

Setup Sheet for Program 1001

JOB DESCRIPTION: AutoSetup 1

DOCUMENT PATH: X_NC01-FORI_EDIT_121007 v7

Setup

WCS: #0

Stock:

DX: 160mm

DY: 95mm

DZ: 35mm

PART:

DX: 150mm

DY: 84.87mm

DZ: 25mm

Stock Lower in WCS #0:

X: -80mm

Y: -47.5mm

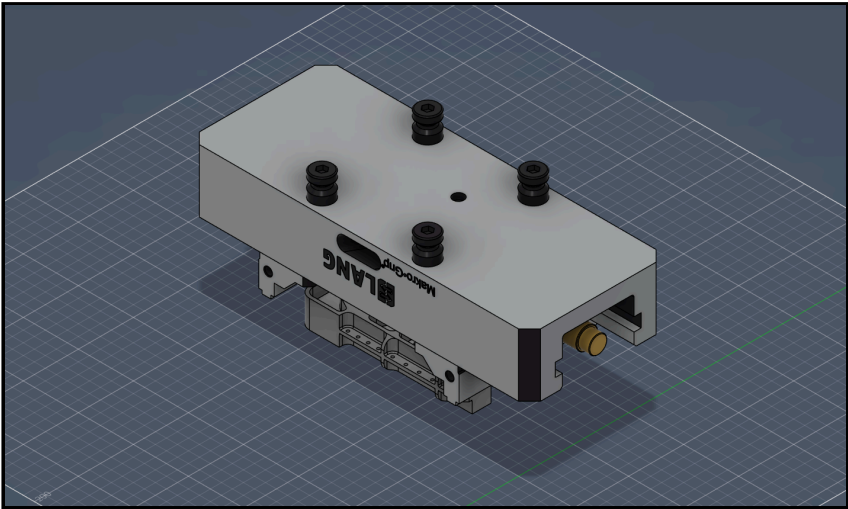
Z: -35mm

Stock Upper in WCS #0:

X: 80mm

Y: 47.5mm

Z: 0mm



Total

NUMBER OF OPERATIONS: 21

NUMBER OF TOOLS: 11

TOOLS: T17002 T17003 T17007 T17009 T17012 T20001 T20002 T20009 T22005 T22007 T22014

MAXIMUM Z: 15mm

MINIMUM Z: -30.5mm

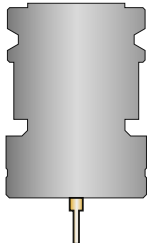
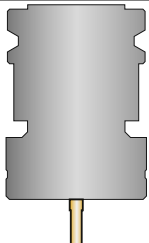
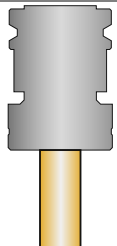
MAXIMUM FEEDRATE: 4307.336mm/min

MAXIMUM SPINDLE SPEED: 8100rpm

CUTTING DISTANCE: 30968.99mm

RAPID DISTANCE: 20129.29mm

ESTIMATED CYCLE TIME: 38m:42s

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: 3000.63mm RAPID DISTANCE: 613.84mm ESTIMATED CYCLE TIME: 9m:59s (25.8%)	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: 3651.64mm RAPID DISTANCE: 1201.95mm ESTIMATED CYCLE TIME: 4m:20s (11.2%)	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 (1.1%)	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 (0.9%)	HOLDER: BT40 - B4C4-1000	
T17012 D17012 L17012 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 1mm LENGTH: 30mm FLUTES: 4 DESCRIPTION: CoroMill Dura PavimentoTascheLateral VENDOR: Sandvik PRODUCT: 1K334-0400-100-XC 1730	MINIMUM Z: -16mm MAXIMUM FEED: 1225.111mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 4069.78mm RAPID DISTANCE: 3463.03mm ESTIMATED CYCLE TIME: 8m:44s (22.6%)	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 (3.8%)	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 (3.4%)	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 (12%)	HOLDER: BT40 - B4C4-1000	
T22005 D22005 L22005 TYPE: face mill DIAMETER: 25mm CORNER RADIUS: 1.6mm LENGTH: 50mm FLUTES: 2 DESCRIPTION: Fresa per creazione foro centrale 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:0s (2.6%)	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 (4.2%)	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

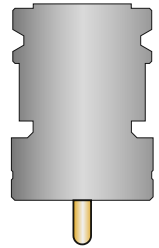
MAXIMUM SPINDLE SPEED: 8100rpm

CUTTING DISTANCE: 1275.89mm

RAPID DISTANCE: 657.67mm

ESTIMATED CYCLE TIME: 1m:6s (2.8%)

HOLDER: BT40 - B4C4-1000

**Operations****Operation 1/21**

DESCRIPTION: Roughing

STRATEGY: Facing

WCS: #0

TOLERANCE: 0.01mm

MAXIMUM STEPDOWN: 15.7mm

MAXIMUM STEPOVER: 18.75mm

MAXIMUM Z: 15mm

MINIMUM Z: -4.75mm

MAXIMUM SPINDLE SPEED: 7639rpm

MAXIMUM FEEDRATE: 3055.775mm/min

CUTTING DISTANCE: 1253.14mm

RAPID DISTANCE: 27.25mm

ESTIMATED CYCLE TIME: 25s (1.1%)

COOLANT: Flood

T22005 D22005 L22005

TYPE: face mill

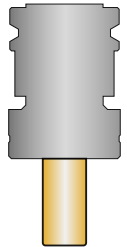
DIAMETER: 25mm

CORNER RADIUS: 1.6mm

LENGTH: 50mm

FLUTES: 2

DESCRIPTION: Fresa per creazione foro centrale

PRODUCT: [R390-025A25-17L](#)**Operation 2/21**

DESCRIPTION: Finishing

STRATEGY: Facing

WCS: #0

TOLERANCE: 0.01mm

MAXIMUM STEPOVER: 22.5mm

MAXIMUM Z: 15mm

MINIMUM Z: -5mm

MAXIMUM SPINDLE SPEED: 7639rpm

MAXIMUM FEEDRATE: 1909.859mm/min

CUTTING DISTANCE: 1063.2mm

RAPID DISTANCE: 27.5mm

ESTIMATED CYCLE TIME: 34s (1.5%)

COOLANT: Flood

T22005 D22005 L22005

TYPE: face mill

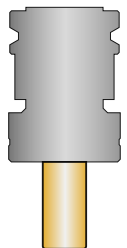
DIAMETER: 25mm

CORNER RADIUS: 1.6mm

LENGTH: 50mm

FLUTES: 2

DESCRIPTION: Fresa per creazione foro centrale

PRODUCT: [R390-025A25-17L](#)**Operation 3/21**

DESCRIPTION: Roughing

STRATEGY: Adaptive

WCS: #0

TOLERANCE: 0.1mm

STOCK TO LEAVE: 0.25mm

MAXIMUM STEPDOWN: 5.15mm

OPTIMAL LOAD: 9.5mm

LOAD DEVIATION: 0.25mm

MAXIMUM Z: 15mm

MINIMUM Z: -30.2mm

MAXIMUM SPINDLE SPEED: 8100rpm

MAXIMUM FEEDRATE: 4307.336mm/min

CUTTING DISTANCE: 10853.89mm

RAPID DISTANCE: 10127.33mm

ESTIMATED CYCLE TIME: 4m:39s (12%)

COOLANT: Flood

T20009 D20009 L20009

TYPE: bullnose end mill

DIAMETER: 10mm

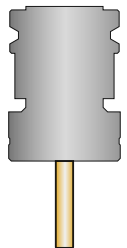
CORNER RADIUS: 0.5mm

LENGTH: 50mm

FLUTES: 5

DESCRIPTION: FORO GRANDE

VENDOR: SANVIK

PRODUCT: [1K335-1000-050-XD 1730](#)**Operation 4/21**

DESCRIPTION: Roughing1

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: -15.75mm

MAXIMUM SPINDLE SPEED: 8100rpm

MAXIMUM FEEDRATE: 2756.695mm/min

CUTTING DISTANCE: 1757.83mm

RAPID DISTANCE: 1423.61mm

ESTIMATED CYCLE TIME: 57s (2.5%)

COOLANT: Flood

T20001 D20001 L20001

TYPE: flat end mill

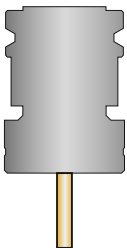
DIAMETER: 8mm

LENGTH: 40mm

FLUTES: 4

DESCRIPTION: sgrossature tasche

VENDOR: sandvik

PRODUCT: [2P342-0800-PA 1730](#)**Operation 5/21**

DESCRIPTION: Roughing2

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: 3651.64mm

RAPID DISTANCE: 1201.95mm

ESTIMATED CYCLE TIME: 4m:20s (11.2%)

COOLANT: Flood

T17003 D17003 L17003

TYPE: flat end mill

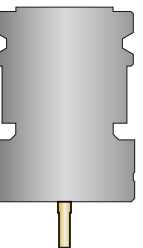
DIAMETER: 5mm

LENGTH: 21mm

FLUTES: 4

DESCRIPTION: CoroMill Dura Tasche

VENDOR: Sandvik

PRODUCT: [2P342-0500-PA 1730](#)**Operation 6/21**

DESCRIPTION: Roughing3

STRATEGY: Adaptive

WCS: #0

TOLERANCE: 0.1mm

STOCK TO LEAVE: 0.25mm

MAXIMUM STEPDOWN: 0.6mm

OPTIMAL LOAD: 2.85mm

LOAD DEVIATION: 0.28mm

MAXIMUM Z: 15mm

MINIMUM Z: -15.75mm

MAXIMUM SPINDLE SPEED: 8100rpm

MAXIMUM FEEDRATE: 1225.111mm/min

CUTTING DISTANCE: 3123.46mm

RAPID DISTANCE: 1894.37mm

ESTIMATED CYCLE TIME: 6m:57s (18%)

COOLANT: Flood

T17012 D17012 L17012

TYPE: bullnose end mill

DIAMETER: 4mm

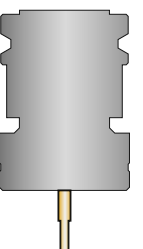
CORNER RADIUS: 1mm

LENGTH: 30mm

FLUTES: 4

DESCRIPTION: CoroMill Dura PavimentoTascheLateral

VENDOR: Sandvik

PRODUCT: [1K334-0400-100-XC 1730](#)

<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: 3000.63mm</p> <p>RAPID DISTANCE: 613.84mm</p> <p>ESTIMATED CYCLE TIME: 9m:59s (25.8%)</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 (0.5%)</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 9/21</p> <p>DESCRIPTION: Flat1</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0.27mm/0mm</p> <p>MAXIMUM STEPOVER: 3.15mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1550.641mm/min</p> <p>CUTTING DISTANCE: 462.08mm</p> <p>RAPID DISTANCE: 407.79mm</p> <p>ESTIMATED CYCLE TIME: 24s (1%)</p> <p>COOLANT: Flood</p>	<p>T20002 D20002 L20002</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4.5mm</p> <p>LENGTH: 35mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: SGROSSATURA TASCHE PICCOLE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1P240-0450-XA 1630</p>	
<p>Operation 10/21</p> <p>DESCRIPTION: Flat2</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0.27mm/0mm</p> <p>MAXIMUM STEPOVER: 1.4mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 648mm/min</p> <p>CUTTING DISTANCE: 619.35mm</p> <p>RAPID DISTANCE: 1243.42mm</p> <p>ESTIMATED CYCLE TIME: 1m:15s (3.2%)</p> <p>COOLANT: Flood</p>	<p>T17012 D17012 L17012</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 4mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 30mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura PavimentoTascheLaterali</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1K334-0400-100-XC 1730</p>	
<p>Operation 11/21</p> <p>DESCRIPTION: Wall</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 8mm</p> <p>MAXIMUM STEPOVER: 1.9mm</p>	<p>MAXIMUM Z: 11.8mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1036.8mm/min</p> <p>CUTTING DISTANCE: 114.82mm</p> <p>RAPID DISTANCE: 92.23mm</p> <p>ESTIMATED CYCLE TIME: 11s (0.5%)</p> <p>COOLANT: Flood</p>	<p>T17012 D17012 L17012</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 4mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 30mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura PavimentoTascheLaterali</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1K334-0400-100-XC 1730</p>	
<p>Operation 12/21</p> <p>DESCRIPTION: Wall1</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 8mm</p> <p>MAXIMUM STEPOVER: 1.9mm</p>	<p>MAXIMUM Z: 11.8mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1036.8mm/min</p> <p>CUTTING DISTANCE: 212.15mm</p> <p>RAPID DISTANCE: 233.01mm</p> <p>ESTIMATED CYCLE TIME: 21s (0.9%)</p> <p>COOLANT: Flood</p>	<p>T17012 D17012 L17012</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 4mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 30mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura PavimentoTascheLaterali</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1K334-0400-100-XC 1730</p>	
<p>Operation 13/21</p> <p>DESCRIPTION: Wall2</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 26mm</p> <p>MAXIMUM STEPOVER: 11.4mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -30mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 3110.4mm/min</p> <p>CUTTING DISTANCE: 45.46mm</p> <p>RAPID DISTANCE: 55.55mm</p> <p>ESTIMATED CYCLE TIME: 6s (0.3%)</p> <p>COOLANT: Flood</p>	<p>T17009 D17009 L17009</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 12mm</p> <p>LENGTH: 60mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura Finituracontornatura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1K334-1200-XB 1730</p>	

<p>Operation 14/21</p> <p>DESCRIPTION: Wall3</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 26mm</p> <p>MAXIMUM STEPOVER: 11.4mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -30.2mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 3110.4mm/min</p> <p>CUTTING DISTANCE: 483.17mm</p> <p>RAPID DISTANCE: 57mm</p> <p>ESTIMATED CYCLE TIME: 14s (0.6%)</p> <p>COOLANT: Flood</p>	<p>T17009 D17009 L17009</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 12mm</p> <p>LENGTH: 60mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura Finituracontornatura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1K334-1200-XB 1730</p>	
<p>Operation 15/21</p> <p>DESCRIPTION: Wall4</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 17.5mm</p> <p>MAXIMUM STEPOVER: 7.6mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1620mm/min</p> <p>CUTTING DISTANCE: 276.42mm</p> <p>RAPID DISTANCE: 188.46mm</p> <p>ESTIMATED CYCLE TIME: 19s (0.8%)</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 16/21</p> <p>DESCRIPTION: Wall5</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 8.73mm</p> <p>MAXIMUM STEPOVER: 4.28mm</p>	<p>MAXIMUM Z: 11.9mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 808.957mm/min</p> <p>CUTTING DISTANCE: 331.93mm</p> <p>RAPID DISTANCE: 62.19mm</p> <p>ESTIMATED CYCLE TIME: 28s (1.2%)</p> <p>COOLANT: Flood</p>	<p>T20002 D20002 L20002</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4.5mm</p> <p>LENGTH: 35mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: SGROSSATURA TASCHE PICCOLE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1P240-0450-XA 1630</p>	
<p>Operation 17/21</p> <p>DESCRIPTION: Wall6</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 8.73mm</p> <p>MAXIMUM STEPOVER: 4.28mm</p>	<p>MAXIMUM Z: 11.9mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 808.957mm/min</p> <p>CUTTING DISTANCE: 266.66mm</p> <p>RAPID DISTANCE: 193.74mm</p> <p>ESTIMATED CYCLE TIME: 27s (1.2%)</p> <p>COOLANT: Flood</p>	<p>T20002 D20002 L20002</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4.5mm</p> <p>LENGTH: 35mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: SGROSSATURA TASCHE PICCOLE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1P240-0450-XA 1630</p>	
<p>Operation 18/21</p> <p>DESCRIPTION: Holemaking</p> <p>STRATEGY: Bore</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -30.5mm</p> <p>MAXIMUM SPINDLE SPEED: 7639rpm</p> <p>MAXIMUM FEEDRATE: 3055.775mm/min</p> <p>CUTTING DISTANCE: 1257.85mm</p> <p>RAPID DISTANCE: 59.5mm</p> <p>ESTIMATED CYCLE TIME: 26s (1.1%)</p> <p>COOLANT: Flood</p>	<p>T17007 D17007 L17007</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 25mm</p> <p>LENGTH: 60mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: CoroMill 390 Finituraforogrande</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: R390-025A25-17L</p>	
<p>Operation 19/21</p> <p>DESCRIPTION: Holemaking1</p> <p>STRATEGY: Drilling</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -20.91mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 465.75mm/min</p> <p>CUTTING DISTANCE: 627.3mm</p> <p>RAPID DISTANCE: 1311.37mm</p> <p>ESTIMATED CYCLE TIME: 1m:37s (4.2%)</p> <p>COOLANT: Flood</p>	<p>T22007 D22007 L22007</p> <p>TYPE: drill</p> <p>DIAMETER: 2.5mm</p> <p>TIP ANGLE: 140°</p> <p>LENGTH: 40mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: Punta per fori piccoli</p> <p>PRODUCT: 862.1-2500-225A0-GM X2BL</p>	
<p>Operation 20/21</p> <p>DESCRIPTION: Freeform</p> <p>STRATEGY: Contour</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 0.56mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -15.82mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1900mm/min</p> <p>CUTTING DISTANCE: 853.68mm</p> <p>RAPID DISTANCE: 557.9mm</p> <p>ESTIMATED CYCLE TIME: 45s (1.9%)</p> <p>COOLANT: Flood</p>	<p>T22014 D22014 L22014</p> <p>TYPE: ball end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 4mm</p> <p>LENGTH: 20mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: nervatura tonda</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: fresa a punta tonda VQ4SVBR04000</p>	

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 (0.9%)

COOLANT: Flood

T22014 D22014 L22014

TYPE: ball end mill

DIAMETER: 8mm

CORNER RADIUS: 4mm

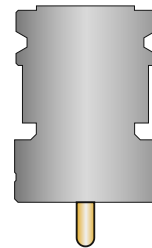
LENGTH: 20mm

FLUTES: 4

DESCRIPTION: nervatura tonda

VENDOR: mitsubishi

PRODUCT: [fresa a punta tonda VQ4SVBR04000](#)



Setup Sheet for Program 1002

JOB DESCRIPTION: AutoSetup 2

DOCUMENT PATH: X_NC01-FORI_EDIT_121007 v7

Setup

WCS: #0

STOCK:

DX: 160mm

DY: 95mm

DZ: 35mm

PART:

DX: 150mm

DY: 84.87mm

DZ: 25mm

STOCK LOWER IN WCS #0:

X: -80mm

Y: -47.5mm

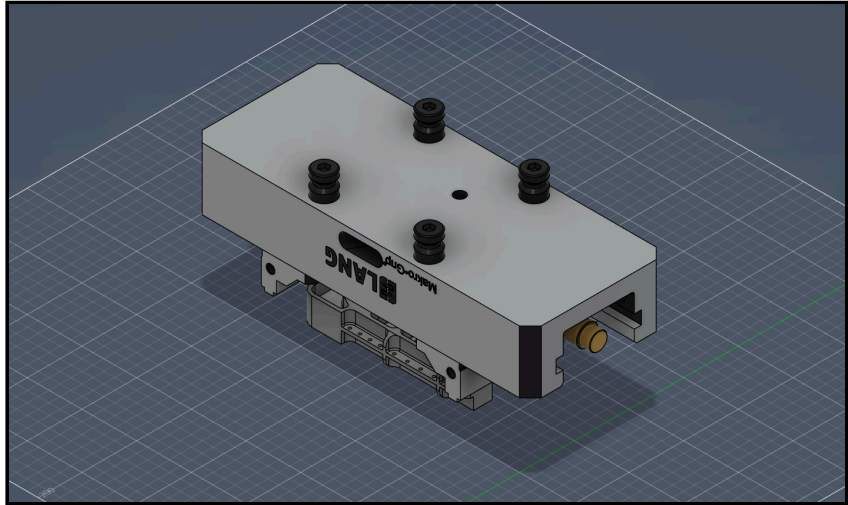
Z: -35mm

STOCK UPPER IN WCS #0:

X: 80mm

Y: 47.5mm

Z: 0mm



Total

NUMBER OF OPERATIONS: 15

NUMBER OF TOOLS: 7

TOOLS: T17002 T17003 T17012 T20001 T20002 T22001 T22014

MAXIMUM Z: 15mm

MINIMUM Z: -16mm

MAXIMUM FEEDRATE: 2756.695mm/min

MAXIMUM SPINDLE SPEED: 8100rpm

CUTTING DISTANCE: 28729.64mm

RAPID DISTANCE: 15537.96mm

ESTIMATED CYCLE TIME: 39m:32s

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

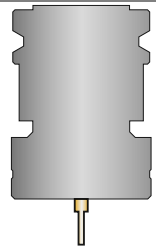
MAXIMUM SPINDLE SPEED: 8100rpm

CUTTING DISTANCE: 3052.2mm

RAPID DISTANCE: 1016.71mm

ESTIMATED CYCLE TIME: 10m:14s (25.9%)

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

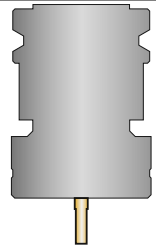
MAXIMUM SPINDLE SPEED: 8100rpm

CUTTING DISTANCE: 5366.8mm

RAPID DISTANCE: 1635.91mm

ESTIMATED CYCLE TIME: 7m:31s (19%)

HOLDER: BT40 - B4C4-1000



T17012 D17012 L17012

TYPE: bullnose end mill

DIAMETER: 4mm

CORNER RADIUS: 1mm

LENGTH: 30mm

FLUTES: 4

DESCRIPTION: CoroMill Dura PavimentoTascheLateral

VENDOR: Sandvik

PRODUCT: [1K334-0400-100-XC 1730](#)

MINIMUM Z: -16mm

MAXIMUM FEED: 1225.111mm/min

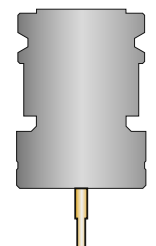
MAXIMUM SPINDLE SPEED: 8100rpm

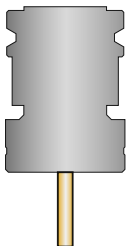
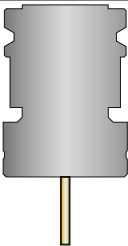
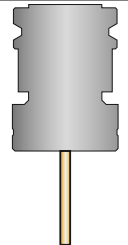
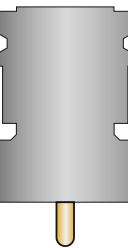
CUTTING DISTANCE: 4235.17mm

RAPID DISTANCE: 3574.52mm

ESTIMATED CYCLE TIME: 9m:4s (23%)

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: 13411.61mm RAPID DISTANCE: 7281.46mm ESTIMATED CYCLE TIME: 6m:58s (17.6%)	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 (3.3%)	HOLDER: BT40 - B4C4-1000	
T22001 D22001 L22001	TYPE: flat end mill DIAMETER: 6mm LENGTH: 57mm FLUTES: 5 DESCRIPTION: finitura_contorno VENDOR: sandvik PRODUCT: 2N342-0600-PC 1730	MINIMUM Z: -8.45mm MAXIMUM FEED: 748.918mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 331.31mm RAPID DISTANCE: 784.45mm ESTIMATED CYCLE TIME: 36s (1.5%)	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 (2.8%)	HOLDER: BT40 - B4C4-1000	

Operations				
Operation 1/15	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 (14.7%) 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 2/15	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 (19%) 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 3/15	DESCRIPTION: Roughing2 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.6mm OPTIMAL LOAD: 2.85mm LOAD DEVIATION: 0.28mm	MAXIMUM Z: 15mm MINIMUM Z: -15.75mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1225.111mm/min CUTTING DISTANCE: 3289.12mm RAPID DISTANCE: 2003.88mm ESTIMATED CYCLE TIME: 7m:18s (18.5%) COOLANT: Flood	T17012 D17012 L17012 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 1mm LENGTH: 30mm FLUTES: 4 DESCRIPTION: CoroMill Dura PavimentoTascheLateral VENDOR: Sandvik PRODUCT: 1K334-0400-100-XC 1730	

<p>Operation 4/15</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: 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: 3052.2mm</p> <p>RAPID DISTANCE: 1016.71mm</p> <p>ESTIMATED CYCLE TIME: 10m:14s (25.9%)</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 5/15</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: 0.33mm</p> <p>OPTIMAL LOAD: 4.5mm</p> <p>LOAD DEVIATION: 0.45mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -8.45mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 748.918mm/min</p> <p>CUTTING DISTANCE: 331.31mm</p> <p>RAPID DISTANCE: 784.45mm</p> <p>ESTIMATED CYCLE TIME: 36s (1.5%)</p> <p>COOLANT: Flood</p>	<p>T22001 D22001 L22001</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 6mm</p> <p>LENGTH: 57mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: finitura_contorno</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 2N342-0600-PC 1730</p>	
<p>Operation 6/15</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: 1636.19mm</p> <p>RAPID DISTANCE: 389.74mm</p> <p>ESTIMATED CYCLE TIME: 49s (2.1%)</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 7/15</p> <p>DESCRIPTION: Flat1</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0.27mm/0mm</p> <p>MAXIMUM STEPOVER: 3.15mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1550.641mm/min</p> <p>CUTTING DISTANCE: 463.35mm</p> <p>RAPID DISTANCE: 349.39mm</p> <p>ESTIMATED CYCLE TIME: 23s (1%)</p> <p>COOLANT: Flood</p>	<p>T20002 D20002 L20002</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4.5mm</p> <p>LENGTH: 35mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: SGROSSATURA TASCHE PICCOLE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1P240-0450-XA 1630</p>	
<p>Operation 8/15</p> <p>DESCRIPTION: Flat2</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0.27mm/0mm</p> <p>MAXIMUM STEPOVER: 1.4mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 648mm/min</p> <p>CUTTING DISTANCE: 619.07mm</p> <p>RAPID DISTANCE: 1245.4mm</p> <p>ESTIMATED CYCLE TIME: 1m:15s (3.2%)</p> <p>COOLANT: Flood</p>	<p>T17012 D17012 L17012</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 4mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 30mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura PavimentoTascheLateral</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1K334-0400-100-XC 1730</p>	
<p>Operation 9/15</p> <p>DESCRIPTION: Wall</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 8mm</p> <p>MAXIMUM STEPOVER: 1.9mm</p>	<p>MAXIMUM Z: 11.8mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1036.8mm/min</p> <p>CUTTING DISTANCE: 114.82mm</p> <p>RAPID DISTANCE: 92.23mm</p> <p>ESTIMATED CYCLE TIME: 11s (0.5%)</p> <p>COOLANT: Flood</p>	<p>T17012 D17012 L17012</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 4mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 30mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura PavimentoTascheLateral</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1K334-0400-100-XC 1730</p>	
<p>Operation 10/15</p> <p>DESCRIPTION: Wall1</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 8mm</p> <p>MAXIMUM STEPOVER: 1.9mm</p>	<p>MAXIMUM Z: 11.8mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1036.8mm/min</p> <p>CUTTING DISTANCE: 212.15mm</p> <p>RAPID DISTANCE: 233.01mm</p> <p>ESTIMATED CYCLE TIME: 21s (0.9%)</p> <p>COOLANT: Flood</p>	<p>T17012 D17012 L17012</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 4mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 30mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura PavimentoTascheLateral</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1K334-0400-100-XC 1730</p>	

<p>Operation 11/15</p> <p>DESCRIPTION: Wall2</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 17.5mm</p> <p>MAXIMUM STEPOVER: 7.6mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1620mm/min</p> <p>CUTTING DISTANCE: 276.42mm</p> <p>RAPID DISTANCE: 243.73mm</p> <p>ESTIMATED CYCLE TIME: 20s (0.8%)</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: sgrossatura tasche</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 2P342-0800-PA 1730</p>	
<p>Operation 12/15</p> <p>DESCRIPTION: Wall3</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 8.73mm</p> <p>MAXIMUM STEPOVER: 4.28mm</p>	<p>MAXIMUM Z: 11.9mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 808.957mm/min</p> <p>CUTTING DISTANCE: 331.93mm</p> <p>RAPID DISTANCE: 62.19mm</p> <p>ESTIMATED CYCLE TIME: 28s (1.2%)</p> <p>COOLANT: Flood</p>	<p>T20002 D20002 L20002</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4.5mm</p> <p>LENGTH: 35mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: SGROSSATURA TASCHE PICCOLE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1P240-0450-XA 1630</p>	
<p>Operation 13/15</p> <p>DESCRIPTION: Wall4</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 8.73mm</p> <p>MAXIMUM STEPOVER: 4.28mm</p>	<p>MAXIMUM Z: 11.9mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 808.957mm/min</p> <p>CUTTING DISTANCE: 266.66mm</p> <p>RAPID DISTANCE: 176.84mm</p> <p>ESTIMATED CYCLE TIME: 27s (1.1%)</p> <p>COOLANT: Flood</p>	<p>T20002 D20002 L20002</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4.5mm</p> <p>LENGTH: 35mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: SGROSSATURA TASCHE PICCOLE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1P240-0450-XA 1630</p>	
<p>Operation 14/15</p> <p>DESCRIPTION: Freeform</p> <p>STRATEGY: Contour</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 0.56mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -15.82mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1900mm/min</p> <p>CUTTING DISTANCE: 853.56mm</p> <p>RAPID DISTANCE: 557.83mm</p> <p>ESTIMATED CYCLE TIME: 45s (1.9%)</p> <p>COOLANT: Flood</p>	<p>T22014 D22014 L22014</p> <p>TYPE: ball end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 4mm</p> <p>LENGTH: 20mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: nervatura tonda</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: fresa a punta tonda VQ4SVBR04000</p>	
<p>Operation 15/15</p> <p>DESCRIPTION: Freeform1</p> <p>STRATEGY: Scallop</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPOVER: 0.28mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -7.08mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1900mm/min</p> <p>CUTTING DISTANCE: 417.03mm</p> <p>RAPID DISTANCE: 98.69mm</p> <p>ESTIMATED CYCLE TIME: 21s (0.9%)</p> <p>COOLANT: Flood</p>	<p>T22014 D22014 L22014</p> <p>TYPE: ball end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 4mm</p> <p>LENGTH: 20mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: nervatura tonda</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: fresa a punta tonda VQ4SVBR04000</p>	