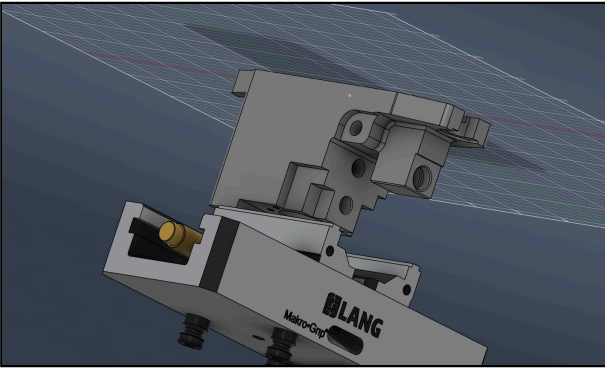


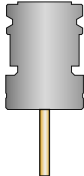
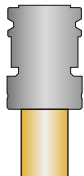
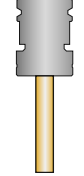
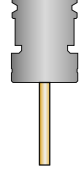
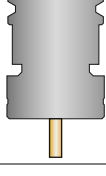
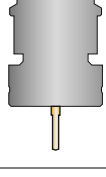
Setup Sheet for Program 1001

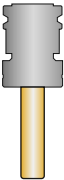
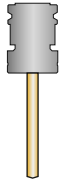
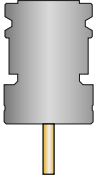
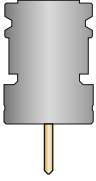
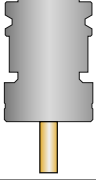
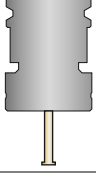
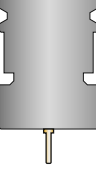
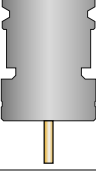
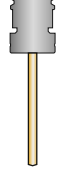
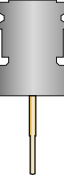
JOB DESCRIPTION: AutoSetup 1

DOCUMENT PATH: 0NC04_DFM_01021107 v1

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

Total
NUMBER OF OPERATIONS: 62
NUMBER OF TOOLS: 17
TOOLS: T10003 T10109 T10110 T10112 T11005 T11011 T11104 T11112 T11115 T11116 T11117 T11119 T11124 T12005 T12007 T13008 T13108
MAXIMUM FEEDRATE: 7637.242mm/min
MAXIMUM SPINDLE SPEED: 8100rpm
CUTTING DISTANCE: 60777.93mm
RAPID DISTANCE: 64847.48mm
ESTIMATED CYCLE TIME: 52m:15s

Tools			
T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730	MAXIMUM FEED: 1780mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 4324.42mm RAPID DISTANCE: 4215.78mm ESTIMATED CYCLE TIME: 5m:43s (10.9%)	HOLDER: BT40 - B4C4-1000	
T10109 D10109 L10109 TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 1.2mm LENGTH: 60mm FLUTES: 3 DESCRIPTION: Fresa per lavorazione grossa tasca centrale VENDOR: Sandvik PRODUCT: R390-040C4-18M060	MAXIMUM FEED: 2864.789mm/min MAXIMUM SPINDLE SPEED: 4775rpm CUTTING DISTANCE: 1926.11mm RAPID DISTANCE: 51.75mm ESTIMATED CYCLE TIME: 48s (1.5%)	HOLDER: BT40 - B4C4-1000	
T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730	MAXIMUM FEED: 4458.366mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 5793.73mm RAPID DISTANCE: 4729.38mm ESTIMATED CYCLE TIME: 7m:30s (14.4%)	HOLDER: BT40 - B4C4-1000	
T10112 D10112 L10112 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216.24-10050CCK22P 1620	MAXIMUM FEED: 3057.303mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 6161.56mm RAPID DISTANCE: 6469.1mm ESTIMATED CYCLE TIME: 5m:42s (10.9%)	HOLDER: BT40 - B4C4-1000	
T11005 D11005 L11005 TYPE: flat end mill DIAMETER: 8mm LENGTH: 25.4mm FLUTES: 5 DESCRIPTION: tasche superiori 1 VENDOR: Sandvik PRODUCT: 2N342-0800-PD	MAXIMUM FEED: 3445.869mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 1414.05mm RAPID DISTANCE: 3164.61mm ESTIMATED CYCLE TIME: 1m:3s (2%)	HOLDER: BT40 - B4C4-1000	
T11011 D11011 L11011 TYPE: drill DIAMETER: 4.2mm TIP ANGLE: 147° LENGTH: 30mm FLUTES: 2 DESCRIPTION: Prefori 4.2mm VENDOR: Sandvik PRODUCT: 860.1-0420-018A0-PM	MAXIMUM FEED: 582.761mm/min MAXIMUM SPINDLE SPEED: 6033rpm CUTTING DISTANCE: 41.24mm RAPID DISTANCE: 251.24mm ESTIMATED CYCLE TIME: 7s (0.2%)	HOLDER: BT40 - B4C4-1000	

T11104 D11104 L11104 TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P	MAXIMUM FEED: 7637.242mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 2525.82mm RAPID DISTANCE: 2347.56mm ESTIMATED CYCLE TIME: 1m:11s (2.3%)	HOLDER: BT40 - B4C4-1000	
T11112 D11112 L11112 TYPE: drill DIAMETER: 14mm TIP ANGLE: 147° LENGTH: 134mm FLUTES: 2 DESCRIPTION: Foro da 14mm VENDOR: Sandvik PRODUCT: 860.1-1400-115A1-PM	MAXIMUM FEED: 536.129mm/min MAXIMUM SPINDLE SPEED: 1665rpm CUTTING DISTANCE: 128.11mm RAPID DISTANCE: 158.11mm ESTIMATED CYCLE TIME: 16s (0.5%)	HOLDER: BT40 - B4C4-1000	
T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD	MAXIMUM FEED: 2992.99mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 2005.74mm RAPID DISTANCE: 2228.66mm ESTIMATED CYCLE TIME: 1m:38s (3.1%)	HOLDER: BT40 - B4C4-1000	
T11116 D11116 L11116 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45 interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA	MAXIMUM FEED: 1960.79mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 465.98mm RAPID DISTANCE: 249.26mm ESTIMATED CYCLE TIME: 40s (1.3%)	HOLDER: BT40 - B4C4-1000	
T11117 D11117 L11117 TYPE: flat end mill DIAMETER: 12.7mm LENGTH: 37.1mm FLUTES: 5 DESCRIPTION: Spallamento fori VENDOR: Sandvik PRODUCT: 2N342-1270-PD	MAXIMUM FEED: 5470.317mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 24670.07mm RAPID DISTANCE: 32752.66mm ESTIMATED CYCLE TIME: 11m:8s (21.3%)	HOLDER: BT40 - B4C4-1000	
T11119 D11119 L11119 TYPE: slot mill DIAMETER: 10mm LENGTH: 40mm FLUTES: 7 DESCRIPTION: Prova 2 S2 contour VENDOR: Sandvik PRODUCT: 1K377-0600-050-XD 1730	MAXIMUM FEED: 2430mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 90.65mm RAPID DISTANCE: 113mm ESTIMATED CYCLE TIME: 4s (0.1%)	HOLDER: BT40 - B4C4-1000	
T11124 D11124 L11124 TYPE: bullnose end mill DIAMETER: 3.17mm CORNER RADIUS: 0.79mm LENGTH: 22mm FLUTES: 4 DESCRIPTION: tasche superiori 34 VENDOR: Sandvik PRODUCT: RA216.24-0830BAK02G	MAXIMUM FEED: 1669.917mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 10043mm RAPID DISTANCE: 6100.63mm ESTIMATED CYCLE TIME: 7m:34s (14.5%)	HOLDER: BT40 - B4C4-1000	
T12005 D12005 L12005 TYPE: flat end mill DIAMETER: 6mm LENGTH: 28.8mm FLUTES: 7 DESCRIPTION: CoroMill dura VENDOR: Sandvik PRODUCT: 1K377-0600-050-XD 1730	MAXIMUM FEED: 3368.131mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 832.13mm RAPID DISTANCE: 1540.4mm ESTIMATED CYCLE TIME: 2m:8s (4.1%)	HOLDER: BT40 - B4C4-1000	
T12007 D12007 L12007 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 161mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM	MAXIMUM FEED: 535.906mm/min MAXIMUM SPINDLE SPEED: 1942rpm CUTTING DISTANCE: 205.17mm RAPID DISTANCE: 265.17mm ESTIMATED CYCLE TIME: 26s (0.8%)	HOLDER: BT40 - B4C4-1000	
T13008 D13008 L13008 TYPE: drill DIAMETER: 4.5mm TIP ANGLE: 147° LENGTH: 73.2mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM solid carbide drill COMMENT: Vita utile 9140 fori VENDOR: Sandvik Coromant PRODUCT: 860.1-0450-027A1-PM P1BM	MAXIMUM FEED: 563.915mm/min MAXIMUM SPINDLE SPEED: 5448rpm CUTTING DISTANCE: 52.59mm RAPID DISTANCE: 82.59mm ESTIMATED CYCLE TIME: 7s (0.2%)	HOLDER: BT40 - B4C4-1000	

T13108 D13108 L13108

TYPE: drill

DIAMETER: 20mm

TIP ANGLE: 147°

LENGTH: 149.9mm

FLUTES: 2

DESCRIPTION: Punta in metallo duro integrale CoroDrill 860-PM

COMMENT: 1320 fori da 3.528 minuti

VENDOR: Sandvik Coromant

PRODUCT: [860-1-2000-077A1-PM.P1BM](#)

MAXIMUM FEED: 576.357mm/min

MAXIMUM SPINDLE SPEED: 1253rpm

CUTTING DISTANCE: 97.56mm

RAPID DISTANCE: 127.56mm

ESTIMATED CYCLE TIME: 12s (0.4%)

HOLDER: BT40 - B4C4-1000

**Operations**

Operation 1/62

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 (0.8%)

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 2/62

DESCRIPTION: Finishing

STRATEGY: Facing

WCS: #0

TOLERANCE: 0.01mm

MAXIMUM STEPOVER: 36mm

MAXIMUM SPINDLE SPEED: 4775rpm

MAXIMUM FEEDRATE: 2864.789mm/min

CUTTING DISTANCE: 963.12mm

RAPID DISTANCE: 26mm

ESTIMATED CYCLE TIME: 21s (0.7%)

COOLANT: Flood

T10109 D10109 L10109

TYPE: face mill

DIAMETER: 40mm

CORNER RADIUS: 1.2mm

LENGTH: 60mm

FLUTES: 3

DESCRIPTION: Fresa per lavorazione grossa tasca centrale

VENDOR: Sandvik

PRODUCT: [R390-040C4-18M060](#)

Operation 3/62

DESCRIPTION: Roughing

STRATEGY: Adaptive

WCS: #0

TOLERANCE: 0.1mm

STOCK TO LEAVE: 0.25mm

MAXIMUM STEPDOWN: 10.9mm

OPTIMAL LOAD: 12.07mm

LOAD DEVIATION: 0.32mm

MAXIMUM SPINDLE SPEED: 8100rpm

MAXIMUM FEEDRATE: 5470.317mm/min

CUTTING DISTANCE: 6746.96mm

RAPID DISTANCE: 8438.57mm

ESTIMATED CYCLE TIME: 2m:57s (5.6%)

COOLANT: Flood

T11117 D11117 L11117

TYPE: flat end mill

DIAMETER: 12.7mm

LENGTH: 37.1mm

FLUTES: 5

DESCRIPTION: Spallamento fori

VENDOR: Sandvik

PRODUCT: 2N342-1270-PD

NOTES:

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

Operation 4/62

DESCRIPTION: Roughing1

STRATEGY: Adaptive

WCS: #0

TOLERANCE: 0.1mm

STOCK TO LEAVE: 0.25mm

MAXIMUM STEPDOWN: 10.9mm

OPTIMAL LOAD: 12.07mm

LOAD DEVIATION: 0.32mm

MAXIMUM SPINDLE SPEED: 8100rpm

MAXIMUM FEEDRATE: 5470.317mm/min

CUTTING DISTANCE: 7424.93mm

RAPID DISTANCE: 7671.31mm

ESTIMATED CYCLE TIME: 2m:55s (5.6%)

COOLANT: Flood

T11117 D11117 L11117

TYPE: flat end mill

DIAMETER: 12.7mm

LENGTH: 37.1mm

FLUTES: 5

DESCRIPTION: Spallamento fori

VENDOR: Sandvik

PRODUCT: 2N342-1270-PD

NOTES:

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

Operation 5/62

DESCRIPTION: Roughing2

STRATEGY: Adaptive

WCS: #0

TOLERANCE: 0.1mm

STOCK TO LEAVE: 0.25mm

MAXIMUM STEPDOWN: 10.9mm

OPTIMAL LOAD: 12.07mm

LOAD DEVIATION: 0.32mm

MAXIMUM SPINDLE SPEED: 8100rpm

MAXIMUM FEEDRATE: 5470.317mm/min

CUTTING DISTANCE: 3683.53mm

RAPID DISTANCE: 3895.25mm

ESTIMATED CYCLE TIME: 1m:28s (2.8%)

COOLANT: Flood

T11117 D11117 L11117

TYPE: flat end mill

DIAMETER: 12.7mm

LENGTH: 37.1mm

FLUTES: 5

DESCRIPTION: Spallamento fori

VENDOR: Sandvik

PRODUCT: 2N342-1270-PD

Operation 6/62

DESCRIPTION: Roughing3

STRATEGY: Adaptive

WCS: #0

TOLERANCE: 0.1mm

STOCK TO LEAVE: 0.25mm

MAXIMUM STEPDOWN: 10.9mm

OPTIMAL LOAD: 12.07mm

LOAD DEVIATION: 0.32mm

MAXIMUM SPINDLE SPEED: 8100rpm

MAXIMUM FEEDRATE: 5470.317mm/min

CUTTING DISTANCE: 3827.41mm

RAPID DISTANCE: 7319.05mm

ESTIMATED CYCLE TIME: 2m:11s (4.2%)

COOLANT: Flood

T11117 D11117 L11117

TYPE: flat end mill

DIAMETER: 12.7mm

LENGTH: 37.1mm

FLUTES: 5

DESCRIPTION: Spallamento fori

VENDOR: Sandvik

PRODUCT: 2N342-1270-PD

Operation 7/62

DESCRIPTION: Roughing4

STRATEGY: Adaptive

WCS: #0

TOLERANCE: 0.1mm

STOCK TO LEAVE: 0.25mm

MAXIMUM STEPDOWN: 10.9mm

OPTIMAL LOAD: 12.07mm

LOAD DEVIATION: 0.32mm

MAXIMUM SPINDLE SPEED: 8100rpm

MAXIMUM FEEDRATE: 5470.317mm/min

CUTTING DISTANCE: 2987.24mm

RAPID DISTANCE: 5428.49mm

ESTIMATED CYCLE TIME: 1m:38s (3.1%)

COOLANT: Flood

T11117 D11117 L11117

TYPE: flat end mill

DIAMETER: 12.7mm

LENGTH: 37.1mm

FLUTES: 5

DESCRIPTION: Spallamento fori

VENDOR: Sandvik

PRODUCT: 2N342-1270-PD

NOTES:

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

Operation 8/62 DESCRIPTION: Roughing5 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 3.5mm OPTIMAL LOAD: 15mm LOAD DEVIATION: 1.5mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4458.366mm/min CUTTING DISTANCE: 4292.03mm RAPID DISTANCE: 2698.6mm ESTIMATED CYCLE TIME: 6m:10s (11.8%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 9/62 DESCRIPTION: Roughing6 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 5.38mm OPTIMAL LOAD: 7.6mm LOAD DEVIATION: 0.2mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3445.869mm/min CUTTING DISTANCE: 770.11mm RAPID DISTANCE: 931.46mm ESTIMATED CYCLE TIME: 25s (0.8%) COOLANT: Flood	T11005 D11005 L11005 TYPE: flat end mill DIAMETER: 8mm LENGTH: 25.4mm FLUTES: 5 DESCRIPTION: tasche superiori 1 VENDOR: Sandvik PRODUCT: 2N342-0800-PD
Operation 10/62 DESCRIPTION: Roughing7 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 5.38mm OPTIMAL LOAD: 7.6mm LOAD DEVIATION: 0.2mm NOTES: 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	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3445.869mm/min CUTTING DISTANCE: 327.78mm RAPID DISTANCE: 1077.27mm ESTIMATED CYCLE TIME: 19s (0.6%) COOLANT: Flood	T11005 D11005 L11005 TYPE: flat end mill DIAMETER: 8mm LENGTH: 25.4mm FLUTES: 5 DESCRIPTION: tasche superiori 1 VENDOR: Sandvik PRODUCT: 2N342-0800-PD
Operation 11/62 DESCRIPTION: Roughing8 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 5.38mm OPTIMAL LOAD: 7.6mm LOAD DEVIATION: 0.2mm NOTES: 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	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3445.869mm/min CUTTING DISTANCE: 316.16mm RAPID DISTANCE: 1155.88mm ESTIMATED CYCLE TIME: 19s (0.6%) COOLANT: Flood	T11005 D11005 L11005 TYPE: flat end mill DIAMETER: 8mm LENGTH: 25.4mm FLUTES: 5 DESCRIPTION: tasche superiori 1 VENDOR: Sandvik PRODUCT: 2N342-0800-PD
Operation 12/62 DESCRIPTION: Roughing9 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: 6161.56mm RAPID DISTANCE: 6469.1mm ESTIMATED CYCLE TIME: 5m:42s (10.9%) COOLANT: Flood	T10112 D10112 L10112 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216.24-10050CCK22P 1620
Operation 13/62 DESCRIPTION: Roughing10 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.6mm OPTIMAL LOAD: 4.5mm LOAD DEVIATION: 0.45mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3368.131mm/min CUTTING DISTANCE: 662.21mm RAPID DISTANCE: 1213.76mm ESTIMATED CYCLE TIME: 1m:48s (3.5%) COOLANT: Flood	T12005 D12005 L12005 TYPE: flat end mill DIAMETER: 6mm LENGTH: 28.8mm FLUTES: 7 DESCRIPTION: CoroMill dura VENDOR: Sandvik PRODUCT: 1K377-0600-050-XD 1730
Operation 14/62 DESCRIPTION: Roughing11 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.6mm OPTIMAL LOAD: 4.5mm LOAD DEVIATION: 0.45mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3368.131mm/min CUTTING DISTANCE: 10.69mm RAPID DISTANCE: 82.7mm ESTIMATED CYCLE TIME: 1s (0%) COOLANT: Flood	T12005 D12005 L12005 TYPE: flat end mill DIAMETER: 6mm LENGTH: 28.8mm FLUTES: 7 DESCRIPTION: CoroMill dura VENDOR: Sandvik PRODUCT: 1K377-0600-050-XD 1730
Operation 15/62 DESCRIPTION: Roughing12 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.6mm OPTIMAL LOAD: 4.5mm LOAD DEVIATION: 0.45mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3368.131mm/min CUTTING DISTANCE: 10.57mm RAPID DISTANCE: 82.7mm ESTIMATED CYCLE TIME: 1s (0%) COOLANT: Flood	T12005 D12005 L12005 TYPE: flat end mill DIAMETER: 6mm LENGTH: 28.8mm FLUTES: 7 DESCRIPTION: CoroMill dura VENDOR: Sandvik PRODUCT: 1K377-0600-050-XD 1730
Operation 16/62 DESCRIPTION: Flat WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 13.3mm	MAXIMUM SPINDLE SPEED: 7637rpm MAXIMUM FEEDRATE: 7637.242mm/min CUTTING DISTANCE: 127.1mm RAPID DISTANCE: 218.06mm ESTIMATED CYCLE TIME: 5s (0.2%) COOLANT: Flood	T11104 D11104 L11104 TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P

Operation 17/62 DESCRIPTION: Flat1 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 13.3mm	MAXIMUM SPINDLE SPEED: 7637rpm MAXIMUM FEEDRATE: 7637.242mm/min CUTTING DISTANCE: 1109.1mm RAPID DISTANCE: 1089.91mm ESTIMATED CYCLE TIME: 29s (0.9%) COOLANT: Flood	T11104 D11104 L11104 TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P
NOTES: This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 18/62 DESCRIPTION: Flat2 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 13.3mm	MAXIMUM SPINDLE SPEED: 7637rpm MAXIMUM FEEDRATE: 7637.242mm/min CUTTING DISTANCE: 1105.18mm RAPID DISTANCE: 890.1mm ESTIMATED CYCLE TIME: 25s (0.8%) COOLANT: Flood	T11104 D11104 L11104 TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P
NOTES: This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 19/62 DESCRIPTION: Flat3 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 701.63mm RAPID DISTANCE: 1097.49mm ESTIMATED CYCLE TIME: 30s (1%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 20/62 DESCRIPTION: Flat4 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 95.21mm RAPID DISTANCE: 105.96mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 21/62 DESCRIPTION: Flat5 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 95.32mm RAPID DISTANCE: 109.66mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 22/62 DESCRIPTION: Flat6 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 178.27mm RAPID DISTANCE: 359.53mm ESTIMATED CYCLE TIME: 10s (0.3%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 23/62 DESCRIPTION: Flat7 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 5.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 379.12mm RAPID DISTANCE: 538.59mm ESTIMATED CYCLE TIME: 15s (0.5%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD
Operation 24/62 DESCRIPTION: Flat8 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 5.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 282.33mm RAPID DISTANCE: 319.76mm ESTIMATED CYCLE TIME: 10s (0.3%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD
Operation 25/62 DESCRIPTION: Flat9 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 5.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 163.74mm RAPID DISTANCE: 97.04mm ESTIMATED CYCLE TIME: 5s (0.1%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD
Operation 26/62 DESCRIPTION: Flat10 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 5.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 379.11mm RAPID DISTANCE: 601.07mm ESTIMATED CYCLE TIME: 16s (0.5%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD

Operation 27/62 DESCRIPTION: Wall STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 50.5mm MAXIMUM STEPOVER: 18.05mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1620mm/min CUTTING DISTANCE: 115.62mm RAPID DISTANCE: 58.49mm ESTIMATED CYCLE TIME: 9s (0.3%) COOLANT: Flood	T11104 D11104 L11104 TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P
Operation 28/62 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: 254.18mm RAPID DISTANCE: 197.9mm ESTIMATED CYCLE TIME: 20s (0.6%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 29/62 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: 62.14mm RAPID DISTANCE: 36.25mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 30/62 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	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 31/62 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	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 32/62 DESCRIPTION: Wall5 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 27.5mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 113.63mm RAPID DISTANCE: 36.43mm ESTIMATED CYCLE TIME: 5s (0.2%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD
Operation 33/62 DESCRIPTION: Wall6 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 27.5mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 191mm RAPID DISTANCE: 263.36mm ESTIMATED CYCLE TIME: 12s (0.4%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD
Operation 34/62 DESCRIPTION: Wall7 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 27.5mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 58.76mm RAPID DISTANCE: 48.4mm ESTIMATED CYCLE TIME: 5s (0.2%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD
Operation 35/62 DESCRIPTION: Wall8 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 27.5mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 214.53mm RAPID DISTANCE: 50.4mm ESTIMATED CYCLE TIME: 11s (0.4%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD
Operation 36/62 DESCRIPTION: Wall9 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 27.5mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 82.16mm RAPID DISTANCE: 83.26mm ESTIMATED CYCLE TIME: 10s (0.3%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD
Operation 37/62 DESCRIPTION: Wall10 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 27.5mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 95.4mm RAPID DISTANCE: 88.95mm ESTIMATED CYCLE TIME: 5s (0.2%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD

Operation 38/62 DESCRIPTION: Wall11 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 27.5mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2992.99mm/min CUTTING DISTANCE: 45.94mm RAPID DISTANCE: 101.4mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	T11115 D11115 L11115 TYPE: flat end mill DIAMETER: 8mm LENGTH: 36.3mm FLUTES: 5 DESCRIPTION: tasche superiori rifinitura VENDOR: Sandvik PRODUCT: 1K365-0800-XD
Operation 39/62 DESCRIPTION: Wall12 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 16mm MAXIMUM STEPOVER: 6.65mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 120.01mm RAPID DISTANCE: 107.21mm ESTIMATED CYCLE TIME: 12s (0.4%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 40/62 DESCRIPTION: Wall13 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 16mm MAXIMUM STEPOVER: 6.65mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 120.01mm RAPID DISTANCE: 107.21mm ESTIMATED CYCLE TIME: 12s (0.4%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 41/62 DESCRIPTION: Wall14 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 16mm MAXIMUM STEPOVER: 6.65mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 108.62mm RAPID DISTANCE: 253.9mm ESTIMATED CYCLE TIME: 14s (0.5%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 42/62 DESCRIPTION: Wall15 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 24mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1000mm/min CUTTING DISTANCE: 148.66mm RAPID DISTANCE: 161.24mm ESTIMATED CYCLE TIME: 17s (0.6%) COOLANT: Flood	T12005 D12005 L12005 TYPE: flat end mill DIAMETER: 6mm LENGTH: 28.8mm FLUTES: 7 DESCRIPTION: CoroMill dura VENDOR: Sandvik PRODUCT: 1K377-0600-050-XD 1730
Operation 43/62 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 (0.5%) COOLANT: Flood	T12007 D12007 L12007 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 161mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM
Operation 44/62 DESCRIPTION: Holmaking1 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1942rpm MAXIMUM FEEDRATE: 535.906mm/min CUTTING DISTANCE: 78.05mm RAPID DISTANCE: 108.05mm ESTIMATED CYCLE TIME: 10s (0.3%) COOLANT: Flood	T12007 D12007 L12007 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 161mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM
Operation 45/62 DESCRIPTION: Holmaking2 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1253rpm MAXIMUM FEEDRATE: 576.357mm/min CUTTING DISTANCE: 97.56mm RAPID DISTANCE: 127.56mm ESTIMATED CYCLE TIME: 12s (0.4%) COOLANT: Flood	T13108 D13108 L13108 TYPE: drill DIAMETER: 20mm TIP ANGLE: 147° LENGTH: 149.9mm FLUTES: 2 DESCRIPTION: Punta in metallo duro integrale CoroDrill 860-PM COMMENT: 1320 fori da 3.528 minuti VENDOR: Sandvik Coromant PRODUCT: 860.1-2000-077A1-PM P1BM
Operation 46/62 DESCRIPTION: Holmaking3 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 6033rpm MAXIMUM FEEDRATE: 582.761mm/min CUTTING DISTANCE: 41.24mm RAPID DISTANCE: 251.24mm ESTIMATED CYCLE TIME: 7s (0.2%) COOLANT: Flood	T11011 D11011 L11011 TYPE: drill DIAMETER: 4.2mm TIP ANGLE: 147° LENGTH: 30mm FLUTES: 2 DESCRIPTION: Prefori 4.2mm VENDOR: Sandvik PRODUCT: 860.1-0420-018A0-PM
Operation 47/62 DESCRIPTION: Holmaking4 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 5448rpm MAXIMUM FEEDRATE: 563.915mm/min CUTTING DISTANCE: 52.59mm RAPID DISTANCE: 82.59mm ESTIMATED CYCLE TIME: 7s (0.2%) COOLANT: Flood	T13008 D13008 L13008 TYPE: drill DIAMETER: 4.5mm TIP ANGLE: 147° LENGTH: 73.2mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM solid carbide drill COMMENT: Vita utile 9140 fori VENDOR: Sandvik Coromant PRODUCT: 860.1-0450-027A1-PM P1BM

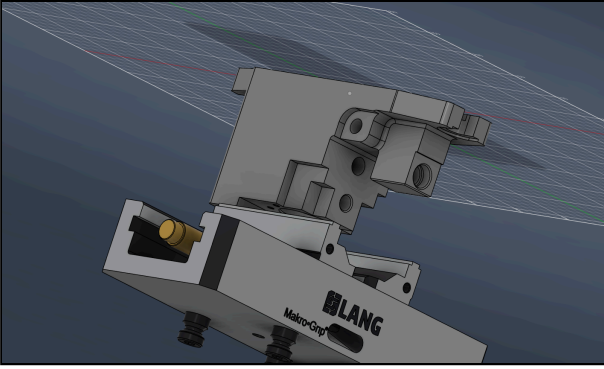
Operation 48/62 DESCRIPTION: Holemaking5 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1665rpm MAXIMUM FEEDRATE: 536.129mm/min CUTTING DISTANCE: 128.11mm RAPID DISTANCE: 158.11mm ESTIMATED CYCLE TIME: 16s (0.5%) COOLANT: Flood	T11112 D11112 L11112 TYPE: drill DIAMETER: 14mm TIP ANGLE: 147° LENGTH: 134mm FLUTES: 2 DESCRIPTION: Foro da 14mm VENDOR: Sandvik PRODUCT: 860.1-1400-115A1-PM
Operation 49/62 DESCRIPTION: Freeform1 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.25mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5965.417mm/min CUTTING DISTANCE: 68.83mm RAPID DISTANCE: 91mm ESTIMATED CYCLE TIME: 2s (0.1%) COOLANT: Flood	T11104 D11104 L11104 TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P
Operation 50/62 DESCRIPTION: Freeform2 STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.2mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 1173.42mm RAPID DISTANCE: 1589.49mm ESTIMATED CYCLE TIME: 1m:49s (3.5%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 51/62 DESCRIPTION: Freeform3 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.1mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 909.73mm RAPID DISTANCE: 173.93mm ESTIMATED CYCLE TIME: 56s (1.8%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 52/62 DESCRIPTION: Freeform4 STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.2mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 964.29mm RAPID DISTANCE: 1825.03mm ESTIMATED CYCLE TIME: 1m:19s (2.5%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 53/62 DESCRIPTION: Freeform5 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: 928.33mm RAPID DISTANCE: 159.02mm ESTIMATED CYCLE TIME: 59s (1.9%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
Operation 54/62 DESCRIPTION: Freeform6 STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.25mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1669.917mm/min CUTTING DISTANCE: 2593.18mm RAPID DISTANCE: 3015.32mm ESTIMATED CYCLE TIME: 2m:19s (4.4%) COOLANT: Flood	T11124 D11124 L11124 TYPE: bullnose end mill DIAMETER: 3.17mm CORNER RADIUS: 0.79mm LENGTH: 22mm FLUTES: 4 DESCRIPTION: tasche superiori 34 VENDOR: Sandvik PRODUCT: RA216.24-0830BAK02G
Operation 55/62 DESCRIPTION: Freeform7 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.13mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1669.917mm/min CUTTING DISTANCE: 2429.33mm RAPID DISTANCE: 37.87mm ESTIMATED CYCLE TIME: 1m:28s (2.8%) COOLANT: Flood	T11124 D11124 L11124 TYPE: bullnose end mill DIAMETER: 3.17mm CORNER RADIUS: 0.79mm LENGTH: 22mm FLUTES: 4 DESCRIPTION: tasche superiori 34 VENDOR: Sandvik PRODUCT: RA216.24-0830BAK02G
Operation 56/62 DESCRIPTION: Freeform8 STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.25mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1669.917mm/min CUTTING DISTANCE: 2591.02mm RAPID DISTANCE: 3009.19mm ESTIMATED CYCLE TIME: 2m:19s (4.4%) COOLANT: Flood	T11124 D11124 L11124 TYPE: bullnose end mill DIAMETER: 3.17mm CORNER RADIUS: 0.79mm LENGTH: 22mm FLUTES: 4 DESCRIPTION: tasche superiori 34 VENDOR: Sandvik PRODUCT: RA216.24-0830BAK02G
Operation 57/62 DESCRIPTION: Freeform9 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.13mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1669.917mm/min CUTTING DISTANCE: 2429.47mm RAPID DISTANCE: 38.24mm ESTIMATED CYCLE TIME: 1m:28s (2.8%) COOLANT: Flood	T11124 D11124 L11124 TYPE: bullnose end mill DIAMETER: 3.17mm CORNER RADIUS: 0.79mm LENGTH: 22mm FLUTES: 4 DESCRIPTION: tasche superiori 34 VENDOR: Sandvik PRODUCT: RA216.24-0830BAK02G

Operation 58/62 DESCRIPTION: Slot wall STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.81mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2430mm/min CUTTING DISTANCE: 90.65mm RAPID DISTANCE: 113mm ESTIMATED CYCLE TIME: 4s (0.1%) COOLANT: Flood	T11119 D11119 L11119 TYPE: slot mill DIAMETER: 10mm LENGTH: 40mm FLUTES: 7 DESCRIPTION: Prova 2 S2 contour
Operation 59/62 DESCRIPTION: Chamfering WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1960.79mm/min CUTTING DISTANCE: 242.73mm RAPID DISTANCE: 69.62mm ESTIMATED CYCLE TIME: 13s (0.4%) COOLANT: Flood	T11116 D11116 L11116 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45 interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA
Operation 60/62 DESCRIPTION: Chamfering1 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1960.79mm/min CUTTING DISTANCE: 41.76mm RAPID DISTANCE: 57.55mm ESTIMATED CYCLE TIME: 7s (0.2%) COOLANT: Flood	T11116 D11116 L11116 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45 interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA
Operation 61/62 DESCRIPTION: Chamfering2 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1960.79mm/min CUTTING DISTANCE: 87.6mm RAPID DISTANCE: 61.04mm ESTIMATED CYCLE TIME: 10s (0.3%) COOLANT: Flood	T11116 D11116 L11116 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45 interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA
Operation 62/62 DESCRIPTION: Chamfering3 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1960.79mm/min CUTTING DISTANCE: 93.89mm RAPID DISTANCE: 61.04mm ESTIMATED CYCLE TIME: 10s (0.3%) COOLANT: Flood	T11116 D11116 L11116 TYPE: chamfer mill DIAMETER: 6mm TAPER ANGLE: 45° LENGTH: 36mm FLUTES: 4 DESCRIPTION: Smusso 45 interno S1 VENDOR: Sandvik PRODUCT: 1C050-0100-045-XA

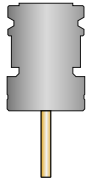
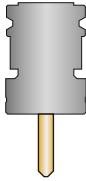
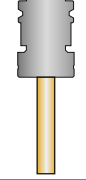
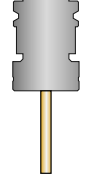
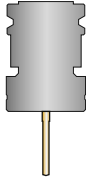
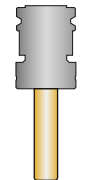
Setup Sheet for Program 1002

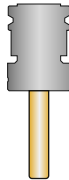
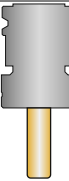
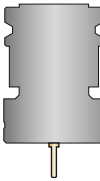
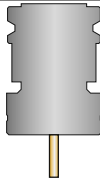

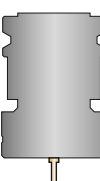

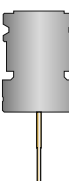
JOB DESCRIPTION: AutoSetup 2

DOCUMENT PATH: 0NC04_DFM_01021107 v1

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

Total
NUMBER OF OPERATIONS: 30
NUMBER OF TOOLS: 14
TOOLS: T10003 T10013 T10110 T10112 T11010 T11104 T11110 T11111 T11124 T12005 T12007 T12112 T12113 T12118
MAXIMUM FEEDRATE: 8614.673mm/min
MAXIMUM SPINDLE SPEED: 8100rpm
CUTTING DISTANCE: 25763.84mm
RAPID DISTANCE: 51594.9mm
ESTIMATED CYCLE TIME: 21m:32s

Tools			
T10003 D10003 L10003			
TYPE: bullnose end mill	MAXIMUM FEED: 1704.805mm/min	HOLDER: BT40 - B4C4-1000	
DIAMETER: 8mm	MAXIMUM SPINDLE SPEED: 8100rpm		
CORNER RADIUS: 0.5mm	CUTTING DISTANCE: 426.29mm		
LENGTH: 55mm	RAPID DISTANCE: 1600.68mm		
FLUTES: 4	ESTIMATED CYCLE TIME: 34s (2.6%)		
DESCRIPTION: Fresa integrale per finitura raggi			
VENDOR: Sandvik			
PRODUCT: 1K377-0800-050-XD 1730			
T10013 D10013 L10013			
TYPE: chamfer mill	MAXIMUM FEED: 2916mm/min	HOLDER: BT40 - B4C4-1000	
DIAMETER: 12mm	MAXIMUM SPINDLE SPEED: 8100rpm		
TAPER ANGLE: 45°	CUTTING DISTANCE: 471.81mm		
LENGTH: 50mm	RAPID DISTANCE: 292.63mm		
FLUTES: 6	ESTIMATED CYCLE TIME: 15s (1.1%)		
DESCRIPTION: Fresa per smussature			
VENDOR: Sandvik			
PRODUCT: 1C050-0300-045-XB 1620			
T10110 D10110 L10110			
TYPE: flat end mill	MAXIMUM FEED: 4458.366mm/min	HOLDER: BT40 - B4C4-1000	
DIAMETER: 20mm	MAXIMUM SPINDLE SPEED: 8100rpm		
LENGTH: 110mm	CUTTING DISTANCE: 3060.91mm		
FLUTES: 5	RAPID DISTANCE: 8662.21mm		
DESCRIPTION: Fresa integrale per particolari lunghi	ESTIMATED CYCLE TIME: 3m:12s (14.8%)		
VENDOR: Sandvik			
PRODUCT: 1K365-2000-XD 1730			
T10112 D10112 L10112			
TYPE: bullnose end mill	MAXIMUM FEED: 1620mm/min	HOLDER: BT40 - B4C4-1000	
DIAMETER: 10mm	MAXIMUM SPINDLE SPEED: 8100rpm		
CORNER RADIUS: 0.1mm	CUTTING DISTANCE: 271.19mm		
LENGTH: 80mm	RAPID DISTANCE: 311.57mm		
FLUTES: 4	ESTIMATED CYCLE TIME: 17s (1.3%)		
DESCRIPTION: Fresa integrale per tasche piccole distanti			
VENDOR: Sandvik			
PRODUCT: R216.24-10050CCK22P 1620			
T11010 D11010 L11010			
TYPE: drill	MAXIMUM FEED: 564.081mm/min	HOLDER: BT40 - B4C4-1000	
DIAMETER: 5mm	MAXIMUM SPINDLE SPEED: 4905rpm		
TIP ANGLE: 147°	CUTTING DISTANCE: 189.44mm		
LENGTH: 52mm	RAPID DISTANCE: 388.45mm		
FLUTES: 2	ESTIMATED CYCLE TIME: 25s (1.9%)		
DESCRIPTION: Fori superiori 5mm			
VENDOR: Sandvik			
PRODUCT: 860.1-0500-037A1-PM			
T11104 D11104 L11104			
TYPE: bullnose end mill	MAXIMUM FEED: 7189.725mm/min	HOLDER: BT40 - B4C4-1000	
DIAMETER: 25mm	MAXIMUM SPINDLE SPEED: 6760rpm		
CORNER RADIUS: 3mm	CUTTING DISTANCE: 14459.26mm		
LENGTH: 98mm	RAPID DISTANCE: 27838.49mm		
FLUTES: 5	ESTIMATED CYCLE TIME: 7m:35s (35.3%)		
DESCRIPTION: Spallamento posteriore			
VENDOR: SANDVIK			
PRODUCT: R216.25-25050GCK54P			

T11110 D11110 L11110 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 90mm FLUTES: 5 DESCRIPTION: Contornatura blocco sup S2 VENDOR: Sandvik PRODUCT: 1K365-2000-300-XD	MAXIMUM FEED: 8100mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 514.89mm RAPID DISTANCE: 1234.06mm ESTIMATED CYCLE TIME: 33s (2.5%)	HOLDER: BT40 - B4C4-1000	
T11111 D11111 L11111 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 60mm FLUTES: 5 VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD	MAXIMUM FEED: 8614.673mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 2917.43mm RAPID DISTANCE: 4263mm ESTIMATED CYCLE TIME: 1m:11s (5.5%)	HOLDER: BT40 - B4C4-1000	
T11124 D11124 L11124 TYPE: bullnose end mill DIAMETER: 3.17mm CORNER RADIUS: 0.79mm LENGTH: 22mm FLUTES: 4 DESCRIPTION: tasche superiori 34 VENDOR: Sandvik PRODUCT: RA216.24-0830BAK02G	MAXIMUM FEED: 1293.388mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 521.19mm RAPID DISTANCE: 662.33mm ESTIMATED CYCLE TIME: 35s (2.7%)	HOLDER: BT40 - B4C4-1000	
T12005 D12005 L12005 TYPE: flat end mill DIAMETER: 6mm LENGTH: 28.8mm FLUTES: 7 DESCRIPTION: CoroMill dura VENDOR: Sandvik PRODUCT: 1K377-0600-050-XD 1730	MAXIMUM FEED: 3368.131mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 1929.58mm RAPID DISTANCE: 4987.69mm ESTIMATED CYCLE TIME: 1m:34s (7.3%)	HOLDER: BT40 - B4C4-1000	
T12007 D12007 L12007 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 161mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM	MAXIMUM FEED: 535.906mm/min MAXIMUM SPINDLE SPEED: 1942rpm CUTTING DISTANCE: 127.12mm RAPID DISTANCE: 157.12mm ESTIMATED CYCLE TIME: 16s (1.2%)	HOLDER: BT40 - B4C4-1000	
T12112 D12112 L12112 TYPE: bullnose end mill DIAMETER: 3mm CORNER RADIUS: 0.2mm LENGTH: 17.4mm FLUTES: 5 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1K365-0300-020-XC 1730	MAXIMUM FEED: 1215mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 212.79mm RAPID DISTANCE: 1087.12mm ESTIMATED CYCLE TIME: 24s (1.8%)	HOLDER: BT40 - B4C4-1000	
T12113 D12113 L12113 TYPE: slot mill DIAMETER: 21.7mm LENGTH: 22.3mm FLUTES: 3 DESCRIPTION: CoroMill 327 VENDOR: Sandvik PRODUCT: 327-16B24SC-12 , 327R12-22 16000-GM 1025	MAXIMUM FEED: 5273.1mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 648.4mm RAPID DISTANCE: 66mm ESTIMATED CYCLE TIME: 9s (0.7%)	HOLDER: BT40 - B4C4-1000	
T12118 D12118 L12118 TYPE: drill DIAMETER: 3mm TIP ANGLE: 140° LENGTH: 64.45mm FLUTES: 2 DESCRIPTION: CoroDrill 862-GM VENDOR: Sandvik PRODUCT: 862.1-3000-270A0-GM X2BL	MAXIMUM FEED: 528.096mm/min MAXIMUM SPINDLE SPEED: 7654rpm CUTTING DISTANCE: 13.55mm RAPID DISTANCE: 43.55mm ESTIMATED CYCLE TIME: 2s (0.2%)	HOLDER: BT40 - B4C4-1000	

Operations

Operation 1/30 DESCRIPTION: Roughing STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 11.68mm OPTIMAL LOAD: 19.59mm LOAD DEVIATION: 1.96mm	MAXIMUM SPINDLE SPEED: 6760rpm MAXIMUM FEEDRATE: 7189.725mm/min CUTTING DISTANCE: 14459.26mm RAPID DISTANCE: 27838.49mm ESTIMATED CYCLE TIME: 7m:35s (35.3%) COOLANT: Flood	T11104 D11104 L11104 TYPE: bullnose end mill DIAMETER: 25mm CORNER RADIUS: 3mm LENGTH: 98mm FLUTES: 5 DESCRIPTION: Spallamento posteriore VENDOR: SANDVIK PRODUCT: R216.25-25050GCK54P
Operation 2/30 DESCRIPTION: Roughing1 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 16.9mm OPTIMAL LOAD: 10.91mm LOAD DEVIATION: 1.09mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 8614.673mm/min CUTTING DISTANCE: 2664.49mm RAPID DISTANCE: 3961.05mm ESTIMATED CYCLE TIME: 1m:6s (5.1%) COOLANT: Flood	T11111 D11111 L11111 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 60mm FLUTES: 5 VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD

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 3/30 DESCRIPTION: Roughing2 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 16.9mm OPTIMAL LOAD: 10.91mm LOAD DEVIATION: 1.09mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 8614.673mm/min CUTTING DISTANCE: 117.16mm RAPID DISTANCE: 147.38mm ESTIMATED CYCLE TIME: 3s (0.2%) COOLANT: Flood	T11111 D11111 L11111 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 60mm FLUTES: 5 VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD
Operation 4/30 DESCRIPTION: Roughing3 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 16.9mm OPTIMAL LOAD: 10.91mm LOAD DEVIATION: 1.09mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 8614.673mm/min CUTTING DISTANCE: 135.78mm RAPID DISTANCE: 154.57mm ESTIMATED CYCLE TIME: 3s (0.2%) COOLANT: Flood	T11111 D11111 L11111 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 60mm FLUTES: 5 VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD
Operation 5/30 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: 337.03mm RAPID DISTANCE: 1805.32mm ESTIMATED CYCLE TIME: 26s (2%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
NOTES:		
This 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 6/30 DESCRIPTION: Roughing5 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.6mm OPTIMAL LOAD: 4.5mm LOAD DEVIATION: 0.45mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3368.131mm/min CUTTING DISTANCE: 598.29mm RAPID DISTANCE: 1303.34mm ESTIMATED CYCLE TIME: 26s (2%) COOLANT: Flood	T12005 D12005 L12005 TYPE: flat end mill DIAMETER: 6mm LENGTH: 28.8mm FLUTES: 7 DESCRIPTION: CoroMill dura VENDOR: Sandvik PRODUCT: 1K377-0600-050-XD 1730
Operation 7/30 DESCRIPTION: Roughing6 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.6mm OPTIMAL LOAD: 4.5mm LOAD DEVIATION: 0.45mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3368.131mm/min CUTTING DISTANCE: 602.77mm RAPID DISTANCE: 1405.69mm ESTIMATED CYCLE TIME: 28s (2.1%) COOLANT: Flood	T12005 D12005 L12005 TYPE: flat end mill DIAMETER: 6mm LENGTH: 28.8mm FLUTES: 7 DESCRIPTION: CoroMill dura VENDOR: Sandvik PRODUCT: 1K377-0600-050-XD 1730
Operation 8/30 DESCRIPTION: Roughing7 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.6mm OPTIMAL LOAD: 4.5mm LOAD DEVIATION: 0.45mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 3368.131mm/min CUTTING DISTANCE: 728.52mm RAPID DISTANCE: 2278.66mm ESTIMATED CYCLE TIME: 40s (3.1%) COOLANT: Flood	T12005 D12005 L12005 TYPE: flat end mill DIAMETER: 6mm LENGTH: 28.8mm FLUTES: 7 DESCRIPTION: CoroMill dura VENDOR: Sandvik PRODUCT: 1K377-0600-050-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 9/30 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: 426.29mm RAPID DISTANCE: 1600.68mm ESTIMATED CYCLE TIME: 34s (2.6%) COOLANT: Flood	T10003 D10003 L10003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730
NOTES:		
This roughing operation may lead to collisions with the shaft or holder, due to a known limitation in Fusion. Enabling Shaft & Holder might help but results vary. Please check the See details in https://cloudnc.atlassian.net/wiki/x/AYCREg		
Operation 10/30 DESCRIPTION: Roughing9 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 3.17mm OPTIMAL LOAD: 0.62mm LOAD DEVIATION: 0.06mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1293.388mm/min CUTTING DISTANCE: 521.19mm RAPID DISTANCE: 662.33mm ESTIMATED CYCLE TIME: 35s (2.7%) COOLANT: Flood	T11124 D11124 L11124 TYPE: bullnose end mill DIAMETER: 3.17mm CORNER RADIUS: 0.79mm LENGTH: 22mm FLUTES: 4 DESCRIPTION: tasche superiori 34 VENDOR: Sandvik PRODUCT: RA216.24-0830BAK02G

Operation 11/30 DESCRIPTION: Roughing10 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.26mm OPTIMAL LOAD: 2.25mm LOAD DEVIATION: 0.23mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1215mm/min CUTTING DISTANCE: 9.84mm RAPID DISTANCE: 39.07mm ESTIMATED CYCLE TIME: 1s (0.1%) COOLANT: Flood	T12112 D12112 L12112 TYPE: bullnose end mill DIAMETER: 3mm CORNER RADIUS: 0.2mm LENGTH: 17.4mm FLUTES: 5 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1K365-0300-020-XC 1730
Operation 12/30 DESCRIPTION: Roughing11 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.26mm OPTIMAL LOAD: 2.25mm LOAD DEVIATION: 0.23mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1215mm/min CUTTING DISTANCE: 102.81mm RAPID DISTANCE: 520.03mm ESTIMATED CYCLE TIME: 11s (0.9%) COOLANT: Flood	T12112 D12112 L12112 TYPE: bullnose end mill DIAMETER: 3mm CORNER RADIUS: 0.2mm LENGTH: 17.4mm FLUTES: 5 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1K365-0300-020-XC 1730
Operation 13/30 DESCRIPTION: Roughing12 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.26mm OPTIMAL LOAD: 2.25mm LOAD DEVIATION: 0.23mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1215mm/min CUTTING DISTANCE: 100.13mm RAPID DISTANCE: 528.02mm ESTIMATED CYCLE TIME: 11s (0.9%) COOLANT: Flood	T12112 D12112 L12112 TYPE: bullnose end mill DIAMETER: 3mm CORNER RADIUS: 0.2mm LENGTH: 17.4mm FLUTES: 5 DESCRIPTION: CoroMill Dura VENDOR: Sandvik PRODUCT: 1K365-0300-020-XC 1730
Operation 14/30 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	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 15/30 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	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
NOTES: This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 16/30 DESCRIPTION: Flat2 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 255.25mm RAPID DISTANCE: 1759.23mm ESTIMATED CYCLE TIME: 30s (2.4%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
NOTES: This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 17/30 DESCRIPTION: Flat3 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 202.28mm RAPID DISTANCE: 298.96mm ESTIMATED CYCLE TIME: 10s (0.8%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
NOTES: This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 18/30 DESCRIPTION: Flat4 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 14mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 4050mm/min CUTTING DISTANCE: 201.34mm RAPID DISTANCE: 299.93mm ESTIMATED CYCLE TIME: 10s (0.8%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
NOTES: This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 19/30 DESCRIPTION: Flat5 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 9.8mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 8100mm/min CUTTING DISTANCE: 324.73mm RAPID DISTANCE: 947.58mm ESTIMATED CYCLE TIME: 16s (1.2%) COOLANT: Flood	T11110 D11110 L11110 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 90mm FLUTES: 5 DESCRIPTION: Contornatura blocco sup S2 VENDOR: Sandvik PRODUCT: 1K365-2000-300-XD

Operation 20/30 DESCRIPTION: Flat6 WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.27mm/0mm MAXIMUM STEPOVER: 6.86mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1620mm/min CUTTING DISTANCE: 122.29mm RAPID DISTANCE: 72.55mm ESTIMATED CYCLE TIME: 5s (0.4%) COOLANT: Flood	T10112 D10112 L10112 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216.24-10050CCK22P 1620
NOTES: This flat finishing operation may not fully finish the surface. Please check the simulation.		
Operation 21/30 DESCRIPTION: Wall STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 70mm MAXIMUM STEPOVER: 19mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2001.934mm/min CUTTING DISTANCE: 103.82mm RAPID DISTANCE: 37.75mm ESTIMATED CYCLE TIME: 5s (0.4%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 22/30 DESCRIPTION: Wall1 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 70mm MAXIMUM STEPOVER: 19mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2001.934mm/min CUTTING DISTANCE: 100.81mm RAPID DISTANCE: 55.2mm ESTIMATED CYCLE TIME: 5s (0.4%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 23/30 DESCRIPTION: Wall2 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 70mm MAXIMUM STEPOVER: 19mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2001.934mm/min CUTTING DISTANCE: 117.05mm RAPID DISTANCE: 653.5mm ESTIMATED CYCLE TIME: 14s (1.1%) COOLANT: Flood	T10110 D10110 L10110 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730
Operation 24/30 DESCRIPTION: Wall3 STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 66.5mm MAXIMUM STEPOVER: 13.3mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1803.93mm/min CUTTING DISTANCE: 190.15mm RAPID DISTANCE: 286.48mm ESTIMATED CYCLE TIME: 17s (1.3%) COOLANT: Flood	T11110 D11110 L11110 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 90mm FLUTES: 5 DESCRIPTION: Contornatura blocco sup S2 VENDOR: Sandvik PRODUCT: 1K365-2000-300-XD
Operation 25/30 DESCRIPTION: Holemaking STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1942rpm MAXIMUM FEEDRATE: 535.906mm/min CUTTING DISTANCE: 127.12mm RAPID DISTANCE: 157.12mm ESTIMATED CYCLE TIME: 16s (1.2%) COOLANT: Flood	T12007 D12007 L12007 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 161mm FLUTES: 2 DESCRIPTION: CoroDrill 860-PM VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM
Operation 26/30 DESCRIPTION: Holemaking1 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 4905rpm MAXIMUM FEEDRATE: 564.081mm/min CUTTING DISTANCE: 189.44mm RAPID DISTANCE: 388.45mm ESTIMATED CYCLE TIME: 25s (1.9%) COOLANT: Flood	T11010 D11010 L11010 TYPE: drill DIAMETER: 5mm TIP ANGLE: 147° LENGTH: 52mm FLUTES: 2 DESCRIPTION: Fori superiori 5mm VENDOR: Sandvik PRODUCT: 860.1-0500-037A1-PM
Operation 27/30 DESCRIPTION: Holemaking2 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 7654rpm MAXIMUM FEEDRATE: 528.096mm/min CUTTING DISTANCE: 13.55mm RAPID DISTANCE: 43.55mm ESTIMATED CYCLE TIME: 2s (0.2%) COOLANT: Flood	T12118 D12118 L12118 TYPE: drill DIAMETER: 3mm TIP ANGLE: 140° LENGTH: 64.45mm FLUTES: 2 DESCRIPTION: CoroDrill 862-GM VENDOR: Sandvik PRODUCT: 862.1-3000-270A0-GM X2BL
Operation 28/30 DESCRIPTION: Freeform STRATEGY: Contour WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 0.08mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1265mm/min CUTTING DISTANCE: 148.9mm RAPID DISTANCE: 239.02mm ESTIMATED CYCLE TIME: 11s (0.9%) COOLANT: Flood	T10112 D10112 L10112 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216.24-10050CCK22P 1620
Operation 29/30 DESCRIPTION: Slot wall STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 1.6mm MAXIMUM STEPOVER: 0.81mm	MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 5273.1mm/min CUTTING DISTANCE: 648.4mm RAPID DISTANCE: 66mm ESTIMATED CYCLE TIME: 9s (0.7%) COOLANT: Flood	T12113 D12113 L12113 TYPE: slot mill DIAMETER: 21.7mm LENGTH: 22.3mm FLUTES: 3 DESCRIPTION: CoroMill 327 VENDOR: Sandvik PRODUCT: 327-16B24SC-12 , 327R12-22 16000-GM 1025

Operation 30/30
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

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](#)

