXIMUM STEPOVER: 4.28mm	MAXIMUM Z: 11.9mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 808.957mm/min CUTTING DISTANCE: 331.93mm RAPID DISTANCE: 62.19mm ESTIMATED CYCLE TIME: 28s (1.5%) COOLANT: Flood	T20002 D20002 L20002 TYPE: flat end mill DIAMETER: 4.5mm LENGTH: 35mm FLUTES: 4 DESCRIPTION: SGROSSATURA TASCHE PICCOLE VENDOR: SANDVIK PRODUCT: 1P240-0450-XA 1630	
Operation 10/16 DESCRIPTION: Wall1 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 8.73mm MAXIMUM STEPOVER: 4.28mm	MAXIMUM Z: 11.9mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 808.957mm/min CUTTING DISTANCE: 266.66mm RAPID DISTANCE: 176.84mm ESTIMATED CYCLE TIME: 27s (1.5%) COOLANT: Flood	T20002 D20002 L20002 TYPE: flat end mill DIAMETER: 4.5mm LENGTH: 35mm FLUTES: 4 DESCRIPTION: SGROSSATURA TASCHE PICCOLE VENDOR: SANDVIK PRODUCT: 1P240-0450-XA 1630	
Operation 11/16 DESCRIPTION: Wall2 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 17.5mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM Z: 12mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1620mm/min CUTTING DISTANCE: 276.42mm RAPID DISTANCE: 243.73mm ESTIMATED CYCLE TIME: 20s (1.1%) COOLANT: Flood	T20001 D20001 L20001 TYPE: flat end mill DIAMETER: 8mm LENGTH: 40mm FLUTES: 4 DESCRIPTION: sgrossature tasche VENDOR: sandvik PRODUCT: 2P342-0800-PA 1730	
Operation 12/16 DESCRIPTION: Wall3 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 4.87mm MAXIMUM STEPOVER: 3.8mm	MAXIMUM Z: 12mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1525.299mm/min CUTTING DISTANCE: 165.57mm RAPID DISTANCE: 134.29mm ESTIMATED CYCLE TIME: 13s (0.7%) COOLANT: Flood	T19010 D19010 L19010 TYPE: bullnose end mill DIAMETER: 6mm CORNER RADIUS: 1mm LENGTH: 57mm FLUTES: 5 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-0600-100-XD 1730	
Operation 13/16 DESCRIPTION: Wall4 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 4.87mm MAXIMUM STEPOVER: 3.8mm	MAXIMUM Z: 12mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1525.299mm/min CUTTING DISTANCE: 191.1mm RAPID DISTANCE: 151.32mm ESTIMATED CYCLE TIME: 14s (0.8%) COOLANT: Flood	T19010 D19010 L19010 TYPE: bullnose end mill DIAMETER: 6mm CORNER RADIUS: 1mm LENGTH: 57mm FLUTES: 5 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-0600-100-XD 1730	

Operation 14/16 DESCRIPTION: Wall5 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 4.87mm MAXIMUM STEPOVER: 3.8mm	MAXIMUM Z: 12mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1525.299mm/min CUTTING DISTANCE: 118.52mm RAPID DISTANCE: 117.7mm ESTIMATED CYCLE TIME: 11s (0.6%) COOLANT: Flood	T19010 D19010 L19010 TYPE: bullnose end mill DIAMETER: 6mm CORNER RADIUS: 1mm LENGTH: 57mm FLUTES: 5 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-0600-100-XD 1730	
Operation 15/16 DESCRIPTION: Freeform STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.56mm	MAXIMUM Z: 15mm MINIMUM Z: -15.82mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1900mm/min CUTTING DISTANCE: 853.56mm RAPID DISTANCE: 557.83mm ESTIMATED CYCLE TIME: 45s (2.4%) 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	
Operation 16/16 DESCRIPTION: Freeform1 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.28mm	MAXIMUM Z: 15mm MINIMUM Z: -7.08mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1900mm/min CUTTING DISTANCE: 417.03mm RAPID DISTANCE: 98.69mm ESTIMATED CYCLE TIME: 21s (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	

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