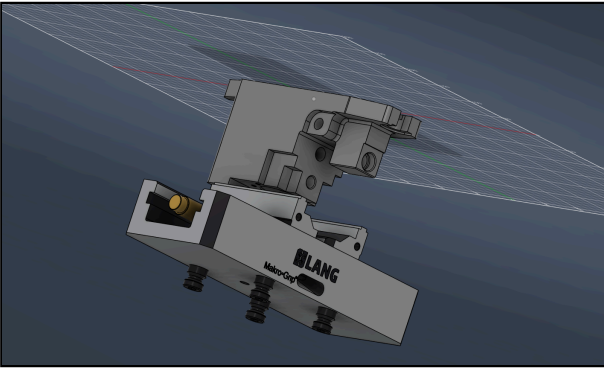
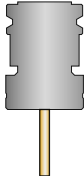
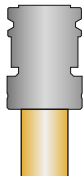
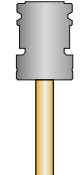
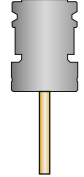
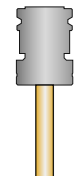
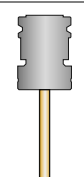


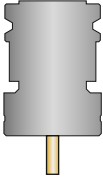
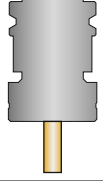
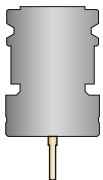
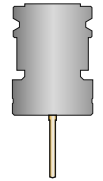
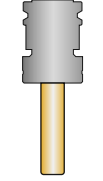
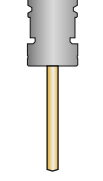
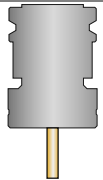
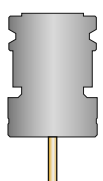
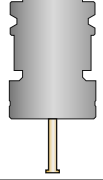
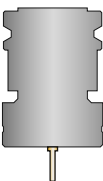
Setup Sheet for Program 1001

JOB DESCRIPTION: AutoSetup 1
DOCUMENT PATH: 0NC02_DFM_0102 v2

Setup	
WCS: #0 Stock: DX: 244mm DY: 85mm DZ: 120mm PART: DX: 234mm DY: 75mm DZ: 110mm Stock LOWER in WCS #0: X: -122mm Y: -42.5mm Z: -120mm Stock UPPER in WCS #0: X: 122mm Y: 42.5mm Z: 0mm	

Total
NUMBER OF OPERATIONS: 60 NUMBER OF TOOLS: 16 TOOLS: T10003 T10109 T10110 T10112 T10113 T10120 T11005 T11008 T11011 T11013 T11104 T11112 T11115 T11116 T11119 T11124 MAXIMUM FEEDRATE: 7637.242mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 60845.03mm RAPID DISTANCE: 59510.28mm ESTIMATED CYCLE TIME: 49m:5s

Tools			
T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730	MAXIMUM FEED: 1780mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 4335.48mm RAPID DISTANCE: 4306mm ESTIMATED CYCLE TIME: 5m:47s (11.8%)	HOLDER: BT40 - B4C4-1000	
T10109 D10109 L10109 TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 1.2mm LENGTH: 60mm FLUTES: 3 DESCRIPTION: Fresa per lavorazione grossa tasca centrale VENDOR: Sandvik PRODUCT: R390-040C4-18M060	MAXIMUM FEED: 2864.789mm/min MAXIMUM SPINDLE SPEED: 4775rpm CUTTING DISTANCE: 1926.11mm RAPID DISTANCE: 51.75mm ESTIMATED CYCLE TIME: 48s (1.6%)	HOLDER: BT40 - B4C4-1000	
T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730	MAXIMUM FEED: 4458.366mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 5793.73mm RAPID DISTANCE: 4729.38mm ESTIMATED CYCLE TIME: 7m:30s (15.3%)	HOLDER: BT40 - B4C4-1000	
T10112 D10112 L10112 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216.24-10050CCK22P 1620	MAXIMUM FEED: 3057.303mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 1263.12mm RAPID DISTANCE: 1712.18mm ESTIMATED CYCLE TIME: 1m:13s (2.5%)	HOLDER: BT40 - B4C4-1000	
T10113 D10113 L10113 TYPE: drill DIAMETER: 20mm TIP ANGLE: 147° LENGTH: 110mm FLUTES: 2 DESCRIPTION: Punta a forare M20 H8 VENDOR: Sandvik PRODUCT: 860.1-2000-077A1-PM P1BM	MAXIMUM FEED: 576.357mm/min MAXIMUM SPINDLE SPEED: 1253rpm CUTTING DISTANCE: 97.56mm RAPID DISTANCE: 127.56mm ESTIMATED CYCLE TIME: 12s (0.4%)	HOLDER: BT40 - B4C4-1000	
T10120 D10120 L10120 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 120mm FLUTES: 2 DESCRIPTION: Punta a forare M12 H8 VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM	MAXIMUM FEED: 535.906mm/min MAXIMUM SPINDLE SPEED: 1942rpm CUTTING DISTANCE: 205.17mm RAPID DISTANCE: 265.17mm ESTIMATED CYCLE TIME: 26s (0.9%)	HOLDER: BT40 - B4C4-1000	

T11005 D11005 L11005 TYPE: flat end mill DIAMETER: 8mm LENGTH: 25.4mm FLUTES: 5 DESCRIPTION: tasche superiori 1 VENDOR: Sandvik PRODUCT: 2N342-0800-PD	MAXIMUM FEED: 3445.869mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 643.94mm RAPID DISTANCE: 2233.15mm ESTIMATED CYCLE TIME: 38s (1.3%)	HOLDER: BT40 - B4C4-1000	
T11008 D11008 L11008 TYPE: flat end mill DIAMETER: 12.7mm LENGTH: 37.1mm FLUTES: 5 DESCRIPTION: Spallamento fori VENDOR: Sandvik PRODUCT: 2N342-1270-PD	MAXIMUM FEED: 5470.317mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 24658.88mm RAPID DISTANCE: 32639.57mm ESTIMATED CYCLE TIME: 11m:7s (22.6%)	HOLDER: BT40 - B4C4-1000	
T11011 D11011 L11011 TYPE: drill DIAMETER: 4.2mm TIP ANGLE: 147° LENGTH: 30mm FLUTES: 2 DESCRIPTION: Prefori 4.2mm VENDOR: Sandvik PRODUCT: 860.1-0420-018A0-PM	MAXIMUM FEED: 582.761mm/min MAXIMUM SPINDLE SPEED: 6033rpm CUTTING DISTANCE: 41.24mm RAPID DISTANCE: 251.24mm ESTIMATED CYCLE TIME: 7s (0.2%)	HOLDER: BT40 - B4C4-1000	
T11013 D11013 L11013 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	MAXIMUM FEED: 535.801mm/min MAXIMUM SPINDLE SPEED: 5177rpm CUTTING DISTANCE: 52.59mm RAPID DISTANCE: 82.59mm ESTIMATED CYCLE TIME: 7s (0.2%)	HOLDER: BT40 - B4C4-1000	
T11104 D11104 L11104 TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P	MAXIMUM FEED: 7637.242mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 7179.74mm RAPID DISTANCE: 2759.06mm ESTIMATED CYCLE TIME: 4m:36s (9.4%)	HOLDER: BT40 - B4C4-1000	
T11112 D11112 L11112 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: 536.129mm/min MAXIMUM SPINDLE SPEED: 1665rpm CUTTING DISTANCE: 128.11mm RAPID DISTANCE: 158.11mm ESTIMATED CYCLE TIME: 16s (0.6%)	HOLDER: BT40 - B4C4-1000	
T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	MAXIMUM FEED: 3445.869mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 3919.72mm RAPID DISTANCE: 3731.62mm ESTIMATED CYCLE TIME: 2m:31s (5.1%)	HOLDER: BT40 - B4C4-1000	
T11116 D11116 L11116 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: 1960.79mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 465.98mm RAPID DISTANCE: 249.26mm ESTIMATED CYCLE TIME: 40s (1.3%)	HOLDER: BT40 - B4C4-1000	
T11119 D11119 L11119 TYPE: slot mill DIAMETER: 10mm LENGTH: 40mm FLUTES: 7 DESCRIPTION: Prova 2 S2 contour	MAXIMUM FEED: 2430mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 90.65mm RAPID DISTANCE: 113mm ESTIMATED CYCLE TIME: 4s (0.1%)	HOLDER: BT40 - B4C4-1000	
T11124 D11124 L11124 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: 1669.917mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 10043mm RAPID DISTANCE: 6100.63mm ESTIMATED CYCLE TIME: 7m:34s (15.4%)	HOLDER: BT40 - B4C4-1000	

Operation 1/60 DESCRIPTION: Roughing STRATEGY: Facing WCS: #0 TOLERANCE: 0.01mm MAXIMUM STEPDOWN: 14.63mm MAXIMUM STEPOVER: 30mm	MAXIMUM SPINDLE SPEED: 3795rpm MAXIMUM FEEDRATE: 2277.197mm/min CUTTING DISTANCE: 962.99mm RAPID DISTANCE: 25.75mm ESTIMATED CYCLE TIME: 26s (0.9%) COOLANT: Flood	T10109 D10109 L10109 TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 1.2mm LENGTH: 60mm FLUTES: 3 DESCRIPTION: Fresa per lavorazione grossa tasca centrale VENDOR: Sandvik PRODUCT: R390-040C4-18M060
Operation 2/60 DESCRIPTION: Finishing STRATEGY: Facing WCS: #0 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 36mm	MAXIMUM SPINDLE SPEED: 4775rpm MAXIMUM FEEDRATE: 2864.789mm/min CUTTING DISTANCE: 963.12mm RAPID DISTANCE: 26mm ESTIMATED CYCLE TIME: 21s (0.7%) COOLANT: Flood	T10109 D10109 L10109 TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 1.2mm LENGTH: 60mm FLUTES: 3 DESCRIPTION: Fresa per lavorazione grossa tasca centrale VENDOR: Sandvik PRODUCT: R390-040C4-18M060
Operation 3/60 DESCRIPTION: Roughing STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 10.9mm OPTIMAL LOAD: 12.07mm LOAD DEVIATION: 0.32mm NOTES:	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5470.317mm/min CUTTING DISTANCE: 6746.96mm RAPID DISTANCE: 8438.57mm ESTIMATED CYCLE TIME: 2m:57s (6%) COOLANT: Flood	T11008 D11008 L11008 TYPE: flat end mill DIAMETER: 12.7mm LENGTH: 37.1mm FLUTES: 5 DESCRIPTION: Spallamento fori VENDOR: Sandvik PRODUCT: 2N342-1270-PD
This roughing operation may lead to collisions with the shaft or holder, due to a known limitation in Fusion. Enabling Shaft & Holder might help but results vary. Please check the See details in https://cloudnc.atlassian.net/wiki/x/AYCREg		
Operation 4/60 DESCRIPTION: Roughing1 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 10.9mm OPTIMAL LOAD: 12.07mm LOAD DEVIATION: 0.32mm NOTES:	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5470.317mm/min CUTTING DISTANCE: 7424.93mm RAPID DISTANCE: 7671.31mm ESTIMATED CYCLE TIME: 2m:55s (5.9%) COOLANT: Flood	T11008 D11008 L11008 TYPE: flat end mill DIAMETER: 12.7mm LENGTH: 37.1mm FLUTES: 5 DESCRIPTION: Spallamento fori VENDOR: Sandvik PRODUCT: 2N342-1270-PD
This roughing operation may lead to collisions with the shaft or holder, due to a known limitation in Fusion. Enabling Shaft & Holder might help but results vary. Please check the See details in https://cloudnc.atlassian.net/wiki/x/AYCREg		
Operation 5/60 DESCRIPTION: Roughing2 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 10.9mm OPTIMAL LOAD: 12.07mm LOAD DEVIATION: 0.32mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5470.317mm/min CUTTING DISTANCE: 3683.53mm RAPID DISTANCE: 3895.25mm ESTIMATED CYCLE TIME: 1m:28s (3%) COOLANT: Flood	T11008 D11008 L11008 TYPE: flat end mill DIAMETER: 12.7mm LENGTH: 37.1mm FLUTES: 5 DESCRIPTION: Spallamento fori VENDOR: Sandvik PRODUCT: 2N342-1270-PD
Operation 6/60 DESCRIPTION: Roughing3 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 10.9mm OPTIMAL LOAD: 12.07mm LOAD DEVIATION: 0.32mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5470.317mm/min CUTTING DISTANCE: 3852.71mm RAPID DISTANCE: 7208.78mm ESTIMATED CYCLE TIME: 2m:10s (4.4%) COOLANT: Flood	T11008 D11008 L11008 TYPE: flat end mill DIAMETER: 12.7mm LENGTH: 37.1mm FLUTES: 5 DESCRIPTION: Spallamento fori VENDOR: Sandvik PRODUCT: 2N342-1270-PD
Operation 7/60 DESCRIPTION: Roughing4 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 10.9mm OPTIMAL LOAD: 12.07mm LOAD DEVIATION: 0.32mm NOTES:	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5470.317mm/min CUTTING DISTANCE: 2950.75mm RAPID DISTANCE: 5425.66mm ESTIMATED CYCLE TIME: 1m:38s (3.3%) COOLANT: Flood	T11008 D11008 L11008 TYPE: flat end mill DIAMETER: 12.7mm LENGTH: 37.1mm FLUTES: 5 DESCRIPTION: Spallamento fori VENDOR: Sandvik PRODUCT: 2N342-1270-PD
This roughing operation may lead to collisions with the shaft or holder, due to a known limitation in Fusion. Enabling Shaft & Holder might help but results vary. Please check the See details in https://cloudnc.atlassian.net/wiki/x/AYCREg		
Operation 8/60 DESCRIPTION: Roughing5 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 3.5mm OPTIMAL LOAD: 15mm LOAD DEVIATION: 1.5mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4458.366mm/min CUTTING DISTANCE: 4292.03mm RAPID DISTANCE: 2698.6mm ESTIMATED CYCLE TIME: 6m:10s (12.6%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 9/60 DESCRIPTION: Roughing6 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 SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3445.869mm/min CUTTING DISTANCE: 327.78mm RAPID DISTANCE: 1077.27mm ESTIMATED CYCLE TIME: 19s (0.6%) COOLANT: Flood	T11005 D11005 L11005 TYPE: flat end mill DIAMETER: 8mm LENGTH: 25.4mm FLUTES: 5 DESCRIPTION: tasche superiori 1 VENDOR: Sandvik PRODUCT: 2N342-0800-PD

NOTES:		
This roughing operation may lead to collisions with the shaft or holder, due to a known limitation in Fusion. Enabling Shaft & Holder might help but results vary. Please check the See details in https://cloudnc.atlassian.net/wiki/x/AYCREg		
Operation 10/60 DESCRIPTION: Roughing7 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 5.38mm OPTIMAL LOAD: 7.6mm LOAD DEVIATION: 0.2mm NOTES:	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3445.869mm/min CUTTING DISTANCE: 316.16mm RAPID DISTANCE: 1155.88mm ESTIMATED CYCLE TIME: 19s (0.7%) COOLANT: Flood	T11005 D11005 L11005 TYPE: flat end mill DIAMETER: 8mm LENGTH: 25.4mm FLUTES: 5 DESCRIPTION: tasche superiori 1 VENDOR: Sandvik PRODUCT: 2N342-0800-PD
This roughing operation may lead to collisions with the shaft or holder, due to a known limitation in Fusion. Enabling Shaft & Holder might help but results vary. Please check the See details in https://cloudnc.atlassian.net/wiki/x/AYCREg		
Operation 11/60 DESCRIPTION: Roughing8 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 3.75mm OPTIMAL LOAD: 7.6mm LOAD DEVIATION: 0.2mm NOTES:	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3445.869mm/min CUTTING DISTANCE: 1080.1mm RAPID DISTANCE: 1000.68mm ESTIMATED CYCLE TIME: 31s (1%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD
This roughing operation may lead to collisions with the shaft or holder, due to a known limitation in Fusion. Enabling Shaft & Holder might help but results vary. Please check the See details in https://cloudnc.atlassian.net/wiki/x/AYCREg		
Operation 12/60 DESCRIPTION: Roughing9 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 3.75mm OPTIMAL LOAD: 7.6mm LOAD DEVIATION: 0.2mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3445.869mm/min CUTTING DISTANCE: 770.43mm RAPID DISTANCE: 338.44mm ESTIMATED CYCLE TIME: 17s (0.6%) COOLANT: Flood	T11115 D11115 L11115 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: Roughing10 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.55mm OPTIMAL LOAD: 7.5mm LOAD DEVIATION: 0.75mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3057.303mm/min CUTTING DISTANCE: 1263.12mm RAPID DISTANCE: 1712.18mm ESTIMATED CYCLE TIME: 1m:13s (2.5%) COOLANT: Flood	T10112 D10112 L10112 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216.24-10050CCK22P 1620
Operation 14/60 DESCRIPTION: Flat WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 13.3mm	MAXIMUM SPINDLE SPEED: 7637rpm MAXIMUM FEEDRATE: 7637.242mm/min CUTTING DISTANCE: 127.1mm RAPID DISTANCE: 218.06mm ESTIMATED CYCLE TIME: 5s (0.2%) COOLANT: Flood	T11104 D11104 L11104 TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P
Operation 15/60 DESCRIPTION: Flat1 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 13.3mm	MAXIMUM SPINDLE SPEED: 7637rpm MAXIMUM FEEDRATE: 7637.242mm/min CUTTING DISTANCE: 1109.1mm RAPID DISTANCE: 1089.91mm ESTIMATED CYCLE TIME: 29s (1%) COOLANT: Flood	T11104 D11104 L11104 TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P
NOTES:		
This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 16/60 DESCRIPTION: Flat2 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 13.3mm	MAXIMUM SPINDLE SPEED: 7637rpm MAXIMUM FEEDRATE: 7637.242mm/min CUTTING DISTANCE: 1105.18mm RAPID DISTANCE: 890.1mm ESTIMATED CYCLE TIME: 25s (0.9%) COOLANT: Flood	T11104 D11104 L11104 TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P
NOTES:		
This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 17/60 DESCRIPTION: Flat3 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 701.63mm RAPID DISTANCE: 1097.49mm ESTIMATED CYCLE TIME: 30s (1%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730

Operation 18/60 DESCRIPTION: Flat4 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 95.21mm RAPID DISTANCE: 105.96mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 19/60 DESCRIPTION: Flat5 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 95.32mm RAPID DISTANCE: 109.66mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 20/60 DESCRIPTION: Flat6 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 178.27mm RAPID DISTANCE: 359.53mm ESTIMATED CYCLE TIME: 10s (0.3%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 21/60 DESCRIPTION: Flat7 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 5.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 379.12mm RAPID DISTANCE: 538.59mm ESTIMATED CYCLE TIME: 15s (0.5%) COOLANT: Flood	T11115 D11115 L11115 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: Flat8 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 5.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 282.33mm RAPID DISTANCE: 319.76mm ESTIMATED CYCLE TIME: 10s (0.3%) COOLANT: Flood	T11115 D11115 L11115 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: Flat9 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 5.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 163.74mm RAPID DISTANCE: 97.04mm ESTIMATED CYCLE TIME: 5s (0.2%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD
Operation 24/60 DESCRIPTION: Flat10 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 5.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 379.11mm RAPID DISTANCE: 601.07mm ESTIMATED CYCLE TIME: 16s (0.5%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD
Operation 25/60 DESCRIPTION: Wall STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 27.5mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 113.63mm RAPID DISTANCE: 36.43mm ESTIMATED CYCLE TIME: 5s (0.2%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD
Operation 26/60 DESCRIPTION: Wall1 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 27.5mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 191mm RAPID DISTANCE: 263.36mm ESTIMATED CYCLE TIME: 12s (0.4%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD
Operation 27/60 DESCRIPTION: Wall2 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 27.5mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 336.75mm RAPID DISTANCE: 262.65mm ESTIMATED CYCLE TIME: 21s (0.7%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD
Operation 28/60 DESCRIPTION: Wall3 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 27.5mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 82.16mm RAPID DISTANCE: 83.26mm ESTIMATED CYCLE TIME: 10s (0.3%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD

Operation 29/60 DESCRIPTION: Wall4 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 27.5mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 95.4mm RAPID DISTANCE: 88.95mm ESTIMATED CYCLE TIME: 5s (0.2%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD
Operation 30/60 DESCRIPTION: Wall5 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 27.5mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 45.94mm RAPID DISTANCE: 101.4mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD
Operation 31/60 DESCRIPTION: Wall6 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 50.5mm MAXIMUM STEPOVER: 18.05mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1620mm/min CUTTING DISTANCE: 115.62mm RAPID DISTANCE: 58.49mm ESTIMATED CYCLE TIME: 9s (0.3%) COOLANT: Flood	T11104 D11104 L11104 TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P
Operation 32/60 DESCRIPTION: Wall7 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 70mm MAXIMUM STEPOVER: 19mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2001.934mm/min CUTTING DISTANCE: 254.18mm RAPID DISTANCE: 197.9mm ESTIMATED CYCLE TIME: 20s (0.7%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 33/60 DESCRIPTION: Wall8 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 70mm MAXIMUM STEPOVER: 19mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2001.934mm/min CUTTING DISTANCE: 62.14mm RAPID DISTANCE: 36.25mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 34/60 DESCRIPTION: Wall9 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 70mm MAXIMUM STEPOVER: 19mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2001.934mm/min CUTTING DISTANCE: 62.14mm RAPID DISTANCE: 36.25mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 35/60 DESCRIPTION: Wall10 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 70mm MAXIMUM STEPOVER: 19mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2001.934mm/min CUTTING DISTANCE: 52.82mm RAPID DISTANCE: 87.75mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 36/60 DESCRIPTION: Wall11 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 16mm MAXIMUM STEPOVER: 6.65mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 120.01mm RAPID DISTANCE: 107.21mm ESTIMATED CYCLE TIME: 12s (0.4%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 37/60 DESCRIPTION: Wall12 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 16mm MAXIMUM STEPOVER: 6.65mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 120.01mm RAPID DISTANCE: 107.21mm ESTIMATED CYCLE TIME: 12s (0.4%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 38/60 DESCRIPTION: Wall13 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 16mm MAXIMUM STEPOVER: 6.65mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 108.62mm RAPID DISTANCE: 253.9mm ESTIMATED CYCLE TIME: 14s (0.5%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730

Operation 39/60 DESCRIPTION: Holemaking STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1942rpm MAXIMUM FEEDRATE: 535.906mm/min CUTTING DISTANCE: 127.12mm RAPID DISTANCE: 157.12mm ESTIMATED CYCLE TIME: 16s (0.5%) COOLANT: Flood	T10120 D10120 L10120 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 120mm FLUTES: 2 DESCRIPTION: Punta a forare M12 H8 VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM
Operation 40/60 DESCRIPTION: Holemaking1 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1942rpm MAXIMUM FEEDRATE: 535.906mm/min CUTTING DISTANCE: 78.05mm RAPID DISTANCE: 108.05mm ESTIMATED CYCLE TIME: 10s (0.3%) COOLANT: Flood	T10120 D10120 L10120 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 120mm FLUTES: 2 DESCRIPTION: Punta a forare M12 H8 VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM
Operation 41/60 DESCRIPTION: Holemaking2 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1253rpm MAXIMUM FEEDRATE: 576.357mm/min CUTTING DISTANCE: 97.56mm RAPID DISTANCE: 127.56mm ESTIMATED CYCLE TIME: 12s (0.4%) COOLANT: Flood	T10113 D10113 L10113 TYPE: drill DIAMETER: 20mm TIP ANGLE: 147° LENGTH: 110mm FLUTES: 2 DESCRIPTION: Punta a forare M20 H8 VENDOR: Sandvik PRODUCT: 860.1-2000-077A1-PM P1BM
Operation 42/60 DESCRIPTION: Holemaking3 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 6033rpm MAXIMUM FEEDRATE: 582.761mm/min CUTTING DISTANCE: 41.24mm RAPID DISTANCE: 251.24mm ESTIMATED CYCLE TIME: 7s (0.2%) COOLANT: Flood	T11011 D11011 L11011 TYPE: drill DIAMETER: 4.2mm TIP ANGLE: 147° LENGTH: 30mm FLUTES: 2 DESCRIPTION: Prefori 4.2mm VENDOR: Sandvik PRODUCT: 860.1-0420-018A0-PM
Operation 43/60 DESCRIPTION: Holemaking4 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 5177rpm MAXIMUM FEEDRATE: 535.801mm/min CUTTING DISTANCE: 52.59mm RAPID DISTANCE: 82.59mm ESTIMATED CYCLE TIME: 7s (0.2%) COOLANT: Flood	T11013 D11013 L11013 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
Operation 44/60 DESCRIPTION: Holemaking5 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1665rpm MAXIMUM FEEDRATE: 536.129mm/min CUTTING DISTANCE: 128.11mm RAPID DISTANCE: 158.11mm ESTIMATED CYCLE TIME: 16s (0.6%) COOLANT: Flood	T11112 D11112 L11112 TYPE: drill DIAMETER: 14mm TIP ANGLE: 147° LENGTH: 134mm FLUTES: 2 DESCRIPTION: Foro da 14mm VENDOR: Sandvik PRODUCT: 860.1-1400-115A1-PM
Operation 45/60 DESCRIPTION: Freeform STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.2mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 1173.42mm RAPID DISTANCE: 1589.49mm ESTIMATED CYCLE TIME: 1m:49s (3.7%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 46/60 DESCRIPTION: Freeform1 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.1mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 921.14mm RAPID DISTANCE: 263.74mm ESTIMATED CYCLE TIME: 1m:0s (2%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 47/60 DESCRIPTION: Freeform2 STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.2mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 964.29mm RAPID DISTANCE: 1825.03mm ESTIMATED CYCLE TIME: 1m:19s (2.7%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 48/60 DESCRIPTION: Freeform3 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.1mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 927.98mm RAPID DISTANCE: 159.42mm ESTIMATED CYCLE TIME: 59s (2%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730

Operation 49/60 DESCRIPTION: Freeform4 STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.49mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5965.417mm/min CUTTING DISTANCE: 4466.12mm RAPID DISTANCE: 210.78mm ESTIMATED CYCLE TIME: 3m:16s (6.6%) COOLANT: Flood	T11104 D11104 L11104 TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P
Operation 50/60 DESCRIPTION: Freeform5 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.25mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5965.417mm/min CUTTING DISTANCE: 187.8mm RAPID DISTANCE: 200.72mm ESTIMATED CYCLE TIME: 10s (0.3%) COOLANT: Flood	T11104 D11104 L11104 TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P
Operation 51/60 DESCRIPTION: Freeform7 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.25mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5965.417mm/min CUTTING DISTANCE: 68.83mm RAPID DISTANCE: 91mm ESTIMATED CYCLE TIME: 2s (0.1%) COOLANT: Flood	T11104 D11104 L11104 TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P
Operation 52/60 DESCRIPTION: Freeform8 STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.25mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1669.917mm/min CUTTING DISTANCE: 2593.18mm RAPID DISTANCE: 3015.32mm ESTIMATED CYCLE TIME: 2m:19s (4.7%) COOLANT: Flood	T11124 D11124 L11124 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 53/60 DESCRIPTION: Freeform9 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.13mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1669.917mm/min CUTTING DISTANCE: 2429.33mm RAPID DISTANCE: 37.87mm ESTIMATED CYCLE TIME: 1m:28s (3%) COOLANT: Flood	T11124 D11124 L11124 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 54/60 DESCRIPTION: Freeform10 STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.25mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1669.917mm/min CUTTING DISTANCE: 2591.02mm RAPID DISTANCE: 3009.19mm ESTIMATED CYCLE TIME: 2m:19s (4.7%) COOLANT: Flood	T11124 D11124 L11124 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 55/60 DESCRIPTION: Freeform11 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.13mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1669.917mm/min CUTTING DISTANCE: 2429.47mm RAPID DISTANCE: 38.24mm ESTIMATED CYCLE TIME: 1m:28s (3%) COOLANT: Flood	T11124 D11124 L11124 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 56/60 DESCRIPTION: Slot wall STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.81mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2430mm/min CUTTING DISTANCE: 90.65mm RAPID DISTANCE: 113mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	T11119 D11119 L11119 TYPE: slot mill DIAMETER: 10mm LENGTH: 40mm FLUTES: 7 DESCRIPTION: Prova 2 S2 contour
Operation 57/60 DESCRIPTION: Chamfering WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1960.79mm/min CUTTING DISTANCE: 242.73mm RAPID DISTANCE: 69.62mm ESTIMATED CYCLE TIME: 13s (0.4%) COOLANT: Flood	T11116 D11116 L11116 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: Chamfering1 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1960.79mm/min CUTTING DISTANCE: 41.76mm RAPID DISTANCE: 57.55mm ESTIMATED CYCLE TIME: 7s (0.2%) COOLANT: Flood	T11116 D11116 L11116 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: Chamfering2
WCS: #0
TOLERANCE: 0.01mm
STOCK TO LEAVE: 0mm

MAXIMUM SPINDLE SPEED: 8100rpm
MAXIMUM FEEDRATE: 1960.79mm/min
CUTTING DISTANCE: 87.6mm
RAPID DISTANCE: 61.04mm
ESTIMATED CYCLE TIME: 10s (0.3%)
COOLANT: Flood

T11116 D11116 L11116
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: Chamfering3
WCS: #0
TOLERANCE: 0.01mm
STOCK TO LEAVE: 0mm

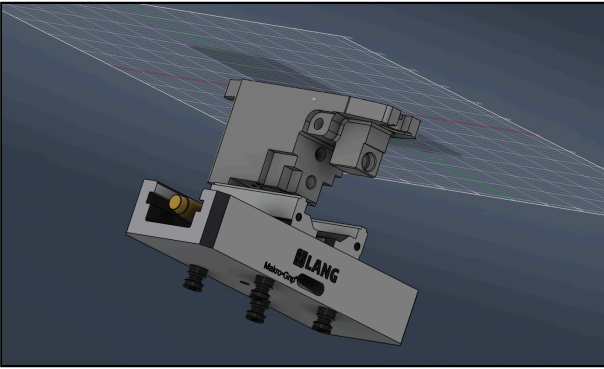
MAXIMUM SPINDLE SPEED: 8100rpm
MAXIMUM FEEDRATE: 1960.79mm/min
CUTTING DISTANCE: 93.89mm
RAPID DISTANCE: 61.04mm
ESTIMATED CYCLE TIME: 10s (0.3%)
COOLANT: Flood

T11116 D11116 L11116
TYPE: chamfer mill
DIAMETER: 6mm
TAPER ANGLE: 45°
LENGTH: 36mm
FLUTES: 4
DESCRIPTION: Smusso 45 interno S1
VENDOR: Sandvik
PRODUCT: 1C050-0100-045-XA

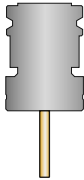
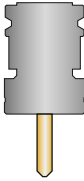
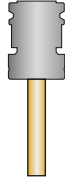
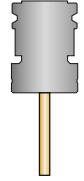
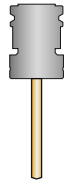


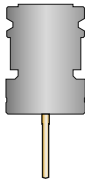
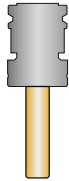
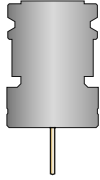
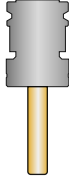
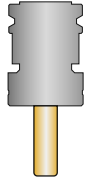
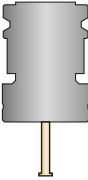
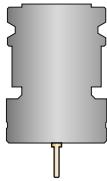
Setup Sheet for Program 1002

JOB DESCRIPTION: AutoSetup 2
DOCUMENT PATH: 0NC02_DFM_0102 v2

Setup	
WCS: #0 Stock: DX: 244mm DY: 85mm DZ: 120mm PART: DX: 234mm DY: 75mm DZ: 110mm Stock LOWER IN WCS #0: X: -122mm Y: -42.5mm Z: -120mm Stock UPPER IN WCS #0: X: 122mm Y: 42.5mm Z: 0mm	

Total
NUMBER OF OPERATIONS: 26 NUMBER OF TOOLS: 13 TOOLS: T10003 T10013 T10110 T10112 T10120 T11005 T11010 T11104 T11108 T11110 T11111 T11119 T11124 MAXIMUM FEEDRATE: 8614.673mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 24697.93mm RAPID DISTANCE: 50071.56mm ESTIMATED CYCLE TIME: 20m:51s

Tools			
T10003 D10003 L10003 Type: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730	MAXIMUM FEED: 1704.805mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 978.8mm RAPID DISTANCE: 2808.82mm ESTIMATED CYCLE TIME: 1m:8s (5.4%)	HOLDER: BT40 - B4C4-1000	
T10013 D10013 L10013 Type: chamfer mill DIAMETER: 12mm TAPER ANGLE: 45° LENGTH: 50mm FLUTES: 6 DESCRIPTION: Fresa per smussature VENDOR: Sandvik PRODUCT: 1C050-0300-045-XB 1620	MAXIMUM FEED: 2916mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 471.81mm RAPID DISTANCE: 292.63mm ESTIMATED CYCLE TIME: 15s (1.2%)	HOLDER: BT40 - B4C4-1000	
T10110 D10110 L10110 Type: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730	MAXIMUM FEED: 4458.366mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 3375.24mm RAPID DISTANCE: 11423.28mm ESTIMATED CYCLE TIME: 3m:49s (18.3%)	HOLDER: BT40 - B4C4-1000	
T10112 D10112 L10112 Type: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216.24-10050CCK22P 1620	MAXIMUM FEED: 1620mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 271.19mm RAPID DISTANCE: 311.57mm ESTIMATED CYCLE TIME: 17s (1.3%)	HOLDER: BT40 - B4C4-1000	
T10120 D10120 L10120 Type: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 120mm FLUTES: 2 DESCRIPTION: Punta a forare M12 H8 VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM	MAXIMUM FEED: 535.906mm/min MAXIMUM SPINDLE SPEED: 1942rpm CUTTING DISTANCE: 127.12mm RAPID DISTANCE: 157.12mm ESTIMATED CYCLE TIME: 16s (1.3%)	HOLDER: BT40 - B4C4-1000	
T11005 D11005 L11005 Type: flat end mill DIAMETER: 8mm LENGTH: 25.4mm FLUTES: 5 DESCRIPTION: tasche superiori 1 VENDOR: Sandvik PRODUCT: 2N342-0800-PD	MAXIMUM FEED: 3445.869mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 530.11mm RAPID DISTANCE: 1033.77mm ESTIMATED CYCLE TIME: 22s (1.7%)	HOLDER: BT40 - B4C4-1000	

T11010 D11010 L11010 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: 564.081mm/min MAXIMUM SPINDLE SPEED: 4905rpm CUTTING DISTANCE: 189.44mm RAPID DISTANCE: 388.45mm ESTIMATED CYCLE TIME: 25s (2%)	HOLDER: BT40 - B4C4-1000	
T11104 D11104 L11104 TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P	MAXIMUM FEED: 7189.725mm/min MAXIMUM SPINDLE SPEED: 6760rpm CUTTING DISTANCE: 14455.52mm RAPID DISTANCE: 27837.07mm ESTIMATED CYCLE TIME: 7m:35s (36.4%)	HOLDER: BT40 - B4C4-1000	
T11108 D11108 L11108 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: 528.096mm/min MAXIMUM SPINDLE SPEED: 7654rpm CUTTING DISTANCE: 13.55mm RAPID DISTANCE: 43.55mm ESTIMATED CYCLE TIME: 2s (0.2%)	HOLDER: BT40 - B4C4-1000	
T11110 D11110 L11110 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: 8100mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 514.89mm RAPID DISTANCE: 1234.06mm ESTIMATED CYCLE TIME: 33s (2.6%)	HOLDER: BT40 - B4C4-1000	
T11111 D11111 L11111 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 60mm FLUTES: 5 VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD	MAXIMUM FEED: 8614.673mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 2650.47mm RAPID DISTANCE: 3875.14mm ESTIMATED CYCLE TIME: 1m:5s (5.2%)	HOLDER: BT40 - B4C4-1000	
T11119 D11119 L11119 TYPE: slot mill DIAMETER: 10mm LENGTH: 40mm FLUTES: 7 DESCRIPTION: Prova 2 S2 contour	MAXIMUM FEED: 2430mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 621.42mm RAPID DISTANCE: 66mm ESTIMATED CYCLE TIME: 17s (1.4%)	HOLDER: BT40 - B4C4-1000	
T11124 D11124 L11124 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: 1293.388mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 498.4mm RAPID DISTANCE: 600.1mm ESTIMATED CYCLE TIME: 33s (2.6%)	HOLDER: BT40 - B4C4-1000	

Operations

Operation 1/26 DESCRIPTION: Roughing STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 11.68mm OPTIMAL LOAD: 19.59mm LOAD DEVIATION: 1.96mm	MAXIMUM SPINDLE SPEED: 6760rpm MAXIMUM FEEDRATE: 7189.725mm/min CUTTING DISTANCE: 14455.52mm RAPID DISTANCE: 27837.07mm ESTIMATED CYCLE TIME: 7m:35s (36.4%) COOLANT: Flood	T11104 D11104 L11104 TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P
Operation 2/26 DESCRIPTION: Roughing1 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 16.9mm OPTIMAL LOAD: 10.91mm LOAD DEVIATION: 1.09mm NOTES:	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 8614.673mm/min CUTTING DISTANCE: 2650.47mm RAPID DISTANCE: 3875.14mm ESTIMATED CYCLE TIME: 1m:5s (5.2%) COOLANT: Flood	T11111 D11111 L11111 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 60mm FLUTES: 5 VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD

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

Operation 3/26 DESCRIPTION: Roughing2 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 3.5mm OPTIMAL LOAD: 15mm LOAD DEVIATION: 1.5mm NOTES: <div>This roughing operation may lead to collisions with the shaft or holder, due to a known limitation in Fusion. Enabling Shaft & Holder might help but results vary. Please check the See details in https://cloudnc.atlassian.net/wiki/x/AYCREG</div>	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4458.366mm/min CUTTING DISTANCE: 651.35mm RAPID DISTANCE: 4566.38mm ESTIMATED CYCLE TIME: 1m:4s (5.1%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730	
Operation 4/26 DESCRIPTION: Roughing3 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 SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3445.869mm/min CUTTING DISTANCE: 293.96mm RAPID DISTANCE: 441.91mm ESTIMATED CYCLE TIME: 10s (0.8%) COOLANT: Flood	T11005 D11005 L11005 TYPE: flat end mill DIAMETER: 8mm LENGTH: 25.4mm FLUTES: 5 DESCRIPTION: tasche superiori 1 VENDOR: Sandvik PRODUCT: 2N342-0800-PD	
Operation 5/26 DESCRIPTION: Roughing4 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 SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3445.869mm/min CUTTING DISTANCE: 236.15mm RAPID DISTANCE: 591.87mm ESTIMATED CYCLE TIME: 11s (0.9%) COOLANT: Flood	T11005 D11005 L11005 TYPE: flat end mill DIAMETER: 8mm LENGTH: 25.4mm FLUTES: 5 DESCRIPTION: tasche superiori 1 VENDOR: Sandvik PRODUCT: 2N342-0800-PD	
Operation 6/26 DESCRIPTION: Roughing5 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.8mm OPTIMAL LOAD: 5.7mm LOAD DEVIATION: 0.57mm NOTES: <div>This roughing operation may lead to collisions with the shaft or holder, due to a known limitation in Fusion. Enabling Shaft & Holder might help but results vary. Please check the See details in https://cloudnc.atlassian.net/wiki/x/AYCREG</div>	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1704.805mm/min CUTTING DISTANCE: 978.8mm RAPID DISTANCE: 2808.82mm ESTIMATED CYCLE TIME: 1m:8s (5.4%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730	
Operation 7/26 DESCRIPTION: Roughing6 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 3.17mm OPTIMAL LOAD: 0.62mm LOAD DEVIATION: 0.06mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1293.388mm/min CUTTING DISTANCE: 419.1mm RAPID DISTANCE: 415.06mm ESTIMATED CYCLE TIME: 27s (2.2%) COOLANT: Flood	T11124 D11124 L11124 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 8/26 DESCRIPTION: Roughing7 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 3.17mm OPTIMAL LOAD: 0.62mm LOAD DEVIATION: 0.06mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1293.388mm/min CUTTING DISTANCE: 38.87mm RAPID DISTANCE: 92.37mm ESTIMATED CYCLE TIME: 3s (0.2%) COOLANT: Flood	T11124 D11124 L11124 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 9/26 DESCRIPTION: Roughing8 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 3.17mm OPTIMAL LOAD: 0.62mm LOAD DEVIATION: 0.06mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1293.388mm/min CUTTING DISTANCE: 40.43mm RAPID DISTANCE: 92.68mm ESTIMATED CYCLE TIME: 3s (0.2%) COOLANT: Flood	T11124 D11124 L11124 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 10/26 DESCRIPTION: Flat WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 1207.48mm RAPID DISTANCE: 1717.17mm ESTIMATED CYCLE TIME: 48s (3.8%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730	
Operation 11/26 DESCRIPTION: Flat1 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm NOTES: <div>This flat finishing operation may not fully finish the surface. Please check the simulation.</div>	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 535.86mm RAPID DISTANCE: 2035.16mm ESTIMATED CYCLE TIME: 43s (3.4%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730	

Operation 12/26 DESCRIPTION: Flat2 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 255.25mm RAPID DISTANCE: 1759.23mm ESTIMATED CYCLE TIME: 30s (2.4%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
NOTES: This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 13/26 DESCRIPTION: Flat3 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 202.28mm RAPID DISTANCE: 298.96mm ESTIMATED CYCLE TIME: 10s (0.8%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
NOTES: This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 14/26 DESCRIPTION: Flat4 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 201.34mm RAPID DISTANCE: 299.93mm ESTIMATED CYCLE TIME: 10s (0.8%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
NOTES: This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 15/26 DESCRIPTION: Flat5 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 9.8mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 8100mm/min CUTTING DISTANCE: 324.73mm RAPID DISTANCE: 947.58mm ESTIMATED CYCLE TIME: 16s (1.3%) COOLANT: Flood	T11110 D11110 L11110 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 16/26 DESCRIPTION: Flat6 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 6.86mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1620mm/min CUTTING DISTANCE: 122.29mm RAPID DISTANCE: 72.55mm ESTIMATED CYCLE TIME: 5s (0.4%) COOLANT: Flood	T10112 D10112 L10112 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216.24-10050CCK22P 1620
NOTES: This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 17/26 DESCRIPTION: Wall STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 70mm MAXIMUM STEPOVER: 19mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2001.934mm/min CUTTING DISTANCE: 103.82mm RAPID DISTANCE: 37.75mm ESTIMATED CYCLE TIME: 5s (0.4%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 18/26 DESCRIPTION: Wall1 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 70mm MAXIMUM STEPOVER: 19mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2001.934mm/min CUTTING DISTANCE: 100.81mm RAPID DISTANCE: 55.2mm ESTIMATED CYCLE TIME: 5s (0.4%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 19/26 DESCRIPTION: Wall2 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 70mm MAXIMUM STEPOVER: 19mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2001.934mm/min CUTTING DISTANCE: 117.05mm RAPID DISTANCE: 653.5mm ESTIMATED CYCLE TIME: 14s (1.1%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 20/26 DESCRIPTION: Wall3 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 66.5mm MAXIMUM STEPOVER: 13.3mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1803.93mm/min CUTTING DISTANCE: 190.15mm RAPID DISTANCE: 286.48mm ESTIMATED CYCLE TIME: 17s (1.3%) COOLANT: Flood	T11110 D11110 L11110 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 21/26 DESCRIPTION: Holemaking STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1942rpm MAXIMUM FEEDRATE: 535.906mm/min CUTTING DISTANCE: 127.12mm RAPID DISTANCE: 157.12mm ESTIMATED CYCLE TIME: 16s (1.3%) COOLANT: Flood	T10120 D10120 L10120 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 120mm FLUTES: 2 DESCRIPTION: Punta a forare M12 H8 VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM
Operation 22/26 DESCRIPTION: Holemaking1 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 4905rpm MAXIMUM FEEDRATE: 564.081mm/min CUTTING DISTANCE: 189.44mm RAPID DISTANCE: 388.45mm ESTIMATED CYCLE TIME: 25s (2%) COOLANT: Flood	T11010 D11010 L11010 TYPE: drill DIAMETER: 5mm TIP ANGLE: 147° LENGTH: 52mm FLUTES: 2 DESCRIPTION: Fori superiori 5mm VENDOR: Sandvik PRODUCT: 860.1-0500-037A1-PM
Operation 23/26 DESCRIPTION: Holemaking2 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 7654rpm MAXIMUM FEEDRATE: 528.096mm/min CUTTING DISTANCE: 13.55mm RAPID DISTANCE: 43.55mm ESTIMATED CYCLE TIME: 2s (0.2%) COOLANT: Flood	T11108 D11108 L11108 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 24/26 DESCRIPTION: Freeform STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.08mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1265mm/min CUTTING DISTANCE: 148.9mm RAPID DISTANCE: 239.02mm ESTIMATED CYCLE TIME: 11s (0.9%) COOLANT: Flood	T10112 D10112 L10112 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216.24-10050CCK22P 1620
Operation 25/26 DESCRIPTION: Slot wall STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 2mm MAXIMUM STEPOVER: 0.81mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2430mm/min CUTTING DISTANCE: 621.42mm RAPID DISTANCE: 66mm ESTIMATED CYCLE TIME: 17s (1.4%) COOLANT: Flood	T11119 D11119 L11119 TYPE: slot mill DIAMETER: 10mm LENGTH: 40mm FLUTES: 7 DESCRIPTION: Prova 2 S2 contour
Operation 26/26 DESCRIPTION: Chamfering1 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2916mm/min CUTTING DISTANCE: 471.81mm RAPID DISTANCE: 292.63mm ESTIMATED CYCLE TIME: 15s (1.2%) COOLANT: Flood	T10013 D10013 L10013 TYPE: chamfer mill DIAMETER: 12mm TAPER ANGLE: 45° LENGTH: 50mm FLUTES: 6 DESCRIPTION: Fresa per smussature VENDOR: Sandvik PRODUCT: 1C050-0300-045-XB 1620