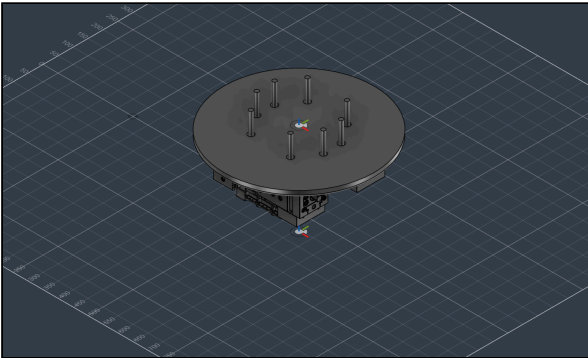








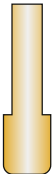


Setup Sheet for Program 1001

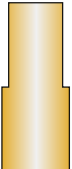


JOB DESCRIPTION: Setup1
DOCUMENT PATH: Finito v20 v1

Setup	
<p>WCS: #1</p> <p>Stock:</p> <p>DX: 160.29mm</p> <p>DY: 295mm</p> <p>DZ: 35mm</p> <p>PART:</p> <p>DX: 150.29mm</p> <p>DY: 284.87mm</p> <p>DZ: 25mm</p> <p>Stock Lower in WCS #1:</p> <p>X: -160mm</p> <p>Y: 0mm</p> <p>Z: -35mm</p> <p>Stock Upper in WCS #1:</p> <p>X: 0.29mm</p> <p>Y: 295mm</p> <p>Z: 0mm</p>	

Total
<p>NUMBER OF OPERATIONS: 18</p> <p>NUMBER OF TOOLS: 13</p> <p>TOOLS: T1 T2 T3 T4 T5 T6 T7 T8 T9 T10 T11 T12 T13</p> <p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -20mm</p> <p>MAXIMUM FEEDRATE: 2470mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8000rpm</p> <p>CUTTING DISTANCE: 33288.01mm</p> <p>RAPID DISTANCE: 11622.74mm</p> <p>ESTIMATED CYCLE TIME: 1h:8m:14s</p>

Tools		
<p>T1 D1 L1</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 40mm</p> <p>LENGTH: 100mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill490 Sgrossatura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 490-040A32-14H</p>	<p>MINIMUM Z: -4.8mm</p> <p>MAXIMUM FEED: 2470mm/min</p> <p>MAXIMUM SPINDLE SPEED: 1880rpm</p> <p>CUTTING DISTANCE: 1865.75mm</p> <p>RAPID DISTANCE: 160.04mm</p> <p>ESTIMATED CYCLE TIME: 49s (1.2%)</p>	
<p>T2 D2 L2</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 14mm</p> <p>LENGTH: 60mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: CoroMill Plura Contornatura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 2N342-1400-PC 1730</p>	<p>MINIMUM Z: -17.8mm</p> <p>MAXIMUM FEED: 695mm/min</p> <p>MAXIMUM SPINDLE SPEED: 1620rpm</p> <p>CUTTING DISTANCE: 3656.14mm</p> <p>RAPID DISTANCE: 2553.32mm</p> <p>ESTIMATED CYCLE TIME: 5m:46s (8.5%)</p>	
<p>T3 D3 L3</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 5mm</p> <p>LENGTH: 21mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura Tasche</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 2P342-0500-PA 1730</p>	<p>MINIMUM Z: -15.6mm</p> <p>MAXIMUM FEED: 420mm/min</p> <p>MAXIMUM SPINDLE SPEED: 5910rpm</p> <p>CUTTING DISTANCE: 7169.02mm</p> <p>RAPID DISTANCE: 1188.29mm</p> <p>ESTIMATED CYCLE TIME: 22m:10s (32.5%)</p>	
<p>T4 D4 L4</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 10mm</p> <p>LENGTH: 35mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura Forogrande</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1K324-1000-XB 1730</p>	<p>MINIMUM Z: -17.8mm</p> <p>MAXIMUM FEED: 350mm/min</p> <p>MAXIMUM SPINDLE SPEED: 2090rpm</p> <p>CUTTING DISTANCE: 1357.13mm</p> <p>RAPID DISTANCE: 247.44mm</p> <p>ESTIMATED CYCLE TIME: 3m:58s (5.8%)</p>	
<p>T5 D5 L5</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4mm</p> <p>LENGTH: 30mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Plura Taschelaterali</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 2S342-0500-100-PA 1730</p>	<p>MINIMUM Z: -15mm</p> <p>MAXIMUM FEED: 959mm/min</p> <p>MAXIMUM SPINDLE SPEED: 5400rpm</p> <p>CUTTING DISTANCE: 1293.4mm</p> <p>RAPID DISTANCE: 514.82mm</p> <p>ESTIMATED CYCLE TIME: 1m:30s (2.2%)</p>	
<p>T6 D6 L6</p> <p>TYPE: drill</p> <p>DIAMETER: 2.5mm</p> <p>TIP ANGLE: 140°</p> <p>LENGTH: 38mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: CoroDrill 862 Foripiccoli</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 862.1-2500-225A0-GM X2BL</p>	<p>MINIMUM Z: -20mm</p> <p>MAXIMUM FEED: 113mm/min</p> <p>MAXIMUM SPINDLE SPEED: 4010rpm</p> <p>CUTTING DISTANCE: 540mm</p> <p>RAPID DISTANCE: 3402.18mm</p> <p>ESTIMATED CYCLE TIME: 5m:28s (8%)</p>	

T7 D7 L7 TYPE: flat end mill DIAMETER: 25mm LENGTH: 60mm FLUTES: 2 DESCRIPTION: CoroMill 390 Finituraforogrande VENDOR: Sandvik PRODUCT: R390-025A25-17L	MINIMUM Z: -17.6mm MAXIMUM FEED: 914.4mm/min MAXIMUM SPINDLE SPEED: 3810rpm CUTTING DISTANCE: 160.86mm RAPID DISTANCE: 245.18mm ESTIMATED CYCLE TIME: 16s (0.4%)	
T8 D8 L8 TYPE: face mill DIAMETER: 50mm CORNER RADIUS: 10mm LENGTH: 180mm FLUTES: 3 DESCRIPTION: CoroMill 200 Finiturasgrossatura VENDOR: Sandvik PRODUCT: R200-030A32-20M	MINIMUM Z: -5mm MAXIMUM FEED: 1050mm/min MAXIMUM SPINDLE SPEED: 2500rpm CUTTING DISTANCE: 2840.45mm RAPID DISTANCE: 317.78mm ESTIMATED CYCLE TIME: 2m:47s (4.1%)	
T9 D9 L9 TYPE: flat end mill DIAMETER: 12mm LENGTH: 60mm FLUTES: 4 DESCRIPTION: CoroMill Dura Finituracontornatura VENDOR: Sandvik PRODUCT: 1K334-1200-XB 1730	MINIMUM Z: -18mm MAXIMUM FEED: 2100mm/min MAXIMUM SPINDLE SPEED: 3710rpm CUTTING DISTANCE: 1933.26mm RAPID DISTANCE: 226.6mm ESTIMATED CYCLE TIME: 1m:5s (1.6%)	
T10 D10 L10 TYPE: flat end mill DIAMETER: 3.97mm LENGTH: 40mm FLUTES: 4 DESCRIPTION: CoroMill Plura Finituratasche VENDOR: Sandvik PRODUCT: RA215.24-1050AAK08L 1620	MINIMUM Z: -16mm MAXIMUM FEED: 753mm/min MAXIMUM SPINDLE SPEED: 4480rpm CUTTING DISTANCE: 6801.65mm RAPID DISTANCE: 1095.62mm ESTIMATED CYCLE TIME: 9m:35s (14.1%)	
T11 D11 L11 TYPE: flat end mill DIAMETER: 2.5mm LENGTH: 30mm FLUTES: 3 DESCRIPTION: CoroMill Plura Finituratascapiccola VENDOR: Sandvik PRODUCT: 1P251-0250-XA 1630	MINIMUM Z: -16mm MAXIMUM FEED: 333.333mm/min MAXIMUM SPINDLE SPEED: 6880rpm CUTTING DISTANCE: 783.72mm RAPID DISTANCE: 249.78mm ESTIMATED CYCLE TIME: 3m:20s (4.9%)	
T12 D12 L12 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 1mm LENGTH: 30mm FLUTES: 4 DESCRIPTION: CoroMill Dura PavimentoTascheLaterali VENDOR: Sandvik PRODUCT: 1K334-0400-100-XC 1730	MINIMUM Z: -16.4mm MAXIMUM FEED: 497mm/min MAXIMUM SPINDLE SPEED: 6120rpm CUTTING DISTANCE: 3582.04mm RAPID DISTANCE: 905.66mm ESTIMATED CYCLE TIME: 7m:33s (11.1%)	
T13 D13 L13 TYPE: flat end mill DIAMETER: 4mm LENGTH: 30mm FLUTES: 3 DESCRIPTION: CoroMill Plura FinituraTascheLaterali VENDOR: Sandvik PRODUCT: R216.23-04050CAK11P 1620	MINIMUM Z: -15mm MAXIMUM FEED: 2330mm/min MAXIMUM SPINDLE SPEED: 8000rpm CUTTING DISTANCE: 1304.6mm RAPID DISTANCE: 516.04mm ESTIMATED CYCLE TIME: 41s (1%)	

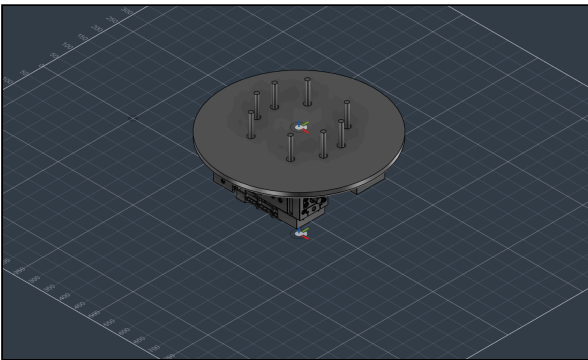
Operations			
Operation 1/18 DESCRIPTION: Sgrossatura faccia superiore STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 28mm	MAXIMUM Z: 15mm MINIMUM Z: -4.8mm MAXIMUM SPINDLE SPEED: 1880rpm MAXIMUM FEEDRATE: 2470mm/min CUTTING DISTANCE: 1865.75mm RAPID DISTANCE: 160.04mm ESTIMATED CYCLE TIME: 49s (1.2%) COOLANT: Air	T1 D1 L1 TYPE: flat end mill DIAMETER: 40mm LENGTH: 100mm FLUTES: 4 DESCRIPTION: CoroMill490 Sgrossatura VENDOR: Sandvik PRODUCT: 490-040A32-14H	
Operation 2/18 DESCRIPTION: Contornatura STRATEGY: Adaptive 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.2mm OPTIMAL LOAD: 5.6mm LOAD DEVIATION: 0.56mm	MAXIMUM Z: 2.5mm MINIMUM Z: -17.8mm MAXIMUM SPINDLE SPEED: 1620rpm MAXIMUM FEEDRATE: 695mm/min CUTTING DISTANCE: 3656.14mm RAPID DISTANCE: 2553.32mm ESTIMATED CYCLE TIME: 5m:46s (8.5%) COOLANT: Flood	T2 D2 L2 TYPE: flat end mill DIAMETER: 14mm LENGTH: 60mm FLUTES: 5 DESCRIPTION: CoroMill Plura Contornatura VENDOR: Sandvik PRODUCT: 2N342-1400-PC 1730	
Operation 3/18 DESCRIPTION: Tasche STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.2mm MAXIMUM STEPDOWN: 3.6mm MAXIMUM STEPOVER: 3.5mm	MAXIMUM Z: 2.5mm MINIMUM Z: -15.6mm MAXIMUM SPINDLE SPEED: 3540rpm MAXIMUM FEEDRATE: 420mm/min CUTTING DISTANCE: 6234.3mm RAPID DISTANCE: 938.34mm ESTIMATED CYCLE TIME: 15m:45s (23.1%) COOLANT: Flood	T3 D3 L3 TYPE: flat end mill DIAMETER: 5mm LENGTH: 21mm FLUTES: 4 DESCRIPTION: CoroMill Dura Tasche VENDOR: Sandvik PRODUCT: 2P342-0500-PA 1730	

<p>Operation 4/18</p> <p>DESCRIPTION: Tasca piccola</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.2mm</p> <p>MAXIMUM STEPDOWN: 3.6mm</p> <p>MAXIMUM STEPOVER: 1.5mm</p>	<p>MAXIMUM Z: 2.5mm</p> <p>MINIMUM Z: -15.6mm</p> <p>MAXIMUM SPINDLE SPEED: 5910rpm</p> <p>MAXIMUM FEEDRATE: 333.333mm/min</p> <p>CUTTING DISTANCE: 934.71mm</p> <p>RAPID DISTANCE: 249.94mm</p> <p>ESTIMATED CYCLE TIME: 6m:25s (9.4%)</p> <p>COOLANT: Flood</p>	<p>T3 D3 L3</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 2.5mm</p> <p>LENGTH: 21mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: CoroMill Plura Tascapiccola</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1P250-0250-XA 1630</p>	
<p>Operation 5/18</p> <p>DESCRIPTION: Foro grande</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.2mm</p> <p>MAXIMUM STEPDOWN: 4.5mm</p> <p>MAXIMUM STEPOVER: 6mm</p>	<p>MAXIMUM Z: 2.5mm</p> <p>MINIMUM Z: -17.8mm</p> <p>MAXIMUM SPINDLE SPEED: 2090rpm</p> <p>MAXIMUM FEEDRATE: 350mm/min</p> <p>CUTTING DISTANCE: 1357.13mm</p> <p>RAPID DISTANCE: 247.44mm</p> <p>ESTIMATED CYCLE TIME: 3m:58s (5.8%)</p> <p>COOLANT: Flood</p>	<p>T4 D4 L4</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 10mm</p> <p>LENGTH: 35mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura Forogrande</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1K324-1000-XB 1730</p>	
<p>Operation 6/18</p> <p>DESCRIPTION: Tasche laterali</p> <p>STRATEGY: Adaptive 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.2mm</p> <p>OPTIMAL LOAD: 3mm</p> <p>LOAD DEVIATION: 0.3mm</p>	<p>MAXIMUM Z: 5mm</p> <p>MINIMUM Z: -15mm</p> <p>MAXIMUM SPINDLE SPEED: 5400rpm</p> <p>MAXIMUM FEEDRATE: 959mm/min</p> <p>CUTTING DISTANCE: 646.7mm</p> <p>RAPID DISTANCE: 257.41mm</p> <p>ESTIMATED CYCLE TIME: 45s (1.1%)</p> <p>COOLANT: Flood</p>	<p>T5 D5 L5</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4mm</p> <p>LENGTH: 30mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Plura Taschelaterali</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 2S342-0500-100-PA 1730</p>	
<p>Operation 7/18</p> <p>DESCRIPTION: Tasche laterali 2</p> <p>STRATEGY: Adaptive 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.2mm</p> <p>OPTIMAL LOAD: 3mm</p> <p>LOAD DEVIATION: 0.3mm</p>	<p>MAXIMUM Z: 5mm</p> <p>MINIMUM Z: -15mm</p> <p>MAXIMUM SPINDLE SPEED: 5400rpm</p> <p>MAXIMUM FEEDRATE: 959mm/min</p> <p>CUTTING DISTANCE: 646.7mm</p> <p>RAPID DISTANCE: 257.41mm</p> <p>ESTIMATED CYCLE TIME: 45s (1.1%)</p> <p>COOLANT: Flood</p>	<p>T5 D5 L5</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4mm</p> <p>LENGTH: 30mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Plura Taschelaterali</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 2S342-0500-100-PA 1730</p>	
<p>Operation 8/18</p> <p>DESCRIPTION: Fori piccoli</p> <p>STRATEGY: Drilling</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -20mm</p> <p>MAXIMUM SPINDLE SPEED: 4010rpm</p> <p>MAXIMUM FEEDRATE: 113mm/min</p> <p>CUTTING DISTANCE: 540mm</p> <p>RAPID DISTANCE: 3402.18mm</p> <p>ESTIMATED CYCLE TIME: 5m:28s (8%)</p> <p>COOLANT: Flood</p>	<p>T6 D6 L6</p> <p>TYPE: drill</p> <p>DIAMETER: 2.5mm</p> <p>TIP ANGLE: 140°</p> <p>LENGTH: 38mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: CoroDrill 862 Foripiccoli</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 862.1-2500-225A0-GM X2BL</p>	
<p>Operation 9/18</p> <p>DESCRIPTION: Finitura faccia superiore</p> <p>STRATEGY: Facing</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>MAXIMUM STEPOVER: 21mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -5mm</p> <p>MAXIMUM SPINDLE SPEED: 2500rpm</p> <p>MAXIMUM FEEDRATE: 1050mm/min</p> <p>CUTTING DISTANCE: 2840.45mm</p> <p>RAPID DISTANCE: 317.78mm</p> <p>ESTIMATED CYCLE TIME: 2m:47s (4.1%)</p> <p>COOLANT: Flood</p>	<p>T8 D8 L8</p> <p>TYPE: face mill</p> <p>DIAMETER: 50mm</p> <p>CORNER RADIUS: 10mm</p> <p>LENGTH: 180mm</p> <p>FLUTES: 3</p> <p>DESCRIPTION: CoroMill 200 Finiturasgrossatura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: R200-030A32-20M</p>	
<p>Operation 10/18</p> <p>DESCRIPTION: Finitura contornatura</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 12.5mm</p> <p>MAXIMUM STEPOVER: 11.4mm</p>	<p>MAXIMUM Z: 2.5mm</p> <p>MINIMUM Z: -18mm</p> <p>MAXIMUM SPINDLE SPEED: 3710rpm</p> <p>MAXIMUM FEEDRATE: 2100mm/min</p> <p>CUTTING DISTANCE: 1933.26mm</p> <p>RAPID DISTANCE: 226.6mm</p> <p>ESTIMATED CYCLE TIME: 1m:5s (1.6%)</p> <p>COOLANT: Flood</p>	<p>T9 D9 L9</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 12mm</p> <p>LENGTH: 60mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura Finituracontornatura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1K334-1200-XB 1730</p>	
<p>Operation 11/18</p> <p>DESCRIPTION: Finitura tasche</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 3.7mm</p> <p>MAXIMUM STEPOVER: 3.5mm</p>	<p>MAXIMUM Z: 2.5mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 4480rpm</p> <p>MAXIMUM FEEDRATE: 753mm/min</p> <p>CUTTING DISTANCE: 6801.65mm</p> <p>RAPID DISTANCE: 1095.62mm</p> <p>ESTIMATED CYCLE TIME: 9m:35s (14.1%)</p> <p>COOLANT: Flood</p>	<p>T10 D10 L10</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 3.97mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Plura Finituratasche</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: RA215.24-1050AAK08L 1620</p>	
<p>Operation 12/18</p> <p>DESCRIPTION: Finitura tasca piccola</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 3.7mm</p> <p>MAXIMUM STEPOVER: 3.5mm</p>	<p>MAXIMUM Z: 2.5mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 6880rpm</p> <p>MAXIMUM FEEDRATE: 333.333mm/min</p> <p>CUTTING DISTANCE: 783.72mm</p> <p>RAPID DISTANCE: 249.78mm</p> <p>ESTIMATED CYCLE TIME: 3m:20s (4.9%)</p> <p>COOLANT: Flood</p>	<p>T11 D11 L11</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 2.5mm</p> <p>LENGTH: 30mm</p> <p>FLUTES: 3</p> <p>DESCRIPTION: CoroMill Plura Finituratascapiccola</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1P251-0250-XA 1630</p>	
<p>Operation 13/18</p> <p>DESCRIPTION: Finitura foro grande</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPOVER: 23.75mm</p>	<p>MAXIMUM Z: 2.5mm</p> <p>MINIMUM Z: -17.6mm</p> <p>MAXIMUM SPINDLE SPEED: 3810rpm</p> <p>MAXIMUM FEEDRATE: 914.4mm/min</p> <p>CUTTING DISTANCE: 160.86mm</p> <p>RAPID DISTANCE: 245.18mm</p> <p>ESTIMATED CYCLE TIME: 16s (0.4%)</p> <p>COOLANT: Flood</p>	<p>T7 D7 L7</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 25mm</p> <p>LENGTH: 60mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: CoroMill 390 Finituraforogrande</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: R390-025A25-17L</p>	



Operation 14/18 DESCRIPTION: Finitura tasche laterali STRATEGY: Adaptive 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm OPTIMAL LOAD: 3mm LOAD DEVIATION: 0.3mm	MAXIMUM Z: 5mm MINIMUM Z: -15mm MAXIMUM SPINDLE SPEED: 8000rpm MAXIMUM FEEDRATE: 2330mm/min CUTTING DISTANCE: 652.3mm RAPID DISTANCE: 258.02mm ESTIMATED CYCLE TIME: 21s (0.5%) COOLANT: Flood	T13 D13 L13 TYPE: flat end mill DIAMETER: 4mm LENGTH: 30mm FLUTES: 3 DESCRIPTION: CoroMill Plura FinituraTascheLaterali VENDOR: Sandvik PRODUCT: R216.23-04050CAK11P 1620	
Operation 15/18 DESCRIPTION: Finitura tasche laterali 2 STRATEGY: Adaptive 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm OPTIMAL LOAD: 3mm LOAD DEVIATION: 0.3mm	MAXIMUM Z: 5mm MINIMUM Z: -15mm MAXIMUM SPINDLE SPEED: 8000rpm MAXIMUM FEEDRATE: 2330mm/min CUTTING DISTANCE: 652.3mm RAPID DISTANCE: 258.02mm ESTIMATED CYCLE TIME: 21s (0.5%) COOLANT: Flood	T13 D13 L13 TYPE: flat end mill DIAMETER: 4mm LENGTH: 30mm FLUTES: 3 DESCRIPTION: CoroMill Plura FinituraTascheLaterali VENDOR: Sandvik PRODUCT: R216.23-04050CAK11P 1620	
Operation 16/18 DESCRIPTION: Finitura pavimento tasche laterali STRATEGY: Adaptive 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm OPTIMAL LOAD: 3mm LOAD DEVIATION: 0.3mm	MAXIMUM Z: 5mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 6120rpm MAXIMUM FEEDRATE: 497mm/min CUTTING DISTANCE: 989.16mm RAPID DISTANCE: 263.96mm ESTIMATED CYCLE TIME: 2m:7s (3.1%) COOLANT: Flood	T12 D12 L12 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 1mm LENGTH: 30mm FLUTES: 4 DESCRIPTION: CoroMill Dura PavimentoTascheLaterali VENDOR: Sandvik PRODUCT: 1K334-0400-100-XC 1730	
Operation 17/18 DESCRIPTION: Finitura pavimento tasche laterali 2 STRATEGY: Adaptive 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm OPTIMAL LOAD: 3mm LOAD DEVIATION: 0.3mm	MAXIMUM Z: 5mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 6120rpm MAXIMUM FEEDRATE: 497mm/min CUTTING DISTANCE: 989.15mm RAPID DISTANCE: 263.96mm ESTIMATED CYCLE TIME: 2m:7s (3.1%) COOLANT: Flood	T12 D12 L12 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 1mm LENGTH: 30mm FLUTES: 4 DESCRIPTION: CoroMill Dura PavimentoTascheLaterali VENDOR: Sandvik PRODUCT: 1K334-0400-100-XC 1730	
Operation 18/18 DESCRIPTION: Raccordo nervatura STRATEGY: Scallop WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.2mm	MAXIMUM Z: 15mm MINIMUM Z: -16.4mm MAXIMUM SPINDLE SPEED: 6120rpm MAXIMUM FEEDRATE: 497mm/min CUTTING DISTANCE: 1603.72mm RAPID DISTANCE: 377.73mm ESTIMATED CYCLE TIME: 3m:19s (4.8%) COOLANT: Flood	T12 D12 L12 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 1mm LENGTH: 30mm FLUTES: 4 DESCRIPTION: CoroMill Dura PavimentoTascheLaterali VENDOR: Sandvik PRODUCT: 1K334-0400-100-XC 1730	





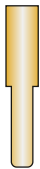
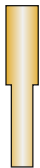
Setup Sheet for Program 1002

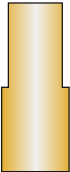



JOB DESCRIPTION: Setup2
DOCUMENT PATH: Finito v20 v1

Setup	
<p>WCS: #1</p> <p>Stock: DX: 160.29mm DY: 295mm DZ: 35mm</p> <p>PART: DX: 150.29mm DY: 284.87mm DZ: 25mm</p> <p>Stock Lower in WCS #1: X: 0mm Y: -295mm Z: -35mm</p> <p>Stock Upper in WCS #1: X: 160.29mm Y: 0mm Z: 0mm</p>	



Total
<p>NUMBER OF OPERATIONS: 17</p> <p>NUMBER OF TOOLS: 12</p> <p>TOOLS: T1 T2 T3 T4 T5 T7 T8 T9 T10 T11 T12 T13</p> <p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -19.4mm</p> <p>MAXIMUM FEEDRATE: 2470mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8000rpm</p> <p>CUTTING DISTANCE: 33065.61mm</p> <p>RAPID DISTANCE: 8537.49mm</p> <p>ESTIMATED CYCLE TIME: 1h:3m:10s</p>

Tools		
<p>T1 D1 L1</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 40mm</p> <p>LENGTH: 100mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill490 Sgrossatura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 490-040A32-14H</p>	<p>MINIMUM Z: -4.8mm</p> <p>MAXIMUM FEED: 2470mm/min</p> <p>MAXIMUM SPINDLE SPEED: 1880rpm</p> <p>CUTTING DISTANCE: 1865.75mm</p> <p>RAPID DISTANCE: 303.19mm</p> <p>ESTIMATED CYCLE TIME: 51s (1.3%)</p>	
<p>T2 D2 L2</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 14mm</p> <p>LENGTH: 60mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: CoroMill Plura Contornatura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 2N342-1400-PC 1730</p>	<p>MINIMUM Z: -17.8mm</p> <p>MAXIMUM FEED: 695mm/min</p> <p>MAXIMUM SPINDLE SPEED: 1620rpm</p> <p>CUTTING DISTANCE: 3631.05mm</p> <p>RAPID DISTANCE: 2642.28mm</p> <p>ESTIMATED CYCLE TIME: 5m:45s (9.1%)</p>	
<p>T3 D3 L3</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 5mm</p> <p>LENGTH: 21mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura Tasche</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 2P342-0500-PA 1730</p>	<p>MINIMUM Z: -15.6mm</p> <p>MAXIMUM FEED: 420mm/min</p> <p>MAXIMUM SPINDLE SPEED: 5910rpm</p> <p>CUTTING DISTANCE: 7115.43mm</p> <p>RAPID DISTANCE: 1347.85mm</p> <p>ESTIMATED CYCLE TIME: 22m:5s (35%)</p>	
<p>T4 D4 L4</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 10mm</p> <p>LENGTH: 35mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura Forogrande</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1K324-1000-XB 1730</p>	<p>MINIMUM Z: -17.8mm</p> <p>MAXIMUM FEED: 350mm/min</p> <p>MAXIMUM SPINDLE SPEED: 2090rpm</p> <p>CUTTING DISTANCE: 1357.13mm</p> <p>RAPID DISTANCE: 247.41mm</p> <p>ESTIMATED CYCLE TIME: 3m:58s (6.3%)</p>	
<p>T5 D5 L5</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4mm</p> <p>LENGTH: 30mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Plura Taschelaterali</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 2S342-0500-100-PA 1730</p>	<p>MINIMUM Z: -15mm</p> <p>MAXIMUM FEED: 959mm/min</p> <p>MAXIMUM SPINDLE SPEED: 5400rpm</p> <p>CUTTING DISTANCE: 1293.21mm</p> <p>RAPID DISTANCE: 495.24mm</p> <p>ESTIMATED CYCLE TIME: 1m:30s (2.4%)</p>	
<p>T7 D7 L7</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 25mm</p> <p>LENGTH: 60mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: CoroMill 390 Finituraforogrande</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: R390-025A25-17L</p>	<p>MINIMUM Z: -17.6mm</p> <p>MAXIMUM FEED: 914.4mm/min</p> <p>MAXIMUM SPINDLE SPEED: 3810rpm</p> <p>CUTTING DISTANCE: 160.86mm</p> <p>RAPID DISTANCE: 245.18mm</p> <p>ESTIMATED CYCLE TIME: 16s (0.4%)</p>	

T8 D8 L8 TYPE: face mill DIAMETER: 50mm CORNER RADIUS: 10mm LENGTH: 180mm FLUTES: 3 DESCRIPTION: CoroMill 200 Finiturasgrossatura VENDOR: Sandvik PRODUCT: R200-030A32-20M	MINIMUM Z: -5mm MAXIMUM FEED: 1050mm/min MAXIMUM SPINDLE SPEED: 2500rpm CUTTING DISTANCE: 2840.45mm RAPID DISTANCE: 142.23mm ESTIMATED CYCLE TIME: 2m:45s (4.4%)	
T9 D9 L9 TYPE: flat end mill DIAMETER: 12mm LENGTH: 60mm FLUTES: 4 DESCRIPTION: CoroMill Dura Finituracontornatura VENDOR: Sandvik PRODUCT: 1K334-1200-XB 1730	MINIMUM Z: -18mm MAXIMUM FEED: 2100mm/min MAXIMUM SPINDLE SPEED: 3710rpm CUTTING DISTANCE: 1933.26mm RAPID DISTANCE: 379.89mm ESTIMATED CYCLE TIME: 1m:6s (1.8%)	
T10 D10 L10 TYPE: flat end mill DIAMETER: 3.97mm LENGTH: 40mm FLUTES: 4 DESCRIPTION: CoroMill Plura Finituratasche VENDOR: Sandvik PRODUCT: RA215.24-1050AAK08L 1620	MINIMUM Z: -16mm MAXIMUM FEED: 753mm/min MAXIMUM SPINDLE SPEED: 4480rpm CUTTING DISTANCE: 6879.53mm RAPID DISTANCE: 1149.03mm ESTIMATED CYCLE TIME: 9m:41s (15.3%)	
T11 D11 L11 TYPE: flat end mill DIAMETER: 2.5mm LENGTH: 30mm FLUTES: 3 DESCRIPTION: CoroMill Plura Finituratascapiccola VENDOR: Sandvik PRODUCT: 1P251-0250-XA 1630	MINIMUM Z: -16mm MAXIMUM FEED: 333.333mm/min MAXIMUM SPINDLE SPEED: 6880rpm CUTTING DISTANCE: 786.66mm RAPID DISTANCE: 244.74mm ESTIMATED CYCLE TIME: 3m:21s (5.3%)	
T12 D12 L12 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 1mm LENGTH: 30mm FLUTES: 4 DESCRIPTION: CoroMill Dura PavimentoTascheLaterali VENDOR: Sandvik PRODUCT: 1K334-0400-100-XC 1730	MINIMUM Z: -19.4mm MAXIMUM FEED: 497mm/min MAXIMUM SPINDLE SPEED: 6120rpm CUTTING DISTANCE: 3898.44mm RAPID DISTANCE: 843.8mm ESTIMATED CYCLE TIME: 8m:11s (12.9%)	
T13 D13 L13 TYPE: flat end mill DIAMETER: 4mm LENGTH: 30mm FLUTES: 3 DESCRIPTION: CoroMill Plura FinituraTascheLaterali VENDOR: Sandvik PRODUCT: R216.23-04050CAK11P 1620	MINIMUM Z: -15mm MAXIMUM FEED: 2330mm/min MAXIMUM SPINDLE SPEED: 8000rpm CUTTING DISTANCE: 1303.83mm RAPID DISTANCE: 496.65mm ESTIMATED CYCLE TIME: 41s (1.1%)	

Operations			
Operation 1/17 DESCRIPTION: Sgrossatura faccia superiore (2) STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 28mm	MAXIMUM Z: 15mm MINIMUM Z: -4.8mm MAXIMUM SPINDLE SPEED: 1880rpm MAXIMUM FEEDRATE: 2470mm/min CUTTING DISTANCE: 1865.75mm RAPID DISTANCE: 303.19mm ESTIMATED CYCLE TIME: 51s (1.3%) COOLANT: Air	T1 D1 L1 TYPE: flat end mill DIAMETER: 40mm LENGTH: 100mm FLUTES: 4 DESCRIPTION: CoroMill490 Sgrossatura VENDOR: Sandvik PRODUCT: 490-040A32-14H	
Operation 2/17 DESCRIPTION: Contornatura (2) STRATEGY: Adaptive 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.2mm OPTIMAL LOAD: 5.6mm LOAD DEVIATION: 0.56mm	MAXIMUM Z: 2.5mm MINIMUM Z: -17.8mm MAXIMUM SPINDLE SPEED: 1620rpm MAXIMUM FEEDRATE: 695mm/min CUTTING DISTANCE: 3631.05mm RAPID DISTANCE: 2642.28mm ESTIMATED CYCLE TIME: 5m:45s (9.1%) COOLANT: Flood	T2 D2 L2 TYPE: flat end mill DIAMETER: 14mm LENGTH: 60mm FLUTES: 5 DESCRIPTION: CoroMill Plura Contornatura VENDOR: Sandvik PRODUCT: 2N342-1400-PC 1730	
Operation 3/17 DESCRIPTION: Tasche (2) STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.2mm MAXIMUM STEPDOWN: 3.6mm MAXIMUM STEPOVER: 3.5mm	MAXIMUM Z: 2.5mm MINIMUM Z: -15.6mm MAXIMUM SPINDLE SPEED: 3540rpm MAXIMUM FEEDRATE: 420mm/min CUTTING DISTANCE: 6177.78mm RAPID DISTANCE: 1106.08mm ESTIMATED CYCLE TIME: 15m:39s (24.8%) COOLANT: Flood	T3 D3 L3 TYPE: flat end mill DIAMETER: 5mm LENGTH: 21mm FLUTES: 4 DESCRIPTION: CoroMill Dura Tasche VENDOR: Sandvik PRODUCT: 2P342-0500-PA 1730	
Operation 4/17 DESCRIPTION: Tasca piccola (2) STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.2mm MAXIMUM STEPDOWN: 3.6mm MAXIMUM STEPOVER: 1.5mm	MAXIMUM Z: 2.5mm MINIMUM Z: -15.6mm MAXIMUM SPINDLE SPEED: 5910rpm MAXIMUM FEEDRATE: 333.333mm/min CUTTING DISTANCE: 937.65mm RAPID DISTANCE: 241.77mm ESTIMATED CYCLE TIME: 6m:26s (10.2%) COOLANT: Flood	T3 D3 L3 TYPE: flat end mill DIAMETER: 2.5mm LENGTH: 21mm FLUTES: 2 DESCRIPTION: CoroMill Plura Tascapiccola VENDOR: Sandvik PRODUCT: 1P250-0250-XA 1630	

<p>Operation 5/17</p> <p>DESCRIPTION: Foro grande (2)</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.2mm</p> <p>MAXIMUM STEPDOWN: 4.5mm</p> <p>MAXIMUM STEPOVER: 6mm</p>	<p>MAXIMUM Z: 2.5mm</p> <p>MINIMUM Z: -17.8mm</p> <p>MAXIMUM SPINDLE SPEED: 2090rpm</p> <p>MAXIMUM FEEDRATE: 350mm/min</p> <p>CUTTING DISTANCE: 1357.13mm</p> <p>RAPID DISTANCE: 247.41mm</p> <p>ESTIMATED CYCLE TIME: 3m:58s (6.3%)</p> <p>COOLANT: Flood</p>	<p>T4 D4 L4</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 10mm</p> <p>LENGTH: 35mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura Forogrande</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1K324-1000-XB 1730</p>	
<p>Operation 6/17</p> <p>DESCRIPTION: Tasche laterali (2)</p> <p>STRATEGY: Adaptive 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.2mm</p> <p>OPTIMAL LOAD: 3mm</p> <p>LOAD DEVIATION: 0.3mm</p>	<p>MAXIMUM Z: 5mm</p> <p>MINIMUM Z: -15mm</p> <p>MAXIMUM SPINDLE SPEED: 5400rpm</p> <p>MAXIMUM FEEDRATE: 959mm/min</p> <p>CUTTING DISTANCE: 646.6mm</p> <p>RAPID DISTANCE: 247.62mm</p> <p>ESTIMATED CYCLE TIME: 45s (1.2%)</p> <p>COOLANT: Flood</p>	<p>T5 D5 L5</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4mm</p> <p>LENGTH: 30mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Plura Taschelaterali</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 2S342-0500-100-PA 1730</p>	
<p>Operation 7/17</p> <p>DESCRIPTION: Tasche laterali 2 (2)</p> <p>STRATEGY: Adaptive 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.2mm</p> <p>OPTIMAL LOAD: 3mm</p> <p>LOAD DEVIATION: 0.3mm</p>	<p>MAXIMUM Z: 5mm</p> <p>MINIMUM Z: -15mm</p> <p>MAXIMUM SPINDLE SPEED: 5400rpm</p> <p>MAXIMUM FEEDRATE: 959mm/min</p> <p>CUTTING DISTANCE: 646.61mm</p> <p>RAPID DISTANCE: 247.62mm</p> <p>ESTIMATED CYCLE TIME: 45s (1.2%)</p> <p>COOLANT: Flood</p>	<p>T5 D5 L5</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4mm</p> <p>LENGTH: 30mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Plura Taschelaterali</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 2S342-0500-100-PA 1730</p>	
<p>Operation 8/17</p> <p>DESCRIPTION: Finitura faccia superiore (2)</p> <p>STRATEGY: Facing</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>MAXIMUM STEPOVER: 21mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -5mm</p> <p>MAXIMUM SPINDLE SPEED: 2500rpm</p> <p>MAXIMUM FEEDRATE: 1050mm/min</p> <p>CUTTING DISTANCE: 2840.45mm</p> <p>RAPID DISTANCE: 142.23mm</p> <p>ESTIMATED CYCLE TIME: 2m:45s (4.4%)</p> <p>COOLANT: Flood</p>	<p>T8 D8 L8</p> <p>TYPE: face mill</p> <p>DIAMETER: 50mm</p> <p>CORNER RADIUS: 10mm</p> <p>LENGTH: 180mm</p> <p>FLUTES: 3</p> <p>DESCRIPTION: CoroMill 200 Finiturasgrossatura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: R200-030A32-20M</p>	
<p>Operation 9/17</p> <p>DESCRIPTION: Finitura contornatura (2)</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 12.5mm</p> <p>MAXIMUM STEPOVER: 11.4mm</p>	<p>MAXIMUM Z: 2.5mm</p> <p>MINIMUM Z: -18mm</p> <p>MAXIMUM SPINDLE SPEED: 3710rpm</p> <p>MAXIMUM FEEDRATE: 2100mm/min</p> <p>CUTTING DISTANCE: 1933.26mm</p> <p>RAPID DISTANCE: 379.89mm</p> <p>ESTIMATED CYCLE TIME: 1m:6s (1.8%)</p> <p>COOLANT: Flood</p>	<p>T9 D9 L9</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 12mm</p> <p>LENGTH: 60mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Dura Finituracontornatura</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1K334-1200-XB 1730</p>	
<p>Operation 10/17</p> <p>DESCRIPTION: Finitura tasche (2)</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 3.7mm</p> <p>MAXIMUM STEPOVER: 3.5mm</p>	<p>MAXIMUM Z: 2.5mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 4480rpm</p> <p>MAXIMUM FEEDRATE: 753mm/min</p> <p>CUTTING DISTANCE: 6879.53mm</p> <p>RAPID DISTANCE: 1149.03mm</p> <p>ESTIMATED CYCLE TIME: 9m:41s (15.3%)</p> <p>COOLANT: Flood</p>	<p>T10 D10 L10</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 3.97mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: CoroMill Plura Finituratasche</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: RA215 24-1050AAK08L 1620</p>	
<p>Operation 11/17</p> <p>DESCRIPTION: Finitura tasca piccola (2)</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 3.7mm</p> <p>MAXIMUM STEPOVER: 3.5mm</p>	<p>MAXIMUM Z: 2.5mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 6880rpm</p> <p>MAXIMUM FEEDRATE: 333.333mm/min</p> <p>CUTTING DISTANCE: 786.66mm</p> <p>RAPID DISTANCE: 244.74mm</p> <p>ESTIMATED CYCLE TIME: 3m:21s (5.3%)</p> <p>COOLANT: Flood</p>	<p>T11 D11 L11</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 2.5mm</p> <p>LENGTH: 30mm</p> <p>FLUTES: 3</p> <p>DESCRIPTION: CoroMill Plura Finituratascapiccola</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: 1P251-0250-XA 1630</p>	
<p>Operation 12/17</p> <p>DESCRIPTION: Finitura foro grande (2)</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPOVER: 23.75mm</p>	<p>MAXIMUM Z: 2.5mm</p> <p>MINIMUM Z: -17.6mm</p> <p>MAXIMUM SPINDLE SPEED: 3810rpm</p> <p>MAXIMUM FEEDRATE: 914.4mm/min</p> <p>CUTTING DISTANCE: 160.86mm</p> <p>RAPID DISTANCE: 245.18mm</p> <p>ESTIMATED CYCLE TIME: 16s (0.4%)</p> <p>COOLANT: Flood</p>	<p>T7 D7 L7</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 25mm</p> <p>LENGTH: 60mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: CoroMill 390 Finituraforogrande</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: R390-025A25-17L</p>	
<p>Operation 13/17</p> <p>DESCRIPTION: Finitura tasche laterali (3)</p> <p>STRATEGY: Adaptive 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>OPTIMAL LOAD: 3mm</p> <p>LOAD DEVIATION: 0.3mm</p>	<p>MAXIMUM Z: 5mm</p> <p>MINIMUM Z: -15mm</p> <p>MAXIMUM SPINDLE SPEED: 8000rpm</p> <p>MAXIMUM FEEDRATE: 2330mm/min</p> <p>CUTTING DISTANCE: 651.91mm</p> <p>RAPID DISTANCE: 248.32mm</p> <p>ESTIMATED CYCLE TIME: 20s (0.5%)</p> <p>COOLANT: Flood</p>	<p>T13 D13 L13</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4mm</p> <p>LENGTH: 30mm</p> <p>FLUTES: 3</p> <p>DESCRIPTION: CoroMill Plura FinituraTascheLaterali</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: R216.23-04050CAK11P 1620</p>	
<p>Operation 14/17</p> <p>DESCRIPTION: Finitura tasche laterali 2 (2)</p> <p>STRATEGY: Adaptive 2D</p> <p>WCS: #1</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>OPTIMAL LOAD: 3mm</p> <p>LOAD DEVIATION: 0.3mm</p>	<p>MAXIMUM Z: 5mm</p> <p>MINIMUM Z: -15mm</p> <p>MAXIMUM SPINDLE SPEED: 8000rpm</p> <p>MAXIMUM FEEDRATE: 2330mm/min</p> <p>CUTTING DISTANCE: 651.92mm</p> <p>RAPID DISTANCE: 248.32mm</p> <p>ESTIMATED CYCLE TIME: 20s (0.5%)</p> <p>COOLANT: Flood</p>	<p>T13 D13 L13</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4mm</p> <p>LENGTH: 30mm</p> <p>FLUTES: 3</p> <p>DESCRIPTION: CoroMill Plura FinituraTascheLaterali</p> <p>VENDOR: Sandvik</p> <p>PRODUCT: R216.23-04050CAK11P 1620</p>	

Operation 15/17 DESCRIPTION: Finitura pavimento tasche laterali (3) STRATEGY: Adaptive 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm OPTIMAL LOAD: 3mm LOAD DEVIATION: 0.3mm	MAXIMUM Z: 5mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 6120rpm MAXIMUM FEEDRATE: 497mm/min CUTTING DISTANCE: 1039.46mm RAPID DISTANCE: 233.45mm ESTIMATED CYCLE TIME: 2m:13s (3.5%) COOLANT: Flood	T12 D12 L12 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 1mm LENGTH: 30mm FLUTES: 4 DESCRIPTION: CoroMill Dura PavimentoTascheLaterali VENDOR: Sandvik PRODUCT: 1K334-0400-100-XC 1730	
Operation 16/17 DESCRIPTION: Finitura pavimento tasche laterali 2 (2) STRATEGY: Adaptive 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm OPTIMAL LOAD: 3mm LOAD DEVIATION: 0.3mm	MAXIMUM Z: 5mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 6120rpm MAXIMUM FEEDRATE: 497mm/min CUTTING DISTANCE: 1039.46mm RAPID DISTANCE: 233.45mm ESTIMATED CYCLE TIME: 2m:13s (3.5%) COOLANT: Flood	T12 D12 L12 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 1mm LENGTH: 30mm FLUTES: 4 DESCRIPTION: CoroMill Dura PavimentoTascheLaterali VENDOR: Sandvik PRODUCT: 1K334-0400-100-XC 1730	
Operation 17/17 DESCRIPTION: Raccordo nervatura (2) STRATEGY: Scallop WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 0.2mm	MAXIMUM Z: 15mm MINIMUM Z: -19.4mm MAXIMUM SPINDLE SPEED: 6120rpm MAXIMUM FEEDRATE: 497mm/min CUTTING DISTANCE: 1819.52mm RAPID DISTANCE: 376.91mm ESTIMATED CYCLE TIME: 3m:45s (5.9%) COOLANT: Flood	T12 D12 L12 TYPE: bullnose end mill DIAMETER: 4mm CORNER RADIUS: 1mm LENGTH: 30mm FLUTES: 4 DESCRIPTION: CoroMill Dura PavimentoTascheLaterali VENDOR: Sandvik PRODUCT: 1K334-0400-100-XC 1730	