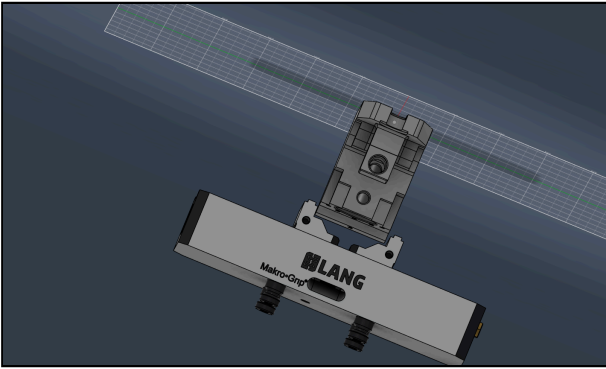
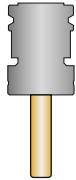
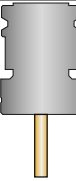
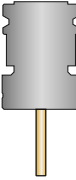
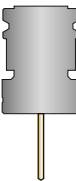
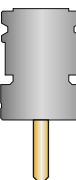
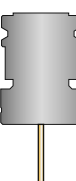


# Setup Sheet for Program 1001

JOB DESCRIPTION: AutoSetup 1  
DOCUMENT PATH: 0NC01\_DFM\_01 v2

Setup	
<b>WCS: #0</b> <b>Stock:</b> DX: 244mm DY: 85mm DZ: 120mm <b>PART:</b> DX: 234mm DY: 75mm DZ: 110mm <b>Stock Lower in WCS #0:</b> X: -122mm Y: -42.5mm Z: -120mm <b>Stock Upper in WCS #0:</b> X: 122mm Y: 42.5mm Z: 0mm	

Total
<b>NUMBER OF OPERATIONS:</b> 63 <b>NUMBER OF TOOLS:</b> 12 <b>TOOLS:</b> T10001 T10002 T10003 T10007 T10013 T10014 T10109 T10110 T10112 T10113 T10118 T10120 <b>MAXIMUM FEEDRATE:</b> 5184mm/min <b>MAXIMUM SPINDLE SPEED:</b> 8100rpm <b>CUTTING DISTANCE:</b> 75487.6mm <b>RAPID DISTANCE:</b> 75414.23mm <b>ESTIMATED CYCLE TIME:</b> 1h:12m:38s

Tools			
<b>T10001</b> D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: <a href="#">1K335-2000-300-XD 1730</a>	MAXIMUM FEED: 5184mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 34695.48mm RAPID DISTANCE: 36232.04mm ESTIMATED CYCLE TIME: 15m:24s (21.2%)	HOLDER: BT40 - B4C4-1000	
<b>T10002</b> D10002 L10002 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: <a href="#">1K334-1000-100-XD 1730</a>	MAXIMUM FEED: 3012.053mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 8134.05mm RAPID DISTANCE: 7456.83mm ESTIMATED CYCLE TIME: 8m:56s (12.3%)	HOLDER: BT40 - B4C4-1000	
<b>T10003</b> 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: <a href="#">1K377-0800-050-XD 1730</a>	MAXIMUM FEED: 1780mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 20564.11mm RAPID DISTANCE: 17566.19mm ESTIMATED CYCLE TIME: 30m:33s (42.1%)	HOLDER: BT40 - B4C4-1000	
<b>T10007</b> D10007 L10007 TYPE: drill DIAMETER: 4.5mm TIP ANGLE: 118° LENGTH: 55mm FLUTES: 2 DESCRIPTION: Punta a forare M4.5 H8 VENDOR: Mitsubishi PRODUCT: VSDD0450	MAXIMUM FEED: 532.47mm/min MAXIMUM SPINDLE SPEED: 5145rpm CUTTING DISTANCE: 53.96mm RAPID DISTANCE: 83.96mm ESTIMATED CYCLE TIME: 7s (0.2%)	HOLDER: BT40 - B4C4-1000	
<b>T10013</b> D10013 L10013 TYPE: chamfer mill DIAMETER: 12mm TAPER ANGLE: 45° LENGTH: 50mm FLUTES: 6 DESCRIPTION: Fresa per smussature VENDOR: Sandvik PRODUCT: <a href="#">1C050-0300-045-XB 1620</a>	MAXIMUM FEED: 2916mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 372.91mm RAPID DISTANCE: 195.03mm ESTIMATED CYCLE TIME: 12s (0.3%)	HOLDER: BT40 - B4C4-1000	
<b>T10014</b> D10014 L10014 TYPE: drill DIAMETER: 4.2mm TIP ANGLE: 118° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Punta a forare M4.2 H8 VENDOR: Mitsubishi PRODUCT: VSDD0420	MAXIMUM FEED: 534.567mm/min MAXIMUM SPINDLE SPEED: 5534rpm CUTTING DISTANCE: 42.52mm RAPID DISTANCE: 252.52mm ESTIMATED CYCLE TIME: 8s (0.2%)	HOLDER: BT40 - B4C4-1000	

<b>T10109 D10109 L10109</b> TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 1.2mm LENGTH: 60mm FLUTES: 3 DESCRIPTION: Fresa per lavorazione grossa tasca centrale VENDOR: Sandvik PRODUCT: <a href="#">R390-040C4-18M060</a>	MAXIMUM FEED: 2864.789mm/min MAXIMUM SPINDLE SPEED: 4775rpm CUTTING DISTANCE: 1926.11mm RAPID DISTANCE: 51.75mm ESTIMATED CYCLE TIME: 48s (1.1%)	HOLDER: BT40 - B4C4-1000	
<b>T10110 D10110 L10110</b> TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>	MAXIMUM FEED: 4458.366mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 6039.58mm RAPID DISTANCE: 5151.09mm ESTIMATED CYCLE TIME: 6m:23s (8.8%)	HOLDER: BT40 - B4C4-1000	
<b>T10112 D10112 L10112</b> TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: <a href="#">R216.24-10050CCK22P 1620</a>	MAXIMUM FEED: 3057.303mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 3228.05mm RAPID DISTANCE: 7873.97mm ESTIMATED CYCLE TIME: 3m:28s (4.8%)	HOLDER: BT40 - B4C4-1000	
<b>T10113 D10113 L10113</b> TYPE: drill DIAMETER: 20mm TIP ANGLE: 147° LENGTH: 110mm FLUTES: 2 DESCRIPTION: Punta a forare M20 H8 VENDOR: Sandvik PRODUCT: <a href="#">860.1-2000-077A1-PM P1BM</a>	MAXIMUM FEED: 576.357mm/min MAXIMUM SPINDLE SPEED: 1253rpm CUTTING DISTANCE: 97.56mm RAPID DISTANCE: 127.56mm ESTIMATED CYCLE TIME: 12s (0.3%)	HOLDER: BT40 - B4C4-1000	
<b>T10118 D10118 L10118</b> TYPE: drill DIAMETER: 14mm TIP ANGLE: 147° LENGTH: 150mm FLUTES: 2 DESCRIPTION: Punta a forare M14 H8 VENDOR: Sandvik PRODUCT: <a href="#">860.1-1400-115A1-PM P1BM</a>	MAXIMUM FEED: 535.928mm/min MAXIMUM SPINDLE SPEED: 1664rpm CUTTING DISTANCE: 128.11mm RAPID DISTANCE: 158.11mm ESTIMATED CYCLE TIME: 16s (0.4%)	HOLDER: BT40 - B4C4-1000	
<b>T10120 D10120 L10120</b> TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 120mm FLUTES: 2 DESCRIPTION: Punta a forare M12 H8 VENDOR: Sandvik PRODUCT: <a href="#">860.1-1200-098A1-PM P1BM</a>	MAXIMUM FEED: 535.906mm/min MAXIMUM SPINDLE SPEED: 1942rpm CUTTING DISTANCE: 205.17mm RAPID DISTANCE: 265.17mm ESTIMATED CYCLE TIME: 26s (0.6%)	HOLDER: BT40 - B4C4-1000	

### Operations

Operation 1/63  
 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 (0.6%)  
 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 2/63  
 DESCRIPTION: Finishing  
 STRATEGY: Facing  
 WCS: #0  
 TOLERANCE: 0.01mm  
 MAXIMUM STEPDOWN: 36mm

MAXIMUM SPINDLE SPEED: 4775rpm  
 MAXIMUM FEEDRATE: 2864.789mm/min  
 CUTTING DISTANCE: 963.12mm  
 RAPID DISTANCE: 26mm  
 ESTIMATED CYCLE TIME: 21s (0.5%)  
 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 3/63  
 DESCRIPTION: Roughing  
 STRATEGY: Adaptive  
 WCS: #0  
 TOLERANCE: 0.1mm  
 STOCK TO LEAVE: 0.25mm  
 MAXIMUM STEPDOWN: 19.95mm  
 OPTIMAL LOAD: 6.75mm  
 LOAD DEVIATION: 0.68mm

MAXIMUM SPINDLE SPEED: 8100rpm  
 MAXIMUM FEEDRATE: 4876.077mm/min  
 CUTTING DISTANCE: 10472.93mm  
 RAPID DISTANCE: 10819.7mm  
 ESTIMATED CYCLE TIME: 4m:19s (5.9%)  
 COOLANT: Flood

**T10001 D10001 L10001**  
 TYPE: bullnose end mill  
 DIAMETER: 20mm  
 CORNER RADIUS: 3mm  
 LENGTH: 80mm  
 FLUTES: 4  
 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate  
 VENDOR: Sandvik  
 PRODUCT: [1K335-2000-300-XD 1730](#)

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 4/63 DESCRIPTION: Roughing1 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 19.95mm OPTIMAL LOAD: 6.75mm LOAD DEVIATION: 0.68mm NOTES: <div>This roughing operation may lead to collisions with the shaft or holder, due to a known limitation in Fusion. Enabling Shaft &amp; Holder might help but results vary. Please check the See details in <a href="https://cloudnc.atlassian.net/wiki/x/AYCREG">https://cloudnc.atlassian.net/wiki/x/AYCREG</a></div>	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4876.077mm/min CUTTING DISTANCE: 10752.4mm RAPID DISTANCE: 11550.94mm ESTIMATED CYCLE TIME: 4m:33s (6.3%) COOLANT: Flood	<b>T10001</b> D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggate VENDOR: Sandvik PRODUCT: <a href="#">1K335-2000-300-XD 1730</a>
Operation 5/63 DESCRIPTION: Roughing2 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 19.95mm OPTIMAL LOAD: 6.75mm LOAD DEVIATION: 0.68mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4876.077mm/min CUTTING DISTANCE: 3650.83mm RAPID DISTANCE: 3881.27mm ESTIMATED CYCLE TIME: 2m:16s (3.1%) COOLANT: Flood	<b>T10001</b> D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggate VENDOR: Sandvik PRODUCT: <a href="#">1K335-2000-300-XD 1730</a>
Operation 6/63 DESCRIPTION: Roughing3 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 19.95mm OPTIMAL LOAD: 6.75mm LOAD DEVIATION: 0.68mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4876.077mm/min CUTTING DISTANCE: 3610.65mm RAPID DISTANCE: 5125.61mm ESTIMATED CYCLE TIME: 2m:0s (2.7%) COOLANT: Flood	<b>T10001</b> D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggate VENDOR: Sandvik PRODUCT: <a href="#">1K335-2000-300-XD 1730</a>
Operation 7/63 DESCRIPTION: Roughing4 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 19.95mm OPTIMAL LOAD: 6.75mm LOAD DEVIATION: 0.68mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4876.077mm/min CUTTING DISTANCE: 2213.21mm RAPID DISTANCE: 4200.78mm ESTIMATED CYCLE TIME: 1m:18s (1.8%) COOLANT: Flood	<b>T10001</b> D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggate VENDOR: Sandvik PRODUCT: <a href="#">1K335-2000-300-XD 1730</a>
Operation 8/63 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: 3065.92mm RAPID DISTANCE: 2234.17mm ESTIMATED CYCLE TIME: 4m:24s (6%) COOLANT: Flood	<b>T10110</b> D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
Operation 9/63 DESCRIPTION: Roughing6 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 2.2mm OPTIMAL LOAD: 7.5mm LOAD DEVIATION: 0.75mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3012.053mm/min CUTTING DISTANCE: 2528.9mm RAPID DISTANCE: 1442.3mm ESTIMATED CYCLE TIME: 1m:8s (1.6%) COOLANT: Flood	<b>T10002</b> D10002 L10002 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: <a href="#">1K334-1000-100-XD 1730</a>
Operation 10/63 DESCRIPTION: Roughing7 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 2.2mm OPTIMAL LOAD: 7.5mm LOAD DEVIATION: 0.75mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3012.053mm/min CUTTING DISTANCE: 2838.92mm RAPID DISTANCE: 2003.48mm ESTIMATED CYCLE TIME: 4m:55s (6.8%) COOLANT: Flood	<b>T10002</b> D10002 L10002 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: <a href="#">1K334-1000-100-XD 1730</a>
Operation 11/63 DESCRIPTION: Roughing8 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 2.2mm OPTIMAL LOAD: 7.5mm LOAD DEVIATION: 0.75mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3012.053mm/min CUTTING DISTANCE: 582.14mm RAPID DISTANCE: 1154.04mm ESTIMATED CYCLE TIME: 36s (0.8%) COOLANT: Flood	<b>T10002</b> D10002 L10002 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: <a href="#">1K334-1000-100-XD 1730</a>
Operation 12/63 DESCRIPTION: Roughing9 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 2.2mm OPTIMAL LOAD: 7.5mm LOAD DEVIATION: 0.75mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3012.053mm/min CUTTING DISTANCE: 583.22mm RAPID DISTANCE: 1286.93mm ESTIMATED CYCLE TIME: 38s (0.9%) COOLANT: Flood	<b>T10002</b> D10002 L10002 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: <a href="#">1K334-1000-100-XD 1730</a>

Operation 13/63 DESCRIPTION: Roughing10 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 2.2mm OPTIMAL LOAD: 7.5mm LOAD DEVIATION: 0.75mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3012.053mm/min CUTTING DISTANCE: 413.19mm RAPID DISTANCE: 404.44mm ESTIMATED CYCLE TIME: 39s (0.9%) COOLANT: Flood	<b>T10002 D10002 L10002</b> TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: <a href="#">1K334-1000-100-XD 1730</a>
Operation 14/63 DESCRIPTION: Roughing11 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: 2376.89mm RAPID DISTANCE: 6627.84mm ESTIMATED CYCLE TIME: 2m:40s (3.7%) COOLANT: Flood	<b>T10112 D10112 L10112</b> TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: <a href="#">R216.24-10050CCK22P 1620</a>
Operation 15/63 DESCRIPTION: Roughing12 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.8mm OPTIMAL LOAD: 5.7mm LOAD DEVIATION: 0.57mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1704.805mm/min CUTTING DISTANCE: 3893.75mm RAPID DISTANCE: 1599.75mm ESTIMATED CYCLE TIME: 10m:55s (15%) COOLANT: Flood	<b>T10003 D10003 L10003</b> TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: <a href="#">1K377-0800-050-XD 1730</a>
Operation 16/63 DESCRIPTION: Roughing13 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.8mm OPTIMAL LOAD: 5.7mm LOAD DEVIATION: 0.57mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1704.805mm/min CUTTING DISTANCE: 96.02mm RAPID DISTANCE: 240.42mm ESTIMATED CYCLE TIME: 6s (0.1%) COOLANT: Flood	<b>T10003 D10003 L10003</b> TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: <a href="#">1K377-0800-050-XD 1730</a>
Operation 17/63 DESCRIPTION: Roughing14 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.8mm OPTIMAL LOAD: 5.7mm LOAD DEVIATION: 0.57mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1704.805mm/min CUTTING DISTANCE: 95.56mm RAPID DISTANCE: 244.55mm ESTIMATED CYCLE TIME: 6s (0.1%) COOLANT: Flood	<b>T10003 D10003 L10003</b> TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: <a href="#">1K377-0800-050-XD 1730</a>
Operation 18/63 DESCRIPTION: Flat WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 9.8mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3240mm/min CUTTING DISTANCE: 165.96mm RAPID DISTANCE: 332.76mm ESTIMATED CYCLE TIME: 8s (0.2%) COOLANT: Flood	<b>T10001 D10001 L10001</b> TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggate VENDOR: Sandvik PRODUCT: <a href="#">1K335-2000-300-XD 1730</a>
Operation 19/63 DESCRIPTION: Flat1 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	<b>T10110 D10110 L10110</b> TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
Operation 20/63 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: 1088.65mm RAPID DISTANCE: 1090.59mm ESTIMATED CYCLE TIME: 36s (0.8%) COOLANT: Flood	<b>T10110 D10110 L10110</b> TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
NOTES:  This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 21/63 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: 95.32mm RAPID DISTANCE: 109.66mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	<b>T10110 D10110 L10110</b> TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
Operation 22/63 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: 1084.93mm RAPID DISTANCE: 893.04mm ESTIMATED CYCLE TIME: 33s (0.8%) COOLANT: Flood	<b>T10110 D10110 L10110</b> TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>

<b>NOTES:</b>  This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 23/63 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: 178.27mm RAPID DISTANCE: 359.53mm ESTIMATED CYCLE TIME: 10s (0.2%) COOLANT: Flood	<b>T10110 D10110 L10110</b> TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
Operation 24/63 Description: Flat6 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 7mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1620mm/min CUTTING DISTANCE: 275.52mm RAPID DISTANCE: 317.28mm ESTIMATED CYCLE TIME: 15s (0.4%) COOLANT: Flood	<b>T10002 D10002 L10002</b> TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: <a href="#">1K334-1000-100-XD 1730</a>
Operation 25/63 Description: Flat7 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 7mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1620mm/min CUTTING DISTANCE: 137mm RAPID DISTANCE: 96.55mm ESTIMATED CYCLE TIME: 7s (0.2%) COOLANT: Flood	<b>T10002 D10002 L10002</b> TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: <a href="#">1K334-1000-100-XD 1730</a>
Operation 26/63 Description: Flat8 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: 377.92mm RAPID DISTANCE: 597.37mm ESTIMATED CYCLE TIME: 22s (0.5%) COOLANT: Flood	<b>T10112 D10112 L10112</b> TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: <a href="#">R216.24-10050CCK22P 1620</a>
<b>NOTES:</b>  This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 27/63 Description: Flat9 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: 377.93mm RAPID DISTANCE: 536.03mm ESTIMATED CYCLE TIME: 21s (0.5%) COOLANT: Flood	<b>T10112 D10112 L10112</b> TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: <a href="#">R216.24-10050CCK22P 1620</a>
<b>NOTES:</b>  This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 28/63 Description: Flat10 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 4.9mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 1435.89mm RAPID DISTANCE: 3230.48mm ESTIMATED CYCLE TIME: 1m:47s (2.5%) COOLANT: Flood	<b>T10003 D10003 L10003</b> TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: <a href="#">1K377-0800-050-XD 1730</a>
Operation 29/63 Description: Wall 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 (0.3%) COOLANT: Flood	<b>T10003 D10003 L10003</b> TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: <a href="#">1K377-0800-050-XD 1730</a>
Operation 30/63 Description: Wall1 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 (0.3%) COOLANT: Flood	<b>T10003 D10003 L10003</b> TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: <a href="#">1K377-0800-050-XD 1730</a>
Operation 31/63 Description: Wall2 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 (0.3%) COOLANT: Flood	<b>T10003 D10003 L10003</b> TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: <a href="#">1K377-0800-050-XD 1730</a>

Operation 32/63 DESCRIPTION: Wall3 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	<b>T10110 D10110 L10110</b> TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
Operation 33/63 DESCRIPTION: Wall4 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	<b>T10110 D10110 L10110</b> TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
Operation 34/63 DESCRIPTION: Wall5 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	<b>T10110 D10110 L10110</b> TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
Operation 35/63 DESCRIPTION: Wall6 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 (0.5%) COOLANT: Flood	<b>T10110 D10110 L10110</b> TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
Operation 36/63 DESCRIPTION: Wall7 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 38mm MAXIMUM STEPOVER: 13.3mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5184mm/min CUTTING DISTANCE: 110.97mm RAPID DISTANCE: 58.99mm ESTIMATED CYCLE TIME: 3s (0.1%) COOLANT: Flood	<b>T10001 D10001 L10001</b> TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggate VENDOR: Sandvik PRODUCT: <a href="#">1K335-2000-300-XD 1730</a>
Operation 37/63 DESCRIPTION: Wall8 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 22mm MAXIMUM STEPOVER: 9.5mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2592mm/min CUTTING DISTANCE: 108.8mm RAPID DISTANCE: 36.23mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	<b>T10002 D10002 L10002</b> TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: <a href="#">1K334-1000-100-XD 1730</a>
Operation 38/63 DESCRIPTION: Wall9 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 22mm MAXIMUM STEPOVER: 9.5mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2592mm/min CUTTING DISTANCE: 188.43mm RAPID DISTANCE: 263.76mm ESTIMATED CYCLE TIME: 10s (0.2%) COOLANT: Flood	<b>T10002 D10002 L10002</b> TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: <a href="#">1K334-1000-100-XD 1730</a>
Operation 39/63 DESCRIPTION: Wall10 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 22mm MAXIMUM STEPOVER: 9.5mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2592mm/min CUTTING DISTANCE: 346.23mm RAPID DISTANCE: 261.87mm ESTIMATED CYCLE TIME: 16s (0.4%) COOLANT: Flood	<b>T10002 D10002 L10002</b> TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: <a href="#">1K334-1000-100-XD 1730</a>
Operation 40/63 DESCRIPTION: Wall11 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 22mm MAXIMUM STEPOVER: 9.5mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2592mm/min CUTTING DISTANCE: 90.57mm RAPID DISTANCE: 88.75mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	<b>T10002 D10002 L10002</b> TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: <a href="#">1K334-1000-100-XD 1730</a>
Operation 41/63 DESCRIPTION: Wall12 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 22mm MAXIMUM STEPOVER: 9.5mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2592mm/min CUTTING DISTANCE: 41.12mm RAPID DISTANCE: 101.2mm ESTIMATED CYCLE TIME: 3s (0.1%) COOLANT: Flood	<b>T10002 D10002 L10002</b> TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: <a href="#">1K334-1000-100-XD 1730</a>
Operation 42/63 DESCRIPTION: Wall13 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 11mm MAXIMUM STEPOVER: 9.31mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1265mm/min CUTTING DISTANCE: 95.3mm RAPID DISTANCE: 112.73mm ESTIMATED CYCLE TIME: 6s (0.1%) COOLANT: Flood	<b>T10112 D10112 L10112</b> TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: <a href="#">R216.24-10050CCK22P 1620</a>

Operation 43/63 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 (0.4%) COOLANT: Flood	<b>T10120</b> D10120 L10120 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 120mm FLUTES: 2 DESCRIPTION: Punta a forare M12 H8 VENDOR: Sandvik PRODUCT: <a href="#">860.1-1200-098A1-PM P1BM</a>
Operation 44/63 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 (0.2%) COOLANT: Flood	<b>T10120</b> D10120 L10120 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 120mm FLUTES: 2 DESCRIPTION: Punta a forare M12 H8 VENDOR: Sandvik PRODUCT: <a href="#">860.1-1200-098A1-PM P1BM</a>
Operation 45/63 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 (0.3%) COOLANT: Flood	<b>T10113</b> D10113 L10113 TYPE: drill DIAMETER: 20mm TIP ANGLE: 147° LENGTH: 110mm FLUTES: 2 DESCRIPTION: Punta a forare M20 H8 VENDOR: Sandvik PRODUCT: <a href="#">860.1-2000-077A1-PM P1BM</a>
Operation 46/63 DESCRIPTION: Holemaking3 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 5534rpm MAXIMUM FEEDRATE: 534.567mm/min CUTTING DISTANCE: 42.52mm RAPID DISTANCE: 252.52mm ESTIMATED CYCLE TIME: 8s (0.2%) COOLANT: Flood	<b>T10014</b> D10014 L10014 TYPE: drill DIAMETER: 4.2mm TIP ANGLE: 118° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Punta a forare M4.2 H8 VENDOR: Mitsubishi PRODUCT: VSDD0420
Operation 47/63 DESCRIPTION: Holemaking4 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 5145rpm MAXIMUM FEEDRATE: 532.47mm/min CUTTING DISTANCE: 53.96mm RAPID DISTANCE: 83.96mm ESTIMATED CYCLE TIME: 7s (0.2%) COOLANT: Flood	<b>T10007</b> D10007 L10007 TYPE: drill DIAMETER: 4.5mm TIP ANGLE: 118° LENGTH: 55mm FLUTES: 2 DESCRIPTION: Punta a forare M4.5 H8 VENDOR: Mitsubishi PRODUCT: VSDD0450
Operation 48/63 DESCRIPTION: Holemaking5 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1664rpm MAXIMUM FEEDRATE: 535.928mm/min CUTTING DISTANCE: 128.11mm RAPID DISTANCE: 158.11mm ESTIMATED CYCLE TIME: 16s (0.4%) COOLANT: Flood	<b>T10118</b> D10118 L10118 TYPE: drill DIAMETER: 14mm TIP ANGLE: 147° LENGTH: 150mm FLUTES: 2 DESCRIPTION: Punta a forare M14 H8 VENDOR: Sandvik PRODUCT: <a href="#">860.1-1400-115A1-PM P1BM</a>
Operation 49/63 DESCRIPTION: Freeform STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.49mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5184mm/min CUTTING DISTANCE: 32.98mm RAPID DISTANCE: 46.54mm ESTIMATED CYCLE TIME: 1s (0%) COOLANT: Flood	<b>T10001</b> D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggate VENDOR: Sandvik PRODUCT: <a href="#">1K335-2000-300-XD 1730</a>
Operation 50/63 DESCRIPTION: Freeform1 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.25mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5184mm/min CUTTING DISTANCE: 1762.99mm RAPID DISTANCE: 49.83mm ESTIMATED CYCLE TIME: 21s (0.5%) COOLANT: Flood	<b>T10001</b> D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggate VENDOR: Sandvik PRODUCT: <a href="#">1K335-2000-300-XD 1730</a>
Operation 51/63 DESCRIPTION: Freeform3 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.25mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5184mm/min CUTTING DISTANCE: 93.78mm RAPID DISTANCE: 66.18mm ESTIMATED CYCLE TIME: 3s (0.1%) COOLANT: Flood	<b>T10001</b> D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggate VENDOR: Sandvik PRODUCT: <a href="#">1K335-2000-300-XD 1730</a>
Operation 52/63 DESCRIPTION: Freeform4 STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.49mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5184mm/min CUTTING DISTANCE: 32.98mm RAPID DISTANCE: 46.54mm ESTIMATED CYCLE TIME: 1s (0%) COOLANT: Flood	<b>T10001</b> D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggate VENDOR: Sandvik PRODUCT: <a href="#">1K335-2000-300-XD 1730</a>



Operation 53/63 DESCRIPTION: Freeform5 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.25mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5184mm/min CUTTING DISTANCE: 1795.78mm RAPID DISTANCE: 52.9mm ESTIMATED CYCLE TIME: 22s (0.5%) COOLANT: Flood	<b>T10001</b> D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: <a href="#">1K335-2000-300-XD 1730</a>
Operation 54/63 DESCRIPTION: Freeform6 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 (2.5%) COOLANT: Flood	<b>T10003</b> 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: <a href="#">1K377-0800-050-XD 1730</a>
Operation 55/63 DESCRIPTION: Freeform7 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: 909.73mm RAPID DISTANCE: 173.93mm ESTIMATED CYCLE TIME: 56s (1.3%) COOLANT: Flood	<b>T10003</b> 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: <a href="#">1K377-0800-050-XD 1730</a>
Operation 56/63 DESCRIPTION: Freeform8 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: 5521.18mm RAPID DISTANCE: 7777.93mm ESTIMATED CYCLE TIME: 6m:54s (9.5%) COOLANT: Flood	<b>T10003</b> 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: <a href="#">1K377-0800-050-XD 1730</a>
Operation 57/63 DESCRIPTION: Freeform9 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: 5210.08mm RAPID DISTANCE: 242.01mm ESTIMATED CYCLE TIME: 5m:3s (7%) COOLANT: Flood	<b>T10003</b> 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: <a href="#">1K377-0800-050-XD 1730</a>
Operation 58/63 DESCRIPTION: Freeform10 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 (1.8%) COOLANT: Flood	<b>T10003</b> 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: <a href="#">1K377-0800-050-XD 1730</a>
Operation 59/63 DESCRIPTION: Freeform11 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: 915.53mm RAPID DISTANCE: 174.28mm ESTIMATED CYCLE TIME: 57s (1.3%) COOLANT: Flood	<b>T10003</b> 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: <a href="#">1K377-0800-050-XD 1730</a>
Operation 60/63 DESCRIPTION: Chamfering WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2916mm/min CUTTING DISTANCE: 81.76mm RAPID DISTANCE: 62.38mm ESTIMATED CYCLE TIME: 3s (0.1%) COOLANT: Flood	<b>T10013</b> D10013 L10013 TYPE: chamfer mill DIAMETER: 12mm TAPER ANGLE: 45° LENGTH: 50mm FLUTES: 6 DESCRIPTION: Fresa per smussature VENDOR: Sandvik PRODUCT: <a href="#">1C050-0300-045-XB 1620</a>
Operation 61/63 DESCRIPTION: Chamfering1 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2916mm/min CUTTING DISTANCE: 75.48mm RAPID DISTANCE: 62.38mm ESTIMATED CYCLE TIME: 3s (0.1%) COOLANT: Flood	<b>T10013</b> D10013 L10013 TYPE: chamfer mill DIAMETER: 12mm TAPER ANGLE: 45° LENGTH: 50mm FLUTES: 6 DESCRIPTION: Fresa per smussature VENDOR: Sandvik PRODUCT: <a href="#">1C050-0300-045-XB 1620</a>
Operation 62/63 DESCRIPTION: Chamfering2 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2916mm/min CUTTING DISTANCE: 114.59mm RAPID DISTANCE: 32.38mm ESTIMATED CYCLE TIME: 3s (0.1%) COOLANT: Flood	<b>T10013</b> D10013 L10013 TYPE: chamfer mill DIAMETER: 12mm TAPER ANGLE: 45° LENGTH: 50mm FLUTES: 6 DESCRIPTION: Fresa per smussature VENDOR: Sandvik PRODUCT: <a href="#">1C050-0300-045-XB 1620</a>



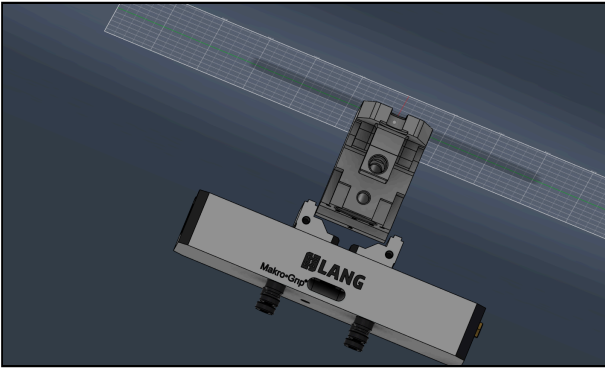
Operation 63/63  
DESCRIPTION: Chamfering3  
WCS: #0  
TOLERANCE: 0.01mm  
STOCK TO LEAVE: 0mm

MAXIMUM SPINDLE SPEED: 8100rpm  
MAXIMUM FEEDRATE: 2916mm/min  
CUTTING DISTANCE: 101.08mm  
RAPID DISTANCE: 37.9mm  
ESTIMATED CYCLE TIME: 3s (0.1%)  
COOLANT: Flood

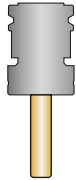
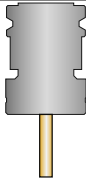
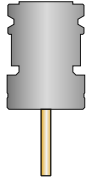
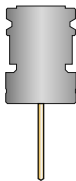
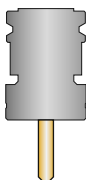
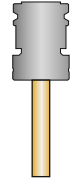
**T10013 D10013 L10013**  
TYPE: chamfer mill  
DIAMETER: 12mm  
TAPER ANGLE: 45°  
LENGTH: 50mm  
FLUTES: 6  
DESCRIPTION: Fresa per smussature  
VENDOR: Sandvik  
PRODUCT: [1C050-0300-045-XB 1620](#)

## Setup Sheet for Program 1002

JOB DESCRIPTION: AutoSetup 2  
DOCUMENT PATH: 0NC01\_DFM\_01 v2

Setup	
<b>WCS: #0</b> <b>Stock:</b> DX: 244mm DY: 85mm DZ: 120mm <b>PART:</b> DX: 234mm DY: 75mm DZ: 110mm <b>Stock Lower in WCS #0:</b> X: -122mm Y: -42.5mm Z: -120mm <b>Stock Upper in WCS #0:</b> X: 122mm Y: 42.5mm Z: 0mm	

Total
<b>NUMBER OF OPERATIONS:</b> 26 <b>NUMBER OF TOOLS:</b> 9 <b>TOOLS:</b> T10001 T10002 T10003 T10006 T10013 T10110 T10112 T10114 T10120 <b>MAXIMUM FEEDRATE:</b> 5184mm/min <b>MAXIMUM SPINDLE SPEED:</b> 8100rpm <b>CUTTING DISTANCE:</b> 25797.25mm <b>RAPID DISTANCE:</b> 46740.63mm <b>ESTIMATED CYCLE TIME:</b> 21m:45s

Tools			
<b>T10001</b> D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: <a href="#">1K335-2000-300-XD 1730</a>	MAXIMUM FEED: 5184mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 19864.48mm RAPID DISTANCE: 30917.28mm ESTIMATED CYCLE TIME: 11m:44s (53.9%)	HOLDER: BT40 - B4C4-1000	
<b>T10002</b> D10002 L10002 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: <a href="#">1K334-1000-100-XD 1730</a>	MAXIMUM FEED: 3012.053mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 777.88mm RAPID DISTANCE: 2065.13mm ESTIMATED CYCLE TIME: 40s (3.1%)	HOLDER: BT40 - B4C4-1000	
<b>T10003</b> 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: <a href="#">1K377-0800-050-XD 1730</a>	MAXIMUM FEED: 1704.805mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 734.08mm RAPID DISTANCE: 3340.57mm ESTIMATED CYCLE TIME: 1m:6s (5.1%)	HOLDER: BT40 - B4C4-1000	
<b>T10006</b> D10006 L10006 TYPE: drill DIAMETER: 5mm TIP ANGLE: 118° LENGTH: 70mm FLUTES: 2 DESCRIPTION: Punta a forare M5 H8 VENDOR: Mitsubishi PRODUCT: VSDD0500	MAXIMUM FEED: 532.782mm/min MAXIMUM SPINDLE SPEED: 4633rpm CUTTING DISTANCE: 194.01mm RAPID DISTANCE: 393.02mm ESTIMATED CYCLE TIME: 27s (2%)	HOLDER: BT40 - B4C4-1000	
<b>T10013</b> D10013 L10013 TYPE: chamfer mill DIAMETER: 12mm TAPER ANGLE: 45° LENGTH: 50mm FLUTES: 6 DESCRIPTION: Fresa per smussature VENDOR: Sandvik PRODUCT: <a href="#">1C050-0300-045-XB 1620</a>	MAXIMUM FEED: 2916mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 471.81mm RAPID DISTANCE: 292.63mm ESTIMATED CYCLE TIME: 15s (1.1%)	HOLDER: BT40 - B4C4-1000	
<b>T10110</b> D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>	MAXIMUM FEED: 4458.366mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 3342.78mm RAPID DISTANCE: 9219.4mm ESTIMATED CYCLE TIME: 3m:29s (16%)	HOLDER: BT40 - B4C4-1000	

<b>T10112</b> 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: <a href="#">R216.24-10050CCK22P 1620</a>	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	
<b>T10114</b> D10114 L10114 TYPE: drill DIAMETER: 3mm TIP ANGLE: 118° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Punta a forare M3 H8 VENDOR: Mitsubishi PRODUCT: VSDD0300	MAXIMUM FEED: 528.409mm/min MAXIMUM SPINDLE SPEED: 7658rpm CUTTING DISTANCE: 13.9mm RAPID DISTANCE: 43.9mm ESTIMATED CYCLE TIME: 2s (0.2%)	HOLDER: BT40 - B4C4-1000	
<b>T10120</b> D10120 L10120 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 120mm FLUTES: 2 DESCRIPTION: Punta a forare M12 H8 VENDOR: Sandvik PRODUCT: <a href="#">860.1-1200-098A1-PM P1BM</a>	MAXIMUM FEED: 535.906mm/min MAXIMUM SPINDLE SPEED: 1942rpm CUTTING DISTANCE: 127.12mm RAPID DISTANCE: 157.12mm ESTIMATED CYCLE TIME: 16s (1.2%)	HOLDER: BT40 - B4C4-1000	

### Operations

Operation 1/26 DESCRIPTION: Roughing STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 19.95mm OPTIMAL LOAD: 6.75mm LOAD DEVIATION: 0.68mm 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 <a href="https://cloudnc.atlassian.net/wiki/x/AYCREg">https://cloudnc.atlassian.net/wiki/x/AYCREg</a>	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4876.077mm/min CUTTING DISTANCE: 19048.48mm RAPID DISTANCE: 29528.42mm ESTIMATED CYCLE TIME: 11m:13s (51.5%) COOLANT: Flood	<b>T10001</b> D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggate VENDOR: Sandvik PRODUCT: <a href="#">1K335-2000-300-XD 1730</a>
Operation 2/26 DESCRIPTION: Roughing1 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 19.95mm OPTIMAL LOAD: 6.75mm LOAD DEVIATION: 0.68mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4876.077mm/min CUTTING DISTANCE: 243.38mm RAPID DISTANCE: 151.9mm ESTIMATED CYCLE TIME: 5s (0.4%) COOLANT: Flood	<b>T10001</b> D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggate VENDOR: Sandvik PRODUCT: <a href="#">1K335-2000-300-XD 1730</a>
Operation 3/26 DESCRIPTION: Roughing2 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 19.95mm OPTIMAL LOAD: 6.75mm LOAD DEVIATION: 0.68mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4876.077mm/min CUTTING DISTANCE: 175.29mm RAPID DISTANCE: 147.36mm ESTIMATED CYCLE TIME: 4s (0.3%) COOLANT: Flood	<b>T10001</b> D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggate VENDOR: Sandvik PRODUCT: <a href="#">1K335-2000-300-XD 1730</a>
Operation 4/26 DESCRIPTION: Roughing3 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 3.5mm OPTIMAL LOAD: 15mm LOAD DEVIATION: 1.5mm 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 <a href="https://cloudnc.atlassian.net/wiki/x/AYCREg">https://cloudnc.atlassian.net/wiki/x/AYCREg</a>	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4458.366mm/min CUTTING DISTANCE: 336.61mm RAPID DISTANCE: 1805.51mm ESTIMATED CYCLE TIME: 26s (2%) COOLANT: Flood	<b>T10110</b> D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
Operation 5/26 DESCRIPTION: Roughing4 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: 130.47mm RAPID DISTANCE: 455.25mm ESTIMATED CYCLE TIME: 7s (0.6%) COOLANT: Flood	<b>T10110</b> D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
Operation 6/26 DESCRIPTION: Roughing5 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 2.2mm OPTIMAL LOAD: 7.5mm LOAD DEVIATION: 0.75mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3012.053mm/min CUTTING DISTANCE: 777.88mm RAPID DISTANCE: 2065.13mm ESTIMATED CYCLE TIME: 40s (3.1%) COOLANT: Flood	<b>T10002</b> D10002 L10002 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: <a href="#">1K334-1000-100-XD 1730</a>

<b>NOTES:</b>  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 <a href="https://cloudnc.atlassian.net/wiki/x/AYCREg">https://cloudnc.atlassian.net/wiki/x/AYCREg</a>		
Operation 7/26 DESCRIPTION: Roughing6 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.8mm OPTIMAL LOAD: 5.7mm LOAD DEVIATION: 0.57mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1704.805mm/min CUTTING DISTANCE: 202.74mm RAPID DISTANCE: 594.4mm ESTIMATED CYCLE TIME: 14s (1.1%) COOLANT: Flood	<b>T10003</b> 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: <a href="#">1K377-0800-050-XD 1730</a>
Operation 8/26 DESCRIPTION: Roughing7 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.8mm OPTIMAL LOAD: 5.7mm LOAD DEVIATION: 0.57mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1704.805mm/min CUTTING DISTANCE: 229.22mm RAPID DISTANCE: 576.08mm ESTIMATED CYCLE TIME: 15s (1.1%) COOLANT: Flood	<b>T10003</b> 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: <a href="#">1K377-0800-050-XD 1730</a>
Operation 9/26 DESCRIPTION: Roughing8 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.8mm OPTIMAL LOAD: 5.7mm LOAD DEVIATION: 0.57mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1704.805mm/min CUTTING DISTANCE: 302.13mm RAPID DISTANCE: 2170.09mm ESTIMATED CYCLE TIME: 37s (2.8%) COOLANT: Flood	<b>T10003</b> 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: <a href="#">1K377-0800-050-XD 1730</a>
<b>NOTES:</b>  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 <a href="https://cloudnc.atlassian.net/wiki/x/AYCREg">https://cloudnc.atlassian.net/wiki/x/AYCREg</a>		
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 (3.7%) COOLANT: Flood	<b>T10110</b> D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
Operation 11/26 DESCRIPTION: Flat1 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 535.86mm RAPID DISTANCE: 2035.16mm ESTIMATED CYCLE TIME: 43s (3.3%) COOLANT: Flood	<b>T10110</b> D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
<b>NOTES:</b>  This flat finishing operation may not fully finish the surface. Please check the simulation.		
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 (2.3%) COOLANT: Flood	<b>T10110</b> D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
<b>NOTES:</b>  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	<b>T10110</b> D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
<b>NOTES:</b>  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	<b>T10110</b> D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
<b>NOTES:</b>  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: 3240mm/min CUTTING DISTANCE: 324.75mm RAPID DISTANCE: 947.61mm ESTIMATED CYCLE TIME: 18s (1.4%) COOLANT: Flood	<b>T10001</b> D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: <a href="#">1K335-2000-300-XD 1730</a>
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	<b>T10112</b> 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: <a href="#">R216.24-10050CCK22P 1620</a>
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	<b>T10110</b> D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
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	<b>T10110</b> D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
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: 151.82mm RAPID DISTANCE: 101.75mm ESTIMATED CYCLE TIME: 10s (0.8%) COOLANT: Flood	<b>T10110</b> D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
Operation 20/26 DESCRIPTION: Wall3 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	<b>T10110</b> D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: <a href="#">1K365-2000-XD 1730</a>
Operation 21/26 DESCRIPTION: Wall4 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 38mm MAXIMUM STEPOVER: 13.3mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5184mm/min CUTTING DISTANCE: 72.58mm RAPID DISTANCE: 141.99mm ESTIMATED CYCLE TIME: 4s (0.3%) COOLANT: Flood	<b>T10001</b> D10001 L10001 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: <a href="#">1K335-2000-300-XD 1730</a>
Operation 22/26 DESCRIPTION: Holmaking 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 (1.2%) COOLANT: Flood	<b>T10120</b> D10120 L10120 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 120mm FLUTES: 2 DESCRIPTION: Punta a forare M12 H8 VENDOR: Sandvik PRODUCT: <a href="#">860.1-1200-098A1-PM P1BM</a>
Operation 23/26 DESCRIPTION: Holmaking1 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 4633rpm MAXIMUM FEEDRATE: 532.782mm/min CUTTING DISTANCE: 194.01mm RAPID DISTANCE: 393.02mm ESTIMATED CYCLE TIME: 27s (2%) COOLANT: Flood	<b>T10006</b> D10006 L10006 TYPE: drill DIAMETER: 5mm TIP ANGLE: 118° LENGTH: 70mm FLUTES: 2 DESCRIPTION: Punta a forare M5 H8 VENDOR: Mitsubishi PRODUCT: VSDD0500
Operation 24/26 DESCRIPTION: Holmaking2 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 7658rpm MAXIMUM FEEDRATE: 528.409mm/min CUTTING DISTANCE: 13.9mm RAPID DISTANCE: 43.9mm ESTIMATED CYCLE TIME: 2s (0.2%) COOLANT: Flood	<b>T10114</b> D10114 L10114 TYPE: drill DIAMETER: 3mm TIP ANGLE: 118° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Punta a forare M3 H8 VENDOR: Mitsubishi PRODUCT: VSDD0300

Operation 25/26 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	<b>T10112 D10112 L10112</b> TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: <a href="#">R216.24-10050CCK22P 1620</a>
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 (1.1%) COOLANT: Flood	<b>T10013 D10013 L10013</b> TYPE: chamfer mill DIAMETER: 12mm TAPER ANGLE: 45° LENGTH: 50mm FLUTES: 6 DESCRIPTION: Fresa per smussature VENDOR: Sandvik PRODUCT: <a href="#">1C050-0300-045-XB 1620</a>