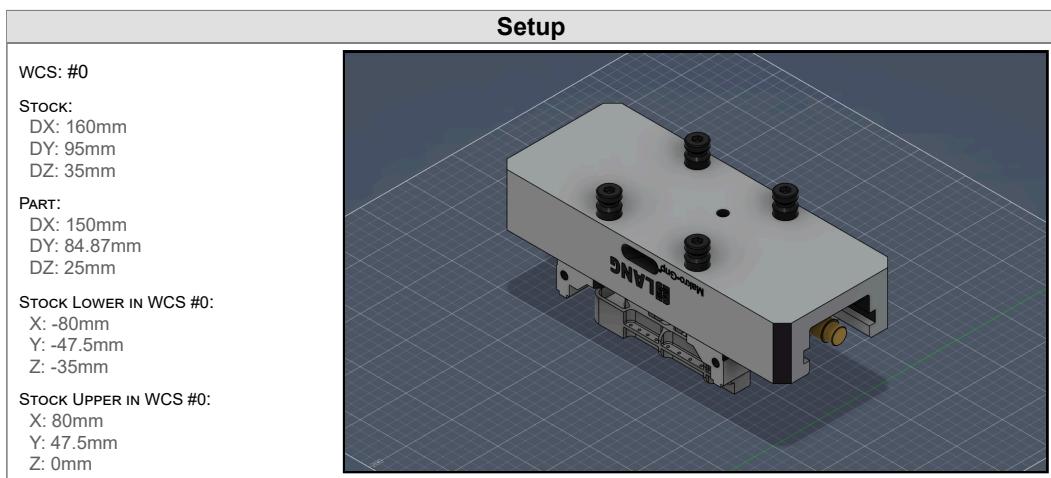


# Setup Sheet for Program 1001

Job DESCRIPTION: AutoSetup 1  
 DOCUMENT PATH: Toolpath-FINITO Fori

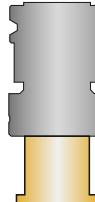
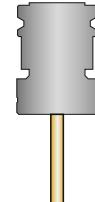
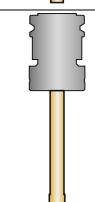
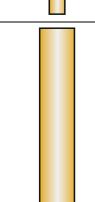
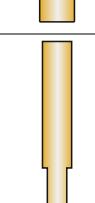
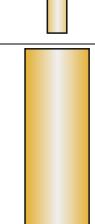
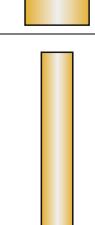
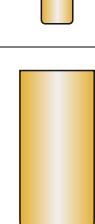


**Total**

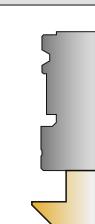
NUMBER OF OPERATIONS: 15 NUMBER OF TOOLS: 12 TOOLS: T13000 T17000 T17006 T17013 T19000 T19006 T19007 T22003 T22011 T22012 T22013 T22014 MAXIMUM Z: 6.05mm MINIMUM Z: -30.25mm MAXIMUM FEEDRATE: 2470mm/min MAXIMUM SPINDLE SPEED: 8000rpm CUTTING DISTANCE: 28100.69mm RAPID DISTANCE: 20265.28mm ESTIMATED CYCLE TIME: 43m:42s
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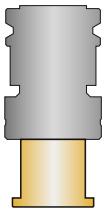
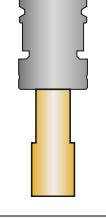
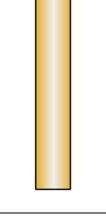
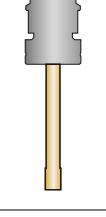
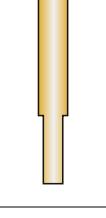
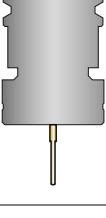
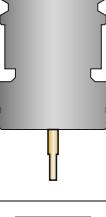
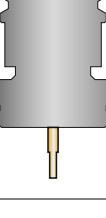
**Tools**

<b>T13000</b> D13000 L13000 TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 0.8mm TAPER ANGLE: 45° LENGTH: 40mm FLUTES: 4 DESCRIPTION: Sgrossatura VENDOR: Sandvik PRODUCT: <a href="#">345-040Q22-13L</a>	MINIMUM Z: -4.5mm MAXIMUM FEED: 2390.004mm/min MAXIMUM SPINDLE SPEED: 1500rpm CUTTING DISTANCE: 3585.66mm RAPID DISTANCE: 291.14mm ESTIMATED CYCLE TIME: 1m:35s (3.6%)	HOLDER: BT40 - B4C4-1000	
<b>T17000</b> D17000 L17000 TYPE: flat end mill DIAMETER: 40mm LENGTH: 100mm FLUTES: 4 DESCRIPTION: CoroMill490 Sgrossatura VENDOR: Sandvik PRODUCT: <a href="#">490-040A32-14H</a>	MINIMUM Z: -30.25mm MAXIMUM FEED: 2470mm/min MAXIMUM SPINDLE SPEED: 1880rpm CUTTING DISTANCE: 7196.44mm RAPID DISTANCE: 6651.85mm ESTIMATED CYCLE TIME: 4m:15s (9.7%)	HOLDER: BT40 - B4C4-1000	
<b>T17006</b> D17006 L17006 TYPE: drill DIAMETER: 2.5mm TIP ANGLE: 140° LENGTH: 38mm FLUTES: 2 DESCRIPTION: CoroDrill 862 Foripiccoli VENDOR: Sandvik PRODUCT: <a href="#">862.1-2500-225A0-GM X2BL</a>	MINIMUM Z: -19.58mm MAXIMUM FEED: 113mm/min MAXIMUM SPINDLE SPEED: 4010rpm CUTTING DISTANCE: 602.7mm RAPID DISTANCE: 1157.43mm ESTIMATED CYCLE TIME: 5m:34s (12.7%)	HOLDER: BT40 - B4C4-1000	
<b>T17013</b> D17013 L17013 TYPE: flat end mill DIAMETER: 4mm LENGTH: 30mm FLUTES: 3 DESCRIPTION: CoroMill Plura Finitura TascheLaterali VENDOR: Sandvik PRODUCT: <a href="#">R216.23-04050CAK11P 1620</a>	MINIMUM Z: -16mm MAXIMUM FEED: 2330mm/min MAXIMUM SPINDLE SPEED: 8000rpm CUTTING DISTANCE: 2433.55mm RAPID DISTANCE: 998.24mm ESTIMATED CYCLE TIME: 1m:45s (4%)	HOLDER: BT40 - B4C4-1000	

<b>T19000</b> D19000 L19000	<b>MINIMUM Z:</b> -5mm <b>MAXIMUM FEED:</b> 1600.002mm/min <b>MAXIMUM SPINDLE SPEED:</b> 1600rpm <b>CUTTING DISTANCE:</b> 763.09mm <b>RAPID DISTANCE:</b> 5.18mm <b>ESTIMATED CYCLE TIME:</b> 29s (1.1%)	HOLDER: BT40 - B4C4-1000	
<b>T19006</b> D19006 L19006	<b>MINIMUM Z:</b> -30.25mm <b>MAXIMUM FEED:</b> 451mm/min <b>MAXIMUM SPINDLE SPEED:</b> 2230rpm <b>CUTTING DISTANCE:</b> 1499.2mm <b>RAPID DISTANCE:</b> 2279.51mm <b>ESTIMATED CYCLE TIME:</b> 3m:50s (8.8%)	HOLDER: BT40 - B4C4-1000	
<b>T19007</b> D19007 L19007	<b>MINIMUM Z:</b> -30.25mm <b>MAXIMUM FEED:</b> 651mm/min <b>MAXIMUM SPINDLE SPEED:</b> 4070rpm <b>CUTTING DISTANCE:</b> 2266.24mm <b>RAPID DISTANCE:</b> 4150.67mm <b>ESTIMATED CYCLE TIME:</b> 5m:37s (12.9%)	HOLDER: BT40 - B4C4-1000	
<b>T22003</b> D22003 L22003	<b>MINIMUM Z:</b> -16mm <b>MAXIMUM FEED:</b> 2170mm/min <b>MAXIMUM SPINDLE SPEED:</b> 2170rpm <b>CUTTING DISTANCE:</b> 7219.48mm <b>RAPID DISTANCE:</b> 2494.03mm <b>ESTIMATED CYCLE TIME:</b> 12m:54s (29.5%)		
<b>T22011</b> D22011 L22011	<b>MINIMUM Z:</b> -16mm <b>MAXIMUM FEED:</b> 2106.67mm/min <b>MAXIMUM SPINDLE SPEED:</b> 7190rpm <b>CUTTING DISTANCE:</b> 1204.52mm <b>RAPID DISTANCE:</b> 1429.99mm <b>ESTIMATED CYCLE TIME:</b> 2m:1s (4.6%)		
<b>T22012</b> D22012 L22012	<b>MINIMUM Z:</b> -30.1mm <b>MAXIMUM FEED:</b> 250mm/min <b>MAXIMUM SPINDLE SPEED:</b> 1393rpm <b>CUTTING DISTANCE:</b> 491.42mm <b>RAPID DISTANCE:</b> 34.12mm <b>ESTIMATED CYCLE TIME:</b> 1m:58s (4.5%)		
<b>T22013</b> D22013 L22013	<b>MINIMUM Z:</b> -16mm <b>MAXIMUM FEED:</b> 1999.2mm/min <b>MAXIMUM SPINDLE SPEED:</b> 6000rpm <b>CUTTING DISTANCE:</b> 459.45mm <b>RAPID DISTANCE:</b> 710.18mm <b>ESTIMATED CYCLE TIME:</b> 31s (1.2%)		
<b>T22014</b> D22014 L22014	<b>MINIMUM Z:</b> -16.29mm <b>MAXIMUM FEED:</b> 1900.001mm/min <b>MAXIMUM SPINDLE SPEED:</b> 8000rpm <b>CUTTING DISTANCE:</b> 378.96mm <b>RAPID DISTANCE:</b> 62.93mm <b>ESTIMATED CYCLE TIME:</b> 13s (0.5%)		

## Operations

Operation 1/15	<b>T13000</b> D13000 L13000	
DESCRIPTION: 1 Face STRATEGY: Facing WCS: #0 TOLERANCE: 0.03mm MAXIMUM STEPDOWN: 1.02mm MAXIMUM STEPOVER: 41.8mm	<b>MAXIMUM Z:</b> 6.05mm <b>MINIMUM Z:</b> -4.5mm <b>MAXIMUM SPINDLE SPEED:</b> 1500rpm <b>MAXIMUM FEEDRATE:</b> 2390.004mm/min <b>CUTTING DISTANCE:</b> 3585.66mm <b>RAPID DISTANCE:</b> 291.14mm <b>ESTIMATED CYCLE TIME:</b> 1m:35s (3.6%) <b>COOLANT:</b> Flood	<b>TYPE:</b> face mill <b>DIAMETER:</b> 40mm <b>CORNER RADIUS:</b> 0.8mm <b>TAPER ANGLE:</b> 45° <b>LENGTH:</b> 40mm <b>FLUTES:</b> 4 <b>DESCRIPTION:</b> Sgrossatura <b>VENDOR:</b> Sandvik <b>PRODUCT:</b> <a href="#">345-040Q22-13L</a>

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

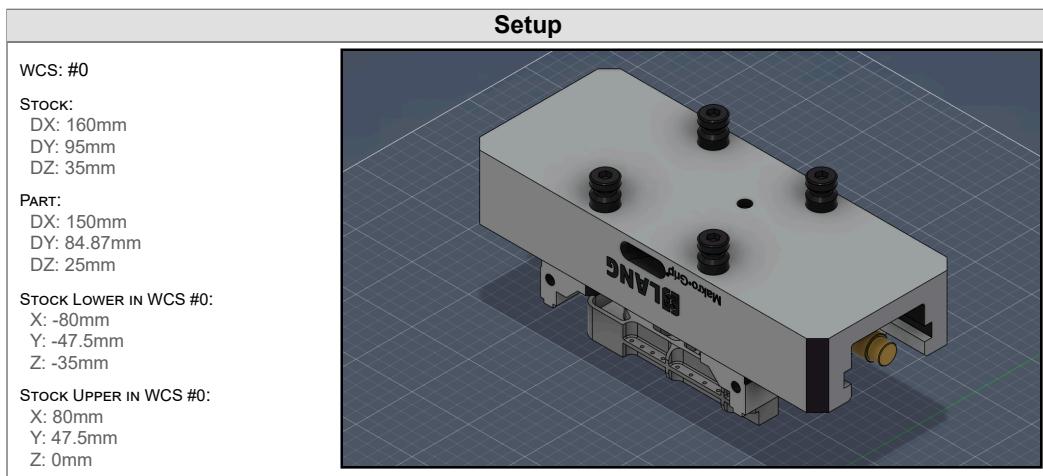
Operation 10/15  DESCRIPTION: 10 Flat WCS: #0 TOLERANCE: 0.03mm STOCK TO LEAVE: 0.13mm/0mm MAXIMUM STEPOVER: 4.2mm	MAXIMUM Z: 0.51mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 6000rpm MAXIMUM FEEDRATE: 1999.2mm/min CUTTING DISTANCE: 303.39mm RAPID DISTANCE: 525.4mm ESTIMATED CYCLE TIME: 17s (0.6%) COOLANT: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

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# Setup Sheet for Program 1002

JOB DESCRIPTION: AutoSetup 2

DOCUMENT PATH: Toolpath-FINITO Fori



**Total**

NUMBER OF OPERATIONS: 9 NUMBER OF TOOLS: 7 <b>TOOLS:</b> T13000 T17013 T19000 T22003 T22011 T22013 T22014 MAXIMUM Z: 6.05mm MINIMUM Z: -16.29mm MAXIMUM FEEDRATE: 2390.004mm/min MAXIMUM SPINDLE SPEED: 8000rpm CUTTING DISTANCE: 14860.52mm RAPID DISTANCE: 6298.6mm ESTIMATED CYCLE TIME: 19m:17s
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**Tools**

<b>T13000</b> D13000 L13000 TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 0.8mm TAPER ANGLE: 45° LENGTH: 40mm FLUTES: 4 DESCRIPTION: Sgrossatura VENDOR: Sandvik PRODUCT: <a href="#">345-040Q22-13L</a>	MINIMUM Z: -4.5mm MAXIMUM FEED: 2390.004mm/min MAXIMUM SPINDLE SPEED: 1500rpm CUTTING DISTANCE: 3585.66mm RAPID DISTANCE: 291.14mm ESTIMATED CYCLE TIME: 1m:35s (8.2%)	<b>HOLDER:</b> BT40 - B4C4-1000	
<b>T17013</b> D17013 L17013 TYPE: flat end mill DIAMETER: 4mm LENGTH: 30mm FLUTES: 3 DESCRIPTION: CoroMill Plura Finitura Tasche Laterali VENDOR: Sandvik PRODUCT: <a href="#">R216.23-04050CAK11P 1620</a>	MINIMUM Z: -16mm MAXIMUM FEED: 2330mm/min MAXIMUM SPINDLE SPEED: 8000rpm CUTTING DISTANCE: 2435.69mm RAPID DISTANCE: 1007.4mm ESTIMATED CYCLE TIME: 1m:45s (9.1%)	<b>HOLDER:</b> BT40 - B4C4-1000	
<b>T19000</b> D19000 L19000 TYPE: face mill DIAMETER: 54.08mm CORNER RADIUS: 0.8mm LENGTH: 45mm FLUTES: 4 DESCRIPTION: Fresa CoroMill 345 per spianatura VENDOR: sandvik PRODUCT: <a href="#">345-040Q22-13M</a>	MINIMUM Z: -5mm MAXIMUM FEED: 1600.002mm/min MAXIMUM SPINDLE SPEED: 1600rpm CUTTING DISTANCE: 761.78mm RAPID DISTANCE: 5.18mm ESTIMATED CYCLE TIME: 29s (2.5%)	<b>HOLDER:</b> BT40 - B4C4-1000	
<b>T22003</b> D22003 L22003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.2mm LENGTH: 45mm FLUTES: 5 DESCRIPTION: Sgrossatura tasche 1 VENDOR: PRODUCT: <a href="#">1K325-0800-XB 1730</a>	MINIMUM Z: -15.75mm MAXIMUM FEED: 2170mm/min MAXIMUM SPINDLE SPEED: 2170rpm CUTTING DISTANCE: 6050.69mm RAPID DISTANCE: 2935.78mm ESTIMATED CYCLE TIME: 11m:0s (57.1%)		

**T22011 D22011 L22011**

**TYPE:** flat end mill  
**DIAMETER:** 4mm  
**LENGTH:** 40mm  
**FLUTES:** 5  
**DESCRIPTION:** Fresa per sgrossatura (tasca piccola) e per finitura totale tasche  
**PRODUCT:** [1K334-0400-050-XC 1730](#)

**MINIMUM Z:** -15.75mm  
**MAXIMUM FEED:** 2106.67mm/min  
**MAXIMUM SPINDLE SPEED:** 7190rpm  
**CUTTING DISTANCE:** 1216.13mm  
**RAPID DISTANCE:** 1368.07mm  
**ESTIMATED CYCLE TIME:** 2m:1s (10.4%)

**T22013 D22013 L22013**

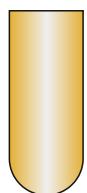
**TYPE:** bullnose end mill  
**DIAMETER:** 8mm  
**CORNER RADIUS:** 1mm  
**LENGTH:** 50mm  
**FLUTES:** 4  
**DESCRIPTION:** 54\_finitura\_fondo\_tondo  
**VENDOR:** mitsubishi  
**PRODUCT:** [MPMHVRBD0800R100](#)

**MINIMUM Z:** -16mm  
**MAXIMUM FEED:** 1999.2mm/min  
**MAXIMUM SPINDLE SPEED:** 6000rpm  
**CUTTING DISTANCE:** 434.29mm  
**RAPID DISTANCE:** 628.51mm  
**ESTIMATED CYCLE TIME:** 29s (2.5%)

**T22014 D22014 L22014**

**TYPE:** ball end mill  
**DIAMETER:** 8mm  
**CORNER RADIUS:** 4mm  
**LENGTH:** 20mm  
**FLUTES:** 4  
**DESCRIPTION:** nervatura tonda  
**VENDOR:** mitsubishi  
**PRODUCT:** [fresa a punta tonda VQ4SVBR04000](#)

**MINIMUM Z:** -16.29mm  
**MAXIMUM FEED:** 1900.001mm/min  
**MAXIMUM SPINDLE SPEED:** 8000rpm  
**CUTTING DISTANCE:** 376.28mm  
**RAPID DISTANCE:** 62.53mm  
**ESTIMATED CYCLE TIME:** 13s (1.1%)

**Operations**

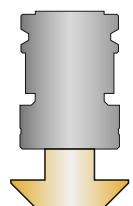
## Operation 1/9

**DESCRIPTION:** 1 Face (2)  
**STRATEGY:** Facing  
**WCS:** #0  
**TOLERANCE:** 0.03mm  
**MAXIMUM STEPDOWN:** 1.02mm  
**MAXIMUM STEPOVER:** 41.8mm

**MAXIMUM Z:** 6.05mm  
**MINIMUM Z:** -4.5mm  
**MAXIMUM SPINDLE SPEED:** 1500rpm  
**MAXIMUM FEEDRATE:** 2390.004mm/min  
**CUTTING DISTANCE:** 3585.66mm  
**RAPID DISTANCE:** 291.14mm  
**ESTIMATED CYCLE TIME:** 1m:35s (8.2%)  
**COOLANT:** Flood

**T13000 D13000 L13000**

**TYPE:** face mill  
**DIAMETER:** 40mm  
**CORNER RADIUS:** 0.8mm  
**TAPER ANGLE:** 45°  
**LENGTH:** 40mm  
**FLUTES:** 4  
**DESCRIPTION:** Sgrossatura  
**VENDOR:** Sandvik  
**PRODUCT:** [345-040Q22-13L](#)



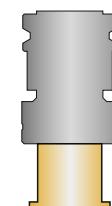
## Operation 2/9

**DESCRIPTION:** 2 Face (2)  
**STRATEGY:** Facing  
**WCS:** #0  
**TOLERANCE:** 0.03mm  
**MAXIMUM STEPOVER:** 36.74mm

**MAXIMUM Z:** 3.05mm  
**MINIMUM Z:** -5mm  
**MAXIMUM SPINDLE SPEED:** 1600rpm  
**MAXIMUM FEEDRATE:** 1600.002mm/min  
**CUTTING DISTANCE:** 761.78mm  
**RAPID DISTANCE:** 5.18mm  
**ESTIMATED CYCLE TIME:** 29s (2.5%)  
**COOLANT:** Flood

**T19000 D19000 L19000**

**TYPE:** face mill  
**DIAMETER:** 54.08mm  
**CORNER RADIUS:** 0.8mm  
**LENGTH:** 45mm  
**FLUTES:** 4  
**DESCRIPTION:** Fresa CoroMill 345 per spianatura  
**VENDOR:** sandvik  
**PRODUCT:** [345-040Q22-13M](#)



## Operation 3/9

**DESCRIPTION:** 3 Adaptive Clearing (2)  
**STRATEGY:** Adaptive  
**WCS:** #0  
**TOLERANCE:** 0.05mm  
**STOCK TO LEAVE:** 0.25mm  
**MAXIMUM STEPDOWN:** 10.8mm  
**OPTIMAL LOAD:** 2.4mm  
**LOAD DEVIATION:** 0.24mm

**MAXIMUM Z:** 0.51mm  
**MINIMUM Z:** -15.75mm  
**MAXIMUM SPINDLE SPEED:** 2170rpm  
**MAXIMUM FEEDRATE:** 2170mm/min  
**CUTTING DISTANCE:** 6050.69mm  
**RAPID DISTANCE:** 2935.78mm  
**ESTIMATED CYCLE TIME:** 11m:0s (57.1%)  
**COOLANT:** Flood

**T22003 D22003 L22003**

**TYPE:** bullnose end mill  
**DIAMETER:** 8mm  
**CORNER RADIUS:** 0.2mm  
**LENGTH:** 45mm  
**FLUTES:** 5  
**DESCRIPTION:** Sgrossatura tasche 1  
**PRODUCT:** [1K325-0800-XB 1730](#)



## Operation 4/9

**DESCRIPTION:** 4 Adaptive Clearing (2)  
**STRATEGY:** Adaptive  
**WCS:** #0  
**TOLERANCE:** 0.05mm  
**STOCK TO LEAVE:** 0.25mm  
**MAXIMUM STEPDOWN:** 8.25mm  
**OPTIMAL LOAD:** 1.6mm  
**LOAD DEVIATION:** 0.16mm

**MAXIMUM Z:** 0.51mm  
**MINIMUM Z:** -15.75mm  
**MAXIMUM SPINDLE SPEED:** 7190rpm  
**MAXIMUM FEEDRATE:** 2106.67mm/min  
**CUTTING DISTANCE:** 1216.13mm  
**RAPID DISTANCE:** 1368.07mm  
**ESTIMATED CYCLE TIME:** 2m:1s (10.4%)  
**COOLANT:** Flood

**T22011 D22011 L22011**

**TYPE:** flat end mill  
**DIAMETER:** 4mm  
**LENGTH:** 40mm  
**FLUTES:** 5  
**DESCRIPTION:** Fresa per sgrossatura (tasca piccola) e per finitura totale tasche  
**PRODUCT:** [1K334-0400-050-XC 1730](#)



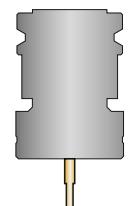
## Operation 5/9

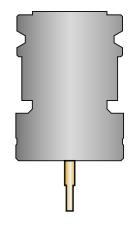
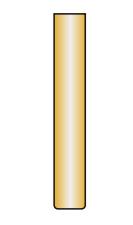
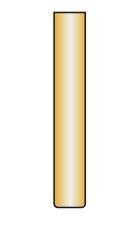
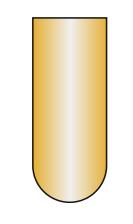
**DESCRIPTION:** 5 Flat  
**WCS:** #0  
**TOLERANCE:** 0.03mm  
**STOCK TO LEAVE:** 0.13mm/0mm  
**MAXIMUM STEPOVER:** 2.8mm

**MAXIMUM Z:** 0.51mm  
**MINIMUM Z:** -16mm  
**MAXIMUM SPINDLE SPEED:** 8000rpm  
**MAXIMUM FEEDRATE:** 2330mm/min  
**CUTTING DISTANCE:** 1197.93mm  
**RAPID DISTANCE:** 476.91mm  
**ESTIMATED CYCLE TIME:** 38s (3.3%)  
**COOLANT:** Flood

**T17013 D17013 L17013**

**TYPE:** flat end mill  
**DIAMETER:** 4mm  
**LENGTH:** 30mm  
**FLUTES:** 3  
**DESCRIPTION:** CoroMill Plura FinituraTascheLaterali  
**VENDOR:** Sandvik  
**PRODUCT:** [R216.23-04050CAK11P 1620](#)



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

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