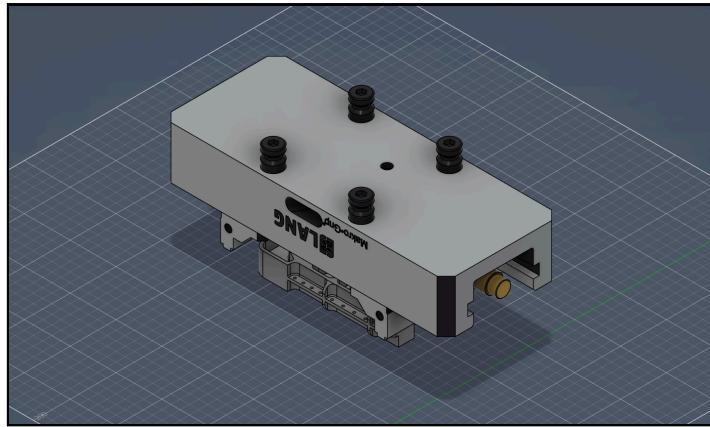


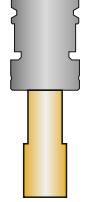
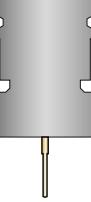
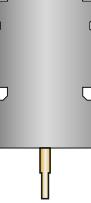
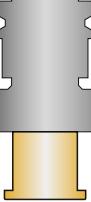
Setup Sheet for Program 1001

Job DESCRIPTION: AutoSetup 1

DOCUMENT PATH: X_TP02_FORI_EDIT_12100709 v1

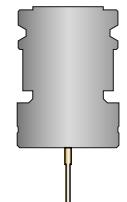
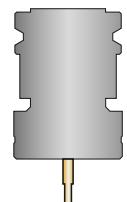
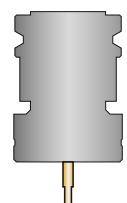
Setup	
<p>WCS: #0</p> <p>STOCK: DX: 160mm DY: 95mm DZ: 35mm</p> <p>PART: DX: 150mm DY: 84.87mm DZ: 25mm</p> <p>STOCK LOWER IN WCS #0: X: -80mm Y: -47.5mm Z: -35mm</p> <p>STOCK UPPER IN WCS #0: X: 80mm Y: 47.5mm Z: 0mm</p>	

Total	
NUMBER OF OPERATIONS: 14	
NUMBER OF TOOLS: 11	
TOOLS: T17000 T17006 T17013 T19000 T19006 T19007 T22003 T22011 T22012 T22013 T22014	
MAXIMUM Z: 6.05mm	
MINIMUM Z: -30.25mm	
MAXIMUM FEEDRATE: 2470mm/min	
MAXIMUM SPINDLE SPEED: 8000rpm	
CUTTING DISTANCE: 28336.27mm	
RAPID DISTANCE: 20302.77mm	
ESTIMATED CYCLE TIME: 44m:20s	

Tools	
T17000 D17000 L17000	<p>TYPE: flat end mill DIAMETER: 40mm LENGTH: 100mm FLUTES: 4 DESCRIPTION: CoroMill490 Sgrossatura VENDOR: Sandvik PRODUCT: 490-040A32-14H</p> <p>MINIMUM Z: -30.25mm MAXIMUM FEED: 2470mm/min MAXIMUM SPINDLE SPEED: 1880rpm CUTTING DISTANCE: 7196.44mm RAPID DISTANCE: 6651.85mm ESTIMATED CYCLE TIME: 4m:15s (9.6%)</p> <p>HOLDER: BT40 - B4C4-1000</p> 
T17006 D17006 L17006	<p>TYPE: drill DIAMETER: 2.5mm TIP ANGLE: 140° LENGTH: 38mm FLUTES: 2 DESCRIPTION: CoroDrill 862 Foripiccoli VENDOR: Sandvik PRODUCT: 862.1-2500-225A0-GM X2BL</p> <p>MINIMUM Z: -19.58mm MAXIMUM FEED: 113mm/min MAXIMUM SPINDLE SPEED: 4010rpm CUTTING DISTANCE: 602.7mm RAPID DISTANCE: 1138.43mm ESTIMATED CYCLE TIME: 5m:34s (12.5%)</p> <p>HOLDER: BT40 - B4C4-1000</p> 
T17013 D17013 L17013	<p>TYPE: flat end mill DIAMETER: 4mm LENGTH: 30mm FLUTES: 3 DESCRIPTION: CoroMill Plura FinituraTascheLaterali VENDOR: Sandvik PRODUCT: R216.23-04050CAK11P 1620</p> <p>MINIMUM Z: -16mm MAXIMUM FEED: 2330mm/min MAXIMUM SPINDLE SPEED: 8000rpm CUTTING DISTANCE: 2433.55mm RAPID DISTANCE: 998.24mm ESTIMATED CYCLE TIME: 1m:45s (4%)</p> <p>HOLDER: BT40 - B4C4-1000</p> 
T19000 D19000 L19000	<p>TYPE: face mill DIAMETER: 54.08mm CORNER RADIUS: 0.8mm LENGTH: 45mm FLUTES: 4 DESCRIPTION: Fresa CoroMill 345 per spianatura VENDOR: sandvik PRODUCT: 345-040Q22-13M</p> <p>MINIMUM Z: -5mm MAXIMUM FEED: 1600.002mm/min MAXIMUM SPINDLE SPEED: 1600rpm CUTTING DISTANCE: 4584.32mm RAPID DISTANCE: 352.82mm ESTIMATED CYCLE TIME: 2m:57s (6.7%)</p> <p>HOLDER: BT40 - B4C4-1000</p> 

T19006 D19006 L19006	MINIMUM Z: -30.25mm MAXIMUM FEED: 451mm/min MAXIMUM SPINDLE SPEED: 2230rpm CUTTING DISTANCE: 1499.2mm RAPID DISTANCE: 2279.51mm ESTIMATED CYCLE TIME: 3m:50s (8.6%)	HOLDER: BT40 - B4C4-1000	
T19007 D19007 L19007	MINIMUM Z: -30.25mm MAXIMUM FEED: 651mm/min MAXIMUM SPINDLE SPEED: 4070rpm CUTTING DISTANCE: 2266.24mm RAPID DISTANCE: 4150.67mm ESTIMATED CYCLE TIME: 5m:37s (12.7%)	HOLDER: BT40 - B4C4-1000	
T22003 D22003 L22003	MINIMUM Z: -16mm MAXIMUM FEED: 2170mm/min MAXIMUM SPINDLE SPEED: 2170rpm CUTTING DISTANCE: 7219.48mm RAPID DISTANCE: 2494.03mm ESTIMATED CYCLE TIME: 12m:54s (29.1%)		
T22011 D22011 L22011	MINIMUM Z: -16mm MAXIMUM FEED: 2106.67mm/min MAXIMUM SPINDLE SPEED: 7190rpm CUTTING DISTANCE: 1204.52mm RAPID DISTANCE: 1429.99mm ESTIMATED CYCLE TIME: 2m:1s (4.5%)		
T22012 D22012 L22012	MINIMUM Z: -30.1mm MAXIMUM FEED: 250mm/min MAXIMUM SPINDLE SPEED: 1393rpm CUTTING DISTANCE: 491.42mm RAPID DISTANCE: 34.12mm ESTIMATED CYCLE TIME: 1m:58s (4.4%)		
T22013 D22013 L22013	MINIMUM Z: -16mm MAXIMUM FEED: 1999.2mm/min MAXIMUM SPINDLE SPEED: 6000rpm CUTTING DISTANCE: 459.45mm RAPID DISTANCE: 710.18mm ESTIMATED CYCLE TIME: 31s (1.2%)		
T22014 D22014 L22014	MINIMUM Z: -16.29mm MAXIMUM FEED: 1900.001mm/min MAXIMUM SPINDLE SPEED: 8000rpm CUTTING DISTANCE: 378.96mm RAPID DISTANCE: 62.93mm ESTIMATED CYCLE TIME: 13s (0.5%)		

Operations			
Operation 1/14	T19000 D19000 L19000		
DESCRIPTION: 1 Face STRATEGY: Facing WCS: #0 TOLERANCE: 0.03mm MAXIMUM STEPDOWN: 1mm MAXIMUM STEPOVER: 36.74mm	MAXIMUM Z: 6.05mm MINIMUM Z: -5mm MAXIMUM SPINDLE SPEED: 1600rpm MAXIMUM FEEDRATE: 1600.002mm/min CUTTING DISTANCE: 4584.32mm RAPID DISTANCE: 352.82mm ESTIMATED CYCLE TIME: 2m:57s (6.7%) COOLANT: Flood	TYPE: face mill DIAMETER: 54.08mm CORNER RADIUS: 0.8mm LENGTH: 45mm FLUTES: 4 DESCRIPTION: Fresa CoroMill 345 per spianatura VENDOR: sandvik PRODUCT: 345-040Q22-13M	
Operation 2/14	T17000 D17000 L17000		
DESCRIPTION: 2 Adaptive Clearing STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.05mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 7.5mm OPTIMAL LOAD: 16mm LOAD DEVIATION: 1.6mm	MAXIMUM Z: 0.51mm MINIMUM Z: -30.25mm MAXIMUM SPINDLE SPEED: 1880rpm MAXIMUM FEEDRATE: 2470mm/min CUTTING DISTANCE: 7196.44mm RAPID DISTANCE: 6651.85mm ESTIMATED CYCLE TIME: 4m:15s (9.6%) COOLANT: Air	TYPE: flat end mill DIAMETER: 40mm LENGTH: 100mm FLUTES: 4 DESCRIPTION: CoroMill490 Sgrossatura VENDOR: Sandvik PRODUCT: 490-040A32-14H	

Operation 3/14 DESCRIPTION: 3 Adaptive Clearing STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.05mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 10.8mm OPTIMAL LOAD: 2.4mm LOAD DEVIATION: 0.24mm	MAXIMUM Z: 0.51mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 2170rpm MAXIMUM FEEDRATE: 2170mm/min CUTTING DISTANCE: 7219.48mm RAPID DISTANCE: 2494.03mm ESTIMATED CYCLE TIME: 12m:54s (29.1%) COOLANT: Flood	T22003 D22003 L22003 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.2mm LENGTH: 45mm FLUTES: 5 DESCRIPTION: Sgrossatura tasche 1 PRODUCT: 1K325-0800-XB 1730	
Operation 4/14 DESCRIPTION: 4 Adaptive Clearing STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.05mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 7.5mm OPTIMAL LOAD: 7.2mm LOAD DEVIATION: 0.72mm	MAXIMUM Z: 0.51mm MINIMUM Z: -30.25mm MAXIMUM SPINDLE SPEED: 4070rpm MAXIMUM FEEDRATE: 651mm/min CUTTING DISTANCE: 2266.24mm RAPID DISTANCE: 4150.67mm ESTIMATED CYCLE TIME: 5m:37s (12.7%) COOLANT: Flood	T19007 D19007 L19007 TYPE: flat end mill DIAMETER: 18mm LENGTH: 145mm FLUTES: 2 DESCRIPTION: Fresa CoroMill 390 per spallamenti VENDOR: sandvik PRODUCT: R390-018A16L-11L	
Operation 5/14 DESCRIPTION: 5 Adaptive Clearing STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.05mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 8.25mm OPTIMAL LOAD: 1.6mm LOAD DEVIATION: 0.16mm	MAXIMUM Z: 0.51mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 7190rpm MAXIMUM FEEDRATE: 2106.67mm/min CUTTING DISTANCE: 1204.52mm RAPID DISTANCE: 1429.99mm ESTIMATED CYCLE TIME: 2m:1s (4.5%) COOLANT: Flood	T22011 D22011 L22011 TYPE: flat end mill DIAMETER: 4mm LENGTH: 40mm FLUTES: 5 DESCRIPTION: Fresa per sgrossatura (tasca piccola) e per finitura totale tasche PRODUCT: 1K334-0400-050-XC 1730	
Operation 6/14 DESCRIPTION: 6 Drill STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM Z: 3.05mm MINIMUM Z: -19.58mm MAXIMUM SPINDLE SPEED: 4010rpm MAXIMUM FEEDRATE: 113mm/min CUTTING DISTANCE: 602.7mm RAPID DISTANCE: 1138.43mm ESTIMATED CYCLE TIME: 5m:34s (12.5%) COOLANT: Flood	T17006 D17006 L17006 TYPE: drill DIAMETER: 2.5mm TIP ANGLE: 140° LENGTH: 38mm FLUTES: 2 DESCRIPTION: CoroDrill 862 Foripiccoli VENDOR: Sandvik PRODUCT: 862.1-2500-225A0-GM X2BL	
Operation 7/14 DESCRIPTION: 7 Flat WCS: #0 TOLERANCE: 0.03mm STOCK TO LEAVE: 0.13mm/0mm MAXIMUM STEPOVER: 2.8mm	MAXIMUM Z: 0.51mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8000rpm MAXIMUM FEEDRATE: 2330mm/min CUTTING DISTANCE: 1195.79mm RAPID DISTANCE: 448.7mm ESTIMATED CYCLE TIME: 37s (1.4%) COOLANT: Flood	T17013 D17013 L17013 TYPE: flat end mill DIAMETER: 4mm LENGTH: 30mm FLUTES: 3 DESCRIPTION: CoroMill Plura FinituraTascheLaterali VENDOR: Sandvik PRODUCT: R216.23-04050CAK11P 1620	
Operation 8/14 DESCRIPTION: 8 2D Contour STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0mm STOCK TO LEAVE: 0mm/0.03mm MAXIMUM STEPDOWN: 9.9mm MAXIMUM STEPOVER: 3.8mm	MAXIMUM Z: 3.05mm MINIMUM Z: -15.97mm MAXIMUM SPINDLE SPEED: 8000rpm MAXIMUM FEEDRATE: 2330mm/min CUTTING DISTANCE: 1237.76mm RAPID DISTANCE: 549.54mm ESTIMATED CYCLE TIME: 1m:8s (2.6%) COOLANT: Flood	T17013 D17013 L17013 TYPE: flat end mill DIAMETER: 4mm LENGTH: 30mm FLUTES: 3 DESCRIPTION: CoroMill Plura FinituraTascheLaterali VENDOR: Sandvik PRODUCT: R216.23-04050CAK11P 1620	
Operation 9/14 DESCRIPTION: 9 Flat WCS: #0 TOLERANCE: 0.03mm STOCK TO LEAVE: 0.13mm/0mm MAXIMUM STEPOVER: 4.2mm	MAXIMUM Z: 0.51mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 6000rpm MAXIMUM FEEDRATE: 1999.2mm/min CUTTING DISTANCE: 303.39mm RAPID DISTANCE: 525.4mm ESTIMATED CYCLE TIME: 17s (0.6%) COOLANT: Flood	T22013 D22013 L22013 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 1mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: 54_finitura_fondo_tondo VENDOR: mitsubishi PRODUCT: MPMHVRBD0800R100	
Operation 10/14 DESCRIPTION: 10 2D Contour STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0mm STOCK TO LEAVE: 0mm/0.03mm MAXIMUM STEPOVER: 5.7mm	MAXIMUM Z: 3.05mm MINIMUM Z: -15.97mm MAXIMUM SPINDLE SPEED: 6000rpm MAXIMUM FEEDRATE: 1999.2mm/min CUTTING DISTANCE: 156.05mm RAPID DISTANCE: 184.78mm ESTIMATED CYCLE TIME: 14s (0.5%) COOLANT: Flood	T22013 D22013 L22013 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 1mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: 54_finitura_fondo_tondo VENDOR: mitsubishi PRODUCT: MPMHVRBD0800R100	

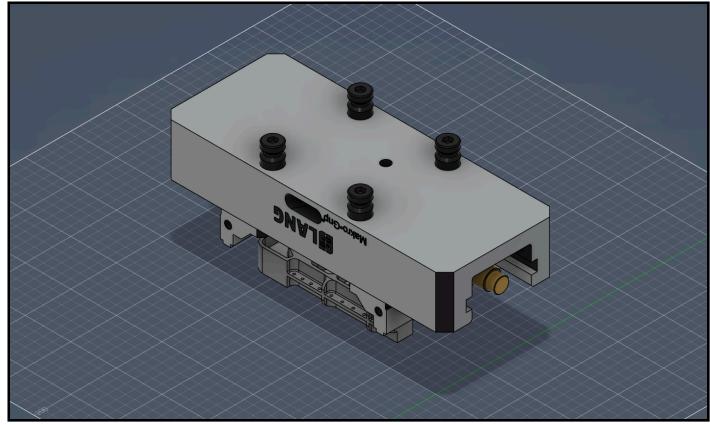
Operation 11/14 DESCRIPTION: 11 Bore STRATEGY: Bore WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM Z: 0.51mm MINIMUM Z: -30.1mm MAXIMUM SPINDLE SPEED: 1393rpm MAXIMUM FEEDRATE: 250mm/min CUTTING DISTANCE: 491.42mm RAPID DISTANCE: 34.12mm ESTIMATED CYCLE TIME: 1m:58s (4.4%) COOLANT: Flood	T22012 D22012 L22012 TYPE: flat end mill DIAMETER: 32mm LENGTH: 100mm FLUTES: 4 DESCRIPTION: fresa per elicoidale VENDOR: mitsubishi PRODUCT: AQXR324SA32S con inserto QOMT1651R-M2 con grado MP6130	
Operation 12/14 DESCRIPTION: 12 Scallop STRATEGY: Scallop WCS: #0 TOLERANCE: 0.03mm STOCK TO LEAVE: 0mm MAXIMUM STEPPOWER: 0.64mm	MAXIMUM Z: 0.51mm MINIMUM Z: -16.29mm MAXIMUM SPINDLE SPEED: 8000rpm MAXIMUM FEEDRATE: 1900.001mm/min CUTTING DISTANCE: 378.96mm RAPID DISTANCE: 62.93mm ESTIMATED CYCLE TIME: 13s (0.5%) COOLANT: Flood	T22014 D22014 L22014 TYPE: ball end mill DIAMETER: 8mm CORNER RADIUS: 4mm LENGTH: 20mm FLUTES: 4 DESCRIPTION: nervatura tonda VENDOR: mitsubishi PRODUCT: fresa a punta tonda VQ4SVBR04000	
Operation 13/14 DESCRIPTION: 13 Adaptive Clearing STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm/0mm MAXIMUM STEPDOWN: 16.5mm OPTIMAL LOAD: 4mm LOAD DEVIATION: 0.4mm	MAXIMUM Z: 0.51mm MINIMUM Z: -30.25mm MAXIMUM SPINDLE SPEED: 2230rpm MAXIMUM FEEDRATE: 451mm/min CUTTING DISTANCE: 523.83mm RAPID DISTANCE: 2210.2mm ESTIMATED CYCLE TIME: 1m:36s (3.6%) COOLANT: Flood	T19006 D19006 L19006 TYPE: flat end mill DIAMETER: 10mm LENGTH: 72mm FLUTES: 4 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-1000-050-XD 1730	
Operation 14/14 DESCRIPTION: 14 2D Contour STRATEGY: Contour 2D WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 22mm MAXIMUM STEPPOWER: 9.5mm	MAXIMUM Z: 3.05mm MINIMUM Z: -30.13mm MAXIMUM SPINDLE SPEED: 2230rpm MAXIMUM FEEDRATE: 451mm/min CUTTING DISTANCE: 975.37mm RAPID DISTANCE: 69.3mm ESTIMATED CYCLE TIME: 2m:13s (5%) COOLANT: Flood	T19006 D19006 L19006 TYPE: flat end mill DIAMETER: 10mm LENGTH: 72mm FLUTES: 4 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-1000-050-XD 1730	

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Setup Sheet for Program 1002

JOB DESCRIPTION: AutoSetup 2

DOCUMENT PATH: X_TP02_FORI_EDIT_12100709 v1

Setup	
<p>WCS: #0</p> <p>STOCK:</p> <ul style="list-style-type: none"> DX: 160mm DY: 95mm DZ: 35mm <p>PART:</p> <ul style="list-style-type: none"> DX: 150mm DY: 84.87mm DZ: 25mm <p>STOCK LOWER IN WCS #0:</p> <ul style="list-style-type: none"> X: -80mm Y: -47.5mm Z: -35mm <p>STOCK UPPER IN WCS #0:</p> <ul style="list-style-type: none"> X: 80mm Y: 47.5mm Z: 0mm 	

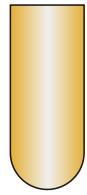
Total	
<p>NUMBER OF OPERATIONS: 8</p> <p>NUMBER OF TOOLS: 5</p> <p>TOOLS: T19000 T22003 T22011 T22013 T22014</p> <p>MAXIMUM Z: 6.05mm</p> <p>MINIMUM Z: -16.29mm</p> <p>MAXIMUM FEEDRATE: 2170mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8000rpm</p> <p>CUTTING DISTANCE: 14481.83mm</p> <p>RAPID DISTANCE: 6229.9mm</p> <p>ESTIMATED CYCLE TIME: 20m:23s</p>	

Tools	
T19000 D19000 L19000	<p>TYPE: face mill</p> <p>DIAMETER: 54.08mm</p> <p>CORNER RADIUS: 0.8mm</p> <p>LENGTH: 45mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: Fresa CoroMill 345 per spianatura</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 345-040Q22-13M</p>
T22003 D22003 L22003	<p>TYPE: bullnose end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 0.2mm</p> <p>LENGTH: 45mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Sgrossatura tasche 1</p> <p>PRODUCT: 1K325-0800-XB 1730</p>
T22011 D22011 L22011	<p>TYPE: flat end mill</p> <p>DIAMETER: 4mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa per sgrossatura (tasca piccola) e per finitura totale tasche</p> <p>PRODUCT: 1K334-0400-050-XC 1730</p>
T22013 D22013 L22013	<p>TYPE: bullnose end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: 54_finitura_fondo_tondo</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: MPMHVRBD0800R100</p>

T22014 D22014 L22014

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

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

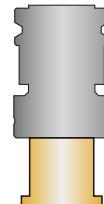
**Operations**

Operation 1/8

DESCRIPTION: 1 Face (2)
STRATEGY: Facing
WCS: #0
TOLERANCE: 0.03mm
MAXIMUM STEPDOWN: 1mm
MAXIMUM STEPOVER: 36.74mm

MAXIMUM Z: 6.05mm
MINIMUM Z: -5mm
MAXIMUM SPINDLE SPEED: 1600rpm
MAXIMUM FEEDRATE: 1600.002mm/min
CUTTING DISTANCE: 4584.32mm
RAPID DISTANCE: 352.82mm
ESTIMATED CYCLE TIME: 2m:57s (14.5%)
COOLANT: Flood

T19000 D19000 L19000
TYPE: face mill
DIAMETER: 54.08mm
CORNER RADIUS: 0.8mm
LENGTH: 45mm
FLUTES: 4
DESCRIPTION: Fresca CoroMill 345 per spianatura
VENDOR: sandvik
PRODUCT: [345-040Q22-13M](#)



Operation 2/8

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

MAXIMUM Z: 0.51mm
MINIMUM Z: -15.75mm
MAXIMUM SPINDLE SPEED: 2170rpm
MAXIMUM FEEDRATE: 2170mm/min
CUTTING DISTANCE: 6050.69mm
RAPID DISTANCE: 2935.78mm
ESTIMATED CYCLE TIME: 11m:0s (54%)
COOLANT: Flood

T22003 D22003 L22003
TYPE: bullnose end mill
DIAMETER: 8mm
CORNER RADIUS: 0.2mm
LENGTH: 45mm
FLUTES: 5
DESCRIPTION: Sgrossatura tasche 1
PRODUCT: [1K325-0800-XB 1730](#)



Operation 3/8

DESCRIPTION: 3 Adaptive Clearing (2)
STRATEGY: Adaptive
WCS: #0
TOLERANCE: 0.05mm
STOCK TO LEAVE: 0.25mm
MAXIMUM STEPDOWN: 8.25mm
OPTIMAL LOAD: 1.6mm
LOAD DEVIATION: 0.16mm

MAXIMUM Z: 0.51mm
MINIMUM Z: -15.75mm
MAXIMUM SPINDLE SPEED: 7190rpm
MAXIMUM FEEDRATE: 2106.67mm/min
CUTTING DISTANCE: 1216.14mm
RAPID DISTANCE: 1368.04mm
ESTIMATED CYCLE TIME: 2m:1s (9.9%)
COOLANT: Flood

T22011 D22011 L22011
TYPE: flat end mill
DIAMETER: 4mm
LENGTH: 40mm
FLUTES: 5
DESCRIPTION: Fresa per sgrossatura (tasca piccola) e per finitura totale tasche
PRODUCT: [1K334-0400-050-XC 1730](#)



Operation 4/8

DESCRIPTION: 4 Flat
WCS: #0
TOLERANCE: 0.03mm
STOCK TO LEAVE: 0.13mm/0mm
MAXIMUM STEPOVER: 2.8mm

MAXIMUM Z: 0.51mm
MINIMUM Z: -16mm
MAXIMUM SPINDLE SPEED: 7190rpm
MAXIMUM FEEDRATE: 2106.67mm/min
CUTTING DISTANCE: 1197.93mm
RAPID DISTANCE: 476.91mm
ESTIMATED CYCLE TIME: 41s (3.3%)
COOLANT: Flood

T22011 D22011 L22011
TYPE: flat end mill
DIAMETER: 4mm
LENGTH: 40mm
FLUTES: 5
DESCRIPTION: Fresa per sgrossatura (tasca piccola) e per finitura totale tasche
PRODUCT: [1K334-0400-050-XC 1730](#)



Operation 5/8

DESCRIPTION: 5 2D Contour
STRATEGY: Contour 2D
WCS: #0
TOLERANCE: 0mm
STOCK TO LEAVE: 0mm/0.03mm
MAXIMUM STEPOVER: 3.8mm

MAXIMUM Z: 3.05mm
MINIMUM Z: -15.97mm
MAXIMUM SPINDLE SPEED: 4510rpm
MAXIMUM FEEDRATE: 369.82mm/min
CUTTING DISTANCE: 622.17mm
RAPID DISTANCE: 405.32mm
ESTIMATED CYCLE TIME: 1m:48s (8.8%)
COOLANT: Flood

T22011 D22011 L22011
TYPE: flat end mill
DIAMETER: 4mm
LENGTH: 40mm
FLUTES: 5
DESCRIPTION: Fresa per sgrossatura (tasca piccola) e per finitura totale tasche
PRODUCT: [1K334-0400-050-XC 1730](#)



Operation 6/8

DESCRIPTION: 6 Flat
WCS: #0
TOLERANCE: 0.03mm
STOCK TO LEAVE: 0.13mm/0mm
MAXIMUM STEPOVER: 4.2mm

MAXIMUM Z: 0.51mm
MINIMUM Z: -16mm
MAXIMUM SPINDLE SPEED: 6000rpm
MAXIMUM FEEDRATE: 1999.2mm/min
CUTTING DISTANCE: 278.24mm
RAPID DISTANCE: 416.01mm
ESTIMATED CYCLE TIME: 14s (1.2%)
COOLANT: Flood

T22013 D22013 L22013
TYPE: bullnose end mill
DIAMETER: 8mm
CORNER RADIUS: 1mm
LENGTH: 50mm
FLUTES: 4
DESCRIPTION: 54_finitura_fondo_tondo
VENDOR: mitsubishi
PRODUCT: [MPMHVRBD0800R100](#)



Operation 7/8

DESCRIPTION: 7 2D Contour
STRATEGY: Contour 2D
WCS: #0
TOLERANCE: 0mm
STOCK TO LEAVE: 0mm/0.03mm
MAXIMUM STEPOVER: 5.7mm

MAXIMUM Z: 3.05mm
MINIMUM Z: -15.97mm
MAXIMUM SPINDLE SPEED: 6000rpm
MAXIMUM FEEDRATE: 1999.2mm/min
CUTTING DISTANCE: 156.05mm
RAPID DISTANCE: 212.5mm
ESTIMATED CYCLE TIME: 15s (1.2%)
COOLANT: Flood

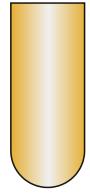
T22013 D22013 L22013
TYPE: bullnose end mill
DIAMETER: 8mm
CORNER RADIUS: 1mm
LENGTH: 50mm
FLUTES: 4
DESCRIPTION: 54_finitura_fondo_tondo
VENDOR: mitsubishi
PRODUCT: [MPMHVRBD0800R100](#)



Operation 8/8
DESCRIPTION: 8 Scallop
STRATEGY: Scallop
WCS: #0
TOLERANCE: 0.03mm
STOCK TO LEAVE: 0mm
MAXIMUM STEP OVER: 0.64mm

MAXIMUM Z: 0.51mm
MINIMUM Z: -16.29mm
MAXIMUM SPINDLE SPEED: 8000rpm
MAXIMUM FEEDRATE: 1900.001mm/min
CUTTING DISTANCE: 376.28mm
RAPID DISTANCE: 62.53mm
ESTIMATED CYCLE TIME: 13s (1.1%)
COOLANT: Flood

T22014 D22014 L22014
TYPE: ball end mill
DIAMETER: 8mm
CORNER RADIUS: 4mm
LENGTH: 20mm
FLUTES: 4
DESCRIPTION: nervatura tonda
VENDOR: mitsubishi
PRODUCT: [fresa a punta tonda VQ4SVBR04000](#)



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