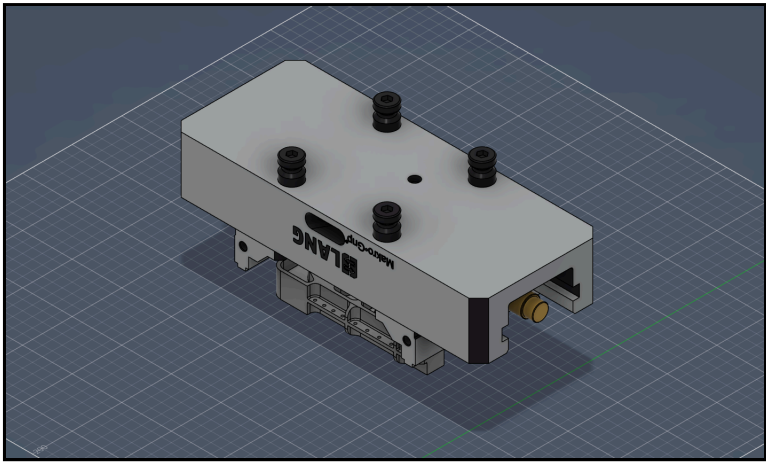


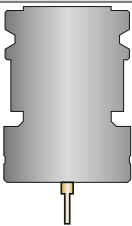
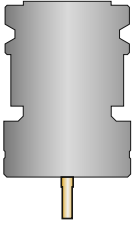
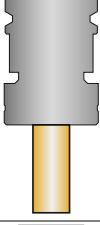
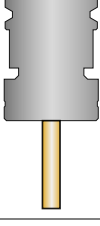
Setup Sheet for Program 1001

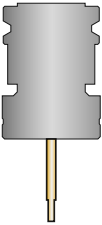
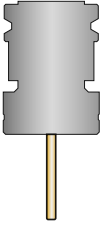
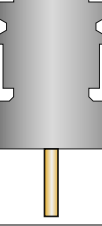
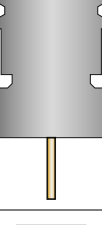
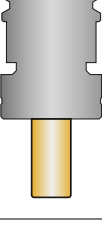
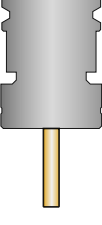
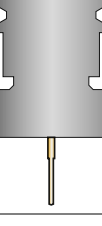

JOB DESCRIPTION: AutoSetup 1

DOCUMENT PATH: X_NC02-FORI_EDIT_12100709 v4

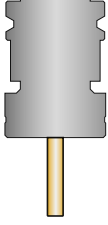
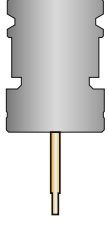
Setup	
<p>WCS: #0</p> <p>Stock:</p> <p>DX: 160mm</p> <p>DY: 95mm</p> <p>DZ: 35mm</p> <p>PART:</p> <p>DX: 150mm</p> <p>DY: 84.87mm</p> <p>DZ: 25mm</p> <p>Stock Lower in WCS #0:</p> <p>X: -80mm</p> <p>Y: -47.5mm</p> <p>Z: -35mm</p> <p>Stock Upper in WCS #0:</p> <p>X: 80mm</p> <p>Y: 47.5mm</p> <p>Z: 0mm</p>	

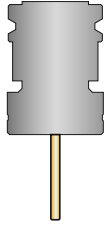
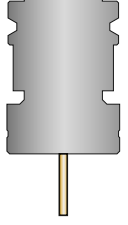
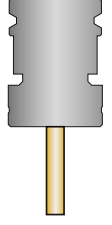
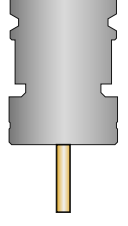
Total
<p>NUMBER OF OPERATIONS: 21</p> <p>NUMBER OF TOOLS: 12</p> <p>TOOLS: T17002 T17003 T17007 T17009 T19004 T19010 T20001 T20002 T20008 T20009 T22007 T22014</p> <p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -30.5mm</p> <p>MAXIMUM FEEDRATE: 4307.336mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>CUTTING DISTANCE: 28493.96mm</p> <p>RAPID DISTANCE: 19180.76mm</p> <p>ESTIMATED CYCLE TIME: 28m:53s</p>

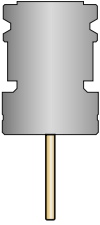
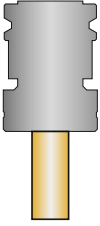
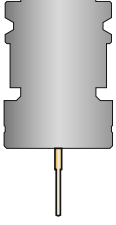
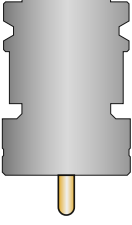
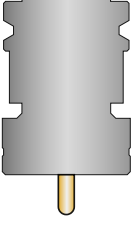
Tools			
T17002 D17002 L17002 TYPE: flat end mill DIAMETER: 2.5mm LENGTH: 21mm FLUTES: 2 DESCRIPTION: CoroMill Plura Tascapiccola VENDOR: Sandvik PRODUCT: 1P250-0250-XA 1630	MINIMUM Z: -15.75mm MAXIMUM FEED: 304.409mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 1886.88mm RAPID DISTANCE: 405.51mm ESTIMATED CYCLE TIME: 6m:17s (21.7%)	HOLDER: BT40 - B4C4-1000	
T17003 D17003 L17003 TYPE: flat end mill DIAMETER: 5mm LENGTH: 21mm FLUTES: 4 DESCRIPTION: CoroMill Dura Tasche VENDOR: Sandvik PRODUCT: 2P342-0500-PA 1730	MINIMUM Z: -15.75mm MAXIMUM FEED: 1863.488mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 3654.73mm RAPID DISTANCE: 1201.93mm ESTIMATED CYCLE TIME: 4m:20s (15%)	HOLDER: BT40 - B4C4-1000	
T17007 D17007 L17007 TYPE: flat end mill DIAMETER: 25mm LENGTH: 60mm FLUTES: 2 DESCRIPTION: CoroMill 390 Finituraforogrande VENDOR: Sandvik PRODUCT: R390-025A25-17L	MINIMUM Z: -30.5mm MAXIMUM FEED: 3055.775mm/min MAXIMUM SPINDLE SPEED: 7639rpm CUTTING DISTANCE: 1257.85mm RAPID DISTANCE: 59.5mm ESTIMATED CYCLE TIME: 26s (1.5%)	HOLDER: BT40 - B4C4-1000	
T17009 D17009 L17009 TYPE: flat end mill DIAMETER: 12mm LENGTH: 60mm FLUTES: 4 DESCRIPTION: CoroMill Dura Finituracontornatura VENDOR: Sandvik PRODUCT: 1K334-1200-XB 1730	MINIMUM Z: -30.2mm MAXIMUM FEED: 3110.4mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 528.63mm RAPID DISTANCE: 112.55mm ESTIMATED CYCLE TIME: 20s (1.2%)	HOLDER: BT40 - B4C4-1000	

T19004 D19004 L19004 TYPE: flat end mill DIAMETER: 4mm LENGTH: 54mm FLUTES: 5 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-0400-020-XC 1730	MINIMUM Z: -15.75mm MAXIMUM FEED: 1722.935mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 1897.4mm RAPID DISTANCE: 1615.37mm ESTIMATED CYCLE TIME: 1m:39s (5.7%)	HOLDER: BT40 - B4C4-1000	
T19010 D19010 L19010 TYPE: bullnose end mill DIAMETER: 6mm CORNER RADIUS: 1mm LENGTH: 57mm FLUTES: 5 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-0600-100-XD 1730	MINIMUM Z: -16mm MAXIMUM FEED: 2584.402mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 807.99mm RAPID DISTANCE: 1107.48mm ESTIMATED CYCLE TIME: 57s (3.3%)	HOLDER: BT40 - B4C4-1000	
T20001 D20001 L20001 TYPE: flat end mill DIAMETER: 8mm LENGTH: 40mm FLUTES: 4 DESCRIPTION: sgrossature tasche VENDOR: sandvik PRODUCT: 2P342-0800-PA 1730	MINIMUM Z: -16mm MAXIMUM FEED: 2756.695mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 2326.38mm RAPID DISTANCE: 1863.58mm ESTIMATED CYCLE TIME: 1m:28s (5.1%)	HOLDER: BT40 - B4C4-1000	
T20002 D20002 L20002 TYPE: flat end mill DIAMETER: 4.5mm LENGTH: 35mm FLUTES: 4 DESCRIPTION: SGROSSATURA TASCHE PICCOLE VENDOR: SANDVIK PRODUCT: 1P240-0450-XA 1630	MINIMUM Z: -16mm MAXIMUM FEED: 1550.641mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 1060.68mm RAPID DISTANCE: 663.72mm ESTIMATED CYCLE TIME: 1m:19s (4.6%)	HOLDER: BT40 - B4C4-1000	
T20008 D20008 L20008 TYPE: face mill DIAMETER: 25mm CORNER RADIUS: 1.6mm LENGTH: 50mm FLUTES: 2 DESCRIPTION: SPALLAMENTO VENDOR: SANDVIK PRODUCT: R390-025A25-17L	MINIMUM Z: -5mm MAXIMUM FEED: 3055.775mm/min MAXIMUM SPINDLE SPEED: 7639rpm CUTTING DISTANCE: 2316.34mm RAPID DISTANCE: 54.75mm ESTIMATED CYCLE TIME: 1m:1s (3.5%)	HOLDER: BT40 - B4C4-1000	
T20009 D20009 L20009 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.5mm LENGTH: 50mm FLUTES: 5 DESCRIPTION: FORO GRANDE VENDOR: SANVIK PRODUCT: 1K335-1000-050-XD 1730	MINIMUM Z: -30.2mm MAXIMUM FEED: 4307.336mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 10853.89mm RAPID DISTANCE: 10127.33mm ESTIMATED CYCLE TIME: 4m:39s (16.1%)	HOLDER: BT40 - B4C4-1000	
T22007 D22007 L22007 TYPE: drill DIAMETER: 2.5mm TIP ANGLE: 140° LENGTH: 40mm FLUTES: 2 DESCRIPTION: Punta per fori piccoli PRODUCT: 862.1-2500-225A0-GM X2BL	MINIMUM Z: -20.91mm MAXIMUM FEED: 465.75mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 627.3mm RAPID DISTANCE: 1311.37mm ESTIMATED CYCLE TIME: 1m:37s (5.6%)	HOLDER: BT40 - B4C4-1000	
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: -15.82mm MAXIMUM FEED: 1900mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 1275.89mm RAPID DISTANCE: 657.67mm ESTIMATED CYCLE TIME: 1m:6s (3.8%)	HOLDER: BT40 - B4C4-1000	

Operations

<p>Operation 1/21</p> <p>DESCRIPTION: Roughing</p> <p>STRATEGY: Facing</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>MAXIMUM STEPDOWN: 15.7mm</p> <p>MAXIMUM STEPOVER: 18.75mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -4.75mm</p> <p>MAXIMUM SPINDLE SPEED: 7639rpm</p> <p>MAXIMUM FEEDRATE: 3055.775mm/min</p> <p>CUTTING DISTANCE: 1253.14mm</p> <p>RAPID DISTANCE: 27.25mm</p> <p>ESTIMATED CYCLE TIME: 26s (1.5%)</p> <p>COOLANT: Flood</p>	<p>T20008 D20008 L20008</p> <p>TYPE: face mill</p> <p>DIAMETER: 25mm</p> <p>CORNER RADIUS: 1.6mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: SPALLAMENTO</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: R390-025A25-17L</p>	
<p>Operation 2/21</p> <p>DESCRIPTION: Finishing</p> <p>STRATEGY: Facing</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>MAXIMUM STEPOVER: 22.5mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -5mm</p> <p>MAXIMUM SPINDLE SPEED: 7639rpm</p> <p>MAXIMUM FEEDRATE: 2896.62mm/min</p> <p>CUTTING DISTANCE: 1063.2mm</p> <p>RAPID DISTANCE: 27.5mm</p> <p>ESTIMATED CYCLE TIME: 35s (2%)</p> <p>COOLANT: Flood</p>	<p>T20008 D20008 L20008</p> <p>TYPE: face mill</p> <p>DIAMETER: 25mm</p> <p>CORNER RADIUS: 1.6mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: SPALLAMENTO</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: R390-025A25-17L</p>	
<p>Operation 3/21</p> <p>DESCRIPTION: Roughing</p> <p>STRATEGY: Adaptive</p> <p>WCS: #0</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.25mm</p> <p>MAXIMUM STEPDOWN: 5.15mm</p> <p>OPTIMAL LOAD: 9.5mm</p> <p>LOAD DEVIATION: 0.25mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -30.2mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 4307.336mm/min</p> <p>CUTTING DISTANCE: 10853.89mm</p> <p>RAPID DISTANCE: 10127.33mm</p> <p>ESTIMATED CYCLE TIME: 4m:39s (16.1%)</p> <p>COOLANT: Flood</p>	<p>T20009 D20009 L20009</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 10mm</p> <p>CORNER RADIUS: 0.5mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: FORO GRANDE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1K335-1000-050-XD 1730</p>	
<p>Operation 4/21</p> <p>DESCRIPTION: Roughing1</p> <p>STRATEGY: Adaptive</p> <p>WCS: #0</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.25mm</p> <p>MAXIMUM STEPDOWN: 5.38mm</p> <p>OPTIMAL LOAD: 7.6mm</p> <p>LOAD DEVIATION: 0.2mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -15.75mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 2756.695mm/min</p> <p>CUTTING DISTANCE: 1757.83mm</p> <p>RAPID DISTANCE: 1423.61mm</p> <p>ESTIMATED CYCLE TIME: 57s (3.3%)</p> <p>COOLANT: Flood</p>	<p>T20001 D20001 L20001</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 8mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: sgrossature tasche</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 2P342-0800-PA 1730</p>	
<p>Operation 5/21</p> <p>DESCRIPTION: Roughing2</p> <p>STRATEGY: Adaptive</p> <p>WCS: #0</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.25mm</p> <p>MAXIMUM STEPDOWN: 4.95mm</p> <p>OPTIMAL LOAD: 1.13mm</p> <p>LOAD DEVIATION: 0.11mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -15.75mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1863.488mm/min</p> <p>CUTTING DISTANCE: 3654.73mm</p> <p>RAPID DISTANCE: 1201.93mm</p> <p>ESTIMATED CYCLE TIME: 4m:20s (15%)</p> <p>COOLANT: Flood</p>	<p>T17003 D17003 L17003</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>Operation 6/21</p> <p>DESCRIPTION: Roughing3</p> <p>STRATEGY: Adaptive</p> <p>WCS: #0</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.25mm</p> <p>MAXIMUM STEPDOWN: 0.74mm</p> <p>OPTIMAL LOAD: 3.8mm</p> <p>LOAD DEVIATION: 0.1mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -15.75mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1722.935mm/min</p> <p>CUTTING DISTANCE: 1897.4mm</p> <p>RAPID DISTANCE: 1615.37mm</p> <p>ESTIMATED CYCLE TIME: 1m:39s (5.7%)</p> <p>COOLANT: Flood</p>	<p>T19004 D19004 L19004</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4mm</p> <p>LENGTH: 54mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 1K335-0400-020-XC 1730</p>	
<p>Operation 7/21</p> <p>DESCRIPTION: Roughing4</p> <p>STRATEGY: Adaptive</p> <p>WCS: #0</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0.25mm</p> <p>MAXIMUM STEPDOWN: 5mm</p> <p>OPTIMAL LOAD: 0.09mm</p> <p>LOAD DEVIATION: 0.01mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -15.75mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 304.409mm/min</p> <p>CUTTING DISTANCE: 1886.88mm</p> <p>RAPID DISTANCE: 405.51mm</p> <p>ESTIMATED CYCLE TIME: 6m:17s (21.7%)</p> <p>COOLANT: Flood</p>	<p>T17002 D17002 L17002</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 8/21</p> <p>DESCRIPTION: Flat</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0.27mm/0mm</p> <p>MAXIMUM STEPOVER: 5.6mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 2370.136mm/min</p> <p>CUTTING DISTANCE: 292.12mm</p> <p>RAPID DISTANCE: 251.5mm</p> <p>ESTIMATED CYCLE TIME: 12s (0.7%)</p> <p>COOLANT: Flood</p>	<p>T20001 D20001 L20001</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 8mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: sgrossature tasche</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 2P342-0800-PA 1730</p>	

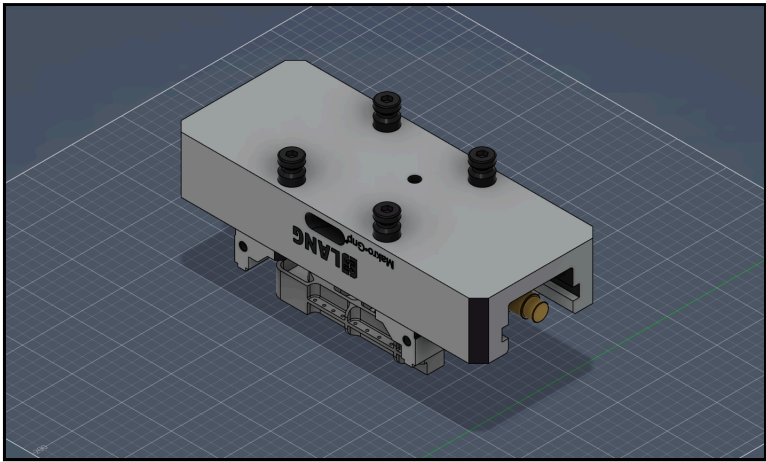
<p>Operation 9/21</p> <p>DESCRIPTION: Flat1</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0.27mm/0mm</p> <p>MAXIMUM STEPOVER: 2.8mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 2584.402mm/min</p> <p>CUTTING DISTANCE: 332.8mm</p> <p>RAPID DISTANCE: 655.39mm</p> <p>ESTIMATED CYCLE TIME: 19s (1.1%)</p> <p>COOLANT: Flood</p>	<p>T19010 D19010 L19010</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 6mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 57mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 1K335-0600-100-XD 1730</p>	
<p>Operation 10/21</p> <p>DESCRIPTION: Flat2</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0.27mm/0mm</p> <p>MAXIMUM STEPOVER: 3.15mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1550.641mm/min</p> <p>CUTTING DISTANCE: 462.08mm</p> <p>RAPID DISTANCE: 407.79mm</p> <p>ESTIMATED CYCLE TIME: 24s (1.4%)</p> <p>COOLANT: Flood</p>	<p>T20002 D20002 L20002</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4.5mm</p> <p>LENGTH: 35mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: SGROSSATURA TASCHE PICCOLE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1P240-0450-XA 1630</p>	
<p>Operation 11/21</p> <p>DESCRIPTION: Wall</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 8.73mm</p> <p>MAXIMUM STEPOVER: 4.28mm</p>	<p>MAXIMUM Z: 11.9mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 808.957mm/min</p> <p>CUTTING DISTANCE: 331.93mm</p> <p>RAPID DISTANCE: 62.19mm</p> <p>ESTIMATED CYCLE TIME: 28s (1.6%)</p> <p>COOLANT: Flood</p>	<p>T20002 D20002 L20002</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4.5mm</p> <p>LENGTH: 35mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: SGROSSATURA TASCHE PICCOLE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1P240-0450-XA 1630</p>	
<p>Operation 12/21</p> <p>DESCRIPTION: Wall1</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 8.73mm</p> <p>MAXIMUM STEPOVER: 4.28mm</p>	<p>MAXIMUM Z: 11.9mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 808.957mm/min</p> <p>CUTTING DISTANCE: 266.66mm</p> <p>RAPID DISTANCE: 193.74mm</p> <p>ESTIMATED CYCLE TIME: 27s (1.6%)</p> <p>COOLANT: Flood</p>	<p>T20002 D20002 L20002</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4.5mm</p> <p>LENGTH: 35mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: SGROSSATURA TASCHE PICCOLE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1P240-0450-XA 1630</p>	
<p>Operation 13/21</p> <p>DESCRIPTION: Wall2</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 26mm</p> <p>MAXIMUM STEPOVER: 11.4mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -30mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 3110.4mm/min</p> <p>CUTTING DISTANCE: 45.46mm</p> <p>RAPID DISTANCE: 55.55mm</p> <p>ESTIMATED CYCLE TIME: 6s (0.3%)</p> <p>COOLANT: Flood</p>	<p>T17009 D17009 L17009</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 14/21</p> <p>DESCRIPTION: Wall3</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 26mm</p> <p>MAXIMUM STEPOVER: 11.4mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -30.2mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 3110.4mm/min</p> <p>CUTTING DISTANCE: 483.17mm</p> <p>RAPID DISTANCE: 57mm</p> <p>ESTIMATED CYCLE TIME: 14s (0.8%)</p> <p>COOLANT: Flood</p>	<p>T17009 D17009 L17009</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 15/21</p> <p>DESCRIPTION: Wall4</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 17.5mm</p> <p>MAXIMUM STEPOVER: 7.6mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1620mm/min</p> <p>CUTTING DISTANCE: 276.42mm</p> <p>RAPID DISTANCE: 188.46mm</p> <p>ESTIMATED CYCLE TIME: 19s (1.1%)</p> <p>COOLANT: Flood</p>	<p>T20001 D20001 L20001</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 8mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: sgrossature tasche</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 2P342-0800-PA 1730</p>	
<p>Operation 16/21</p> <p>DESCRIPTION: Wall5</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 4.87mm</p> <p>MAXIMUM STEPOVER: 3.8mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1525.299mm/min</p> <p>CUTTING DISTANCE: 165.57mm</p> <p>RAPID DISTANCE: 134.29mm</p> <p>ESTIMATED CYCLE TIME: 13s (0.7%)</p> <p>COOLANT: Flood</p>	<p>T19010 D19010 L19010</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 6mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 57mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 1K335-0600-100-XD 1730</p>	

<p>Operation 17/21</p> <p>DESCRIPTION: Wall6</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 4.87mm</p> <p>MAXIMUM STEPOVER: 3.8mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1525.299mm/min</p> <p>CUTTING DISTANCE: 309.62mm</p> <p>RAPID DISTANCE: 317.81mm</p> <p>ESTIMATED CYCLE TIME: 25s (1.5%)</p> <p>COOLANT: Flood</p>	<p>T19010 D19010 L19010</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 6mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 57mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 1K335-0600-100-XD 1730</p>	
<p>Operation 18/21</p> <p>DESCRIPTION: Holemaking</p> <p>STRATEGY: Bore</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -30.5mm</p> <p>MAXIMUM SPINDLE SPEED: 7639rpm</p> <p>MAXIMUM FEEDRATE: 3055.775mm/min</p> <p>CUTTING DISTANCE: 1257.85mm</p> <p>RAPID DISTANCE: 59.5mm</p> <p>ESTIMATED CYCLE TIME: 26s (1.5%)</p> <p>COOLANT: Flood</p>	<p>T17007 D17007 L17007</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 19/21</p> <p>DESCRIPTION: Holemaking1</p> <p>STRATEGY: Drilling</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -20.91mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 465.75mm/min</p> <p>CUTTING DISTANCE: 627.3mm</p> <p>RAPID DISTANCE: 1311.37mm</p> <p>ESTIMATED CYCLE TIME: 1m:37s (5.6%)</p> <p>COOLANT: Flood</p>	<p>T22007 D22007 L22007</p> <p>TYPE: drill</p> <p>DIAMETER: 2.5mm</p> <p>TIP ANGLE: 140°</p> <p>LENGTH: 40mm</p> <p>FLUTES: 2</p> <p>DESCRIPTION: Punta per fori piccoli</p> <p>PRODUCT: 862.1-2500-225A0-GM X2BL</p>	
<p>Operation 20/21</p> <p>DESCRIPTION: Freeform</p> <p>STRATEGY: Contour</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 0.56mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -15.82mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1900mm/min</p> <p>CUTTING DISTANCE: 853.68mm</p> <p>RAPID DISTANCE: 557.9mm</p> <p>ESTIMATED CYCLE TIME: 45s (2.6%)</p> <p>COOLANT: Flood</p>	<p>T22014 D22014 L22014</p> <p>TYPE: ball end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 4mm</p> <p>LENGTH: 20mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: nervatura tonda</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: fresa a punta tonda VQ4SVBR04000</p>	
<p>Operation 21/21</p> <p>DESCRIPTION: Freeform1</p> <p>STRATEGY: Scallop</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPOVER: 0.28mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -7.08mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1900mm/min</p> <p>CUTTING DISTANCE: 422.21mm</p> <p>RAPID DISTANCE: 99.77mm</p> <p>ESTIMATED CYCLE TIME: 21s (1.2%)</p> <p>COOLANT: Flood</p>	<p>T22014 D22014 L22014</p> <p>TYPE: ball end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 4mm</p> <p>LENGTH: 20mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: nervatura tonda</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: fresa a punta tonda VQ4SVBR04000</p>	

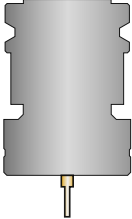
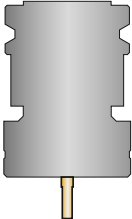
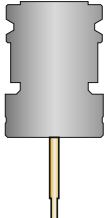
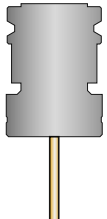
Setup Sheet for Program 1002

JOB DESCRIPTION: AutoSetup 2

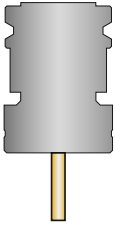
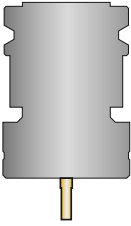
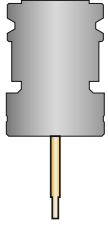
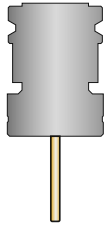
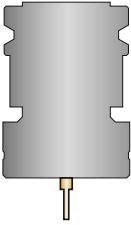
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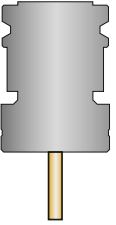
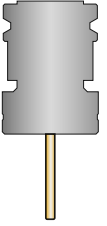
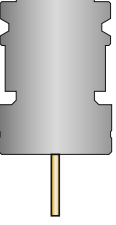
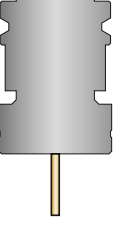
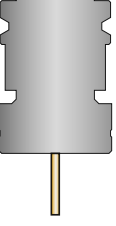
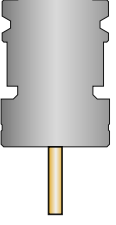
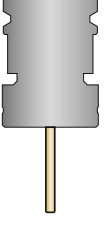
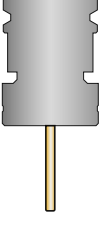
Setup	
<p>WCS: #0</p> <p>Stock: DX: 160mm DY: 95mm DZ: 35mm</p> <p>PART: DX: 150mm DY: 84.87mm DZ: 25mm</p> <p>Stock Lower in WCS #0: X: -80mm Y: -47.5mm Z: -35mm</p> <p>Stock Upper in WCS #0: X: 80mm Y: 47.5mm Z: 0mm</p>	

Total
<p>NUMBER OF OPERATIONS: 16</p> <p>NUMBER OF TOOLS: 7</p> <p>TOOLS: T17002 T17003 T19004 T19010 T20001 T20002 T22014</p> <p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM FEEDRATE: 2756.695mm/min</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>CUTTING DISTANCE: 26547.45mm</p> <p>RAPID DISTANCE: 13970.18mm</p> <p>ESTIMATED CYCLE TIME: 30m:40s</p>

Tools			
T17002 D17002 L17002 TYPE: flat end mill DIAMETER: 2.5mm LENGTH: 21mm FLUTES: 2 DESCRIPTION: CoroMill Plura Tascapiccola VENDOR: Sandvik PRODUCT: 1P250-0250-XA 1630		MINIMUM Z: -15.75mm MAXIMUM FEED: 304.409mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 2464.1mm RAPID DISTANCE: 662.68mm ESTIMATED CYCLE TIME: 8m:14s (26.8%)	HOLDER: BT40 - B4C4-1000 
T17003 D17003 L17003 TYPE: flat end mill DIAMETER: 5mm LENGTH: 21mm FLUTES: 4 DESCRIPTION: CoroMill Dura Tasche VENDOR: Sandvik PRODUCT: 2P342-0500-PA 1730		MINIMUM Z: -15.75mm MAXIMUM FEED: 1863.488mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 5366.8mm RAPID DISTANCE: 1635.91mm ESTIMATED CYCLE TIME: 7m:31s (24.5%)	HOLDER: BT40 - B4C4-1000 
T19004 D19004 L19004 TYPE: flat end mill DIAMETER: 4mm LENGTH: 54mm FLUTES: 5 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-0400-020-XC 1730		MINIMUM Z: -15.75mm MAXIMUM FEED: 1722.935mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 1892.61mm RAPID DISTANCE: 1567.63mm ESTIMATED CYCLE TIME: 1m:37s (5.3%)	HOLDER: BT40 - B4C4-1000 
T19010 D19010 L19010 TYPE: bullnose end mill DIAMETER: 6mm CORNER RADIUS: 1mm LENGTH: 57mm FLUTES: 5 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-0600-100-XD 1730		MINIMUM Z: -16mm MAXIMUM FEED: 2584.402mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 1079.78mm RAPID DISTANCE: 1577.58mm ESTIMATED CYCLE TIME: 1m:12s (3.9%)	HOLDER: BT40 - B4C4-1000 

T20001 D20001 L20001 TYPE: flat end mill DIAMETER: 8mm LENGTH: 40mm FLUTES: 4 DESCRIPTION: sgrossature tasche VENDOR: sandvik PRODUCT: 2P342-0800-PA 1730	MINIMUM Z: -16mm MAXIMUM FEED: 2756.695mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 13411.61mm RAPID DISTANCE: 7281.46mm ESTIMATED CYCLE TIME: 6m:58s (22.7%)	HOLDER: BT40 - B4C4-1000 
T20002 D20002 L20002 TYPE: flat end mill DIAMETER: 4.5mm LENGTH: 35mm FLUTES: 4 DESCRIPTION: SGROSSATURA TASCHE PICCOLE VENDOR: SANDVIK PRODUCT: 1P240-0450-XA 1630	MINIMUM Z: -16mm MAXIMUM FEED: 1550.641mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 1061.95mm RAPID DISTANCE: 588.42mm ESTIMATED CYCLE TIME: 1m:19s (4.3%)	HOLDER: BT40 - B4C4-1000 
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: -15.82mm MAXIMUM FEED: 1900mm/min MAXIMUM SPINDLE SPEED: 8100rpm CUTTING DISTANCE: 1270.6mm RAPID DISTANCE: 656.51mm ESTIMATED CYCLE TIME: 1m:5s (3.6%)	HOLDER: BT40 - B4C4-1000 

Operations			
Operation 1/16 DESCRIPTION: Roughing 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 Z: 15mm MINIMUM Z: -16mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 2756.695mm/min CUTTING DISTANCE: 11499mm RAPID DISTANCE: 6647.99mm ESTIMATED CYCLE TIME: 5m:49s (19%) COOLANT: Flood	T20001 D20001 L20001 TYPE: flat end mill DIAMETER: 8mm LENGTH: 40mm FLUTES: 4 DESCRIPTION: sgrossature tasche VENDOR: sandvik PRODUCT: 2P342-0800-PA 1730	
Operation 2/16 DESCRIPTION: Roughing1 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 4.95mm OPTIMAL LOAD: 1.13mm LOAD DEVIATION: 0.11mm	MAXIMUM Z: 15mm MINIMUM Z: -15.75mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1863.488mm/min CUTTING DISTANCE: 5366.8mm RAPID DISTANCE: 1635.91mm ESTIMATED CYCLE TIME: 7m:31s (24.5%) COOLANT: Flood	T17003 D17003 L17003 TYPE: flat end mill DIAMETER: 5mm LENGTH: 21mm FLUTES: 4 DESCRIPTION: CoroMill Dura Tasche VENDOR: Sandvik PRODUCT: 2P342-0500-PA 1730	
Operation 3/16 DESCRIPTION: Roughing2 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.74mm OPTIMAL LOAD: 3.8mm LOAD DEVIATION: 0.1mm	MAXIMUM Z: 15mm MINIMUM Z: -15.75mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 1722.935mm/min CUTTING DISTANCE: 1892.61mm RAPID DISTANCE: 1567.63mm ESTIMATED CYCLE TIME: 1m:37s (5.3%) COOLANT: Flood	T19004 D19004 L19004 TYPE: flat end mill DIAMETER: 4mm LENGTH: 54mm FLUTES: 5 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-0400-020-XC 1730	
Operation 4/16 DESCRIPTION: Roughing3 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 0.67mm OPTIMAL LOAD: 5mm LOAD DEVIATION: 0.5mm	MAXIMUM Z: 15mm MINIMUM Z: -8.75mm MAXIMUM SPINDLE SPEED: 7945rpm MAXIMUM FEEDRATE: 1679.133mm/min CUTTING DISTANCE: 259.85mm RAPID DISTANCE: 587.37mm ESTIMATED CYCLE TIME: 16s (0.9%) COOLANT: Flood	T19010 D19010 L19010 TYPE: bullnose end mill DIAMETER: 6mm CORNER RADIUS: 1mm LENGTH: 57mm FLUTES: 5 DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale VENDOR: sandvik PRODUCT: 1K335-0600-100-XD 1730	
Operation 5/16 DESCRIPTION: Roughing4 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.25mm MAXIMUM STEPDOWN: 5mm OPTIMAL LOAD: 0.09mm LOAD DEVIATION: 0.01mm	MAXIMUM Z: 15mm MINIMUM Z: -15.75mm MAXIMUM SPINDLE SPEED: 8100rpm MAXIMUM FEEDRATE: 304.409mm/min CUTTING DISTANCE: 2464.1mm RAPID DISTANCE: 662.68mm ESTIMATED CYCLE TIME: 8m:14s (26.8%) COOLANT: Flood	T17002 D17002 L17002 TYPE: flat end mill DIAMETER: 2.5mm LENGTH: 21mm FLUTES: 2 DESCRIPTION: CoroMill Plura Tascapiccola VENDOR: Sandvik PRODUCT: 1P250-0250-XA 1630	

<p>Operation 6/16</p> <p>DESCRIPTION: Flat</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0.27mm/0mm</p> <p>MAXIMUM STEPOVER: 5.6mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 2370.136mm/min</p> <p>CUTTING DISTANCE: 1636.19mm</p> <p>RAPID DISTANCE: 389.74mm</p> <p>ESTIMATED CYCLE TIME: 49s (2.7%)</p> <p>COOLANT: Flood</p>	<p>T20001 D20001 L20001</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 8mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: sgrossature tasche</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 2P342-0800-PA 1730</p>	
<p>Operation 7/16</p> <p>DESCRIPTION: Flat1</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0.27mm/0mm</p> <p>MAXIMUM STEPOVER: 2.8mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 2584.402mm/min</p> <p>CUTTING DISTANCE: 344.74mm</p> <p>RAPID DISTANCE: 586.91mm</p> <p>ESTIMATED CYCLE TIME: 18s (1%)</p> <p>COOLANT: Flood</p>	<p>T19010 D19010 L19010</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 6mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 57mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 1K335-0600-100-XD 1730</p>	
<p>Operation 8/16</p> <p>DESCRIPTION: Flat2</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0.27mm/0mm</p> <p>MAXIMUM STEPOVER: 3.15mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1550.641mm/min</p> <p>CUTTING DISTANCE: 463.35mm</p> <p>RAPID DISTANCE: 349.39mm</p> <p>ESTIMATED CYCLE TIME: 23s (1.3%)</p> <p>COOLANT: Flood</p>	<p>T20002 D20002 L20002</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4.5mm</p> <p>LENGTH: 35mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: SGROSSATURA TASCHE PICCOLE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1P240-0450-XA 1630</p>	
<p>Operation 9/16</p> <p>DESCRIPTION: Wall</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 8.73mm</p> <p>MAXIMUM STEPOVER: 4.28mm</p>	<p>MAXIMUM Z: 11.9mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 808.957mm/min</p> <p>CUTTING DISTANCE: 331.93mm</p> <p>RAPID DISTANCE: 62.19mm</p> <p>ESTIMATED CYCLE TIME: 28s (1.5%)</p> <p>COOLANT: Flood</p>	<p>T20002 D20002 L20002</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4.5mm</p> <p>LENGTH: 35mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: SGROSSATURA TASCHE PICCOLE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1P240-0450-XA 1630</p>	
<p>Operation 10/16</p> <p>DESCRIPTION: Wall1</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 8.73mm</p> <p>MAXIMUM STEPOVER: 4.28mm</p>	<p>MAXIMUM Z: 11.9mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 808.957mm/min</p> <p>CUTTING DISTANCE: 266.66mm</p> <p>RAPID DISTANCE: 176.84mm</p> <p>ESTIMATED CYCLE TIME: 27s (1.5%)</p> <p>COOLANT: Flood</p>	<p>T20002 D20002 L20002</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 4.5mm</p> <p>LENGTH: 35mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: SGROSSATURA TASCHE PICCOLE</p> <p>VENDOR: SANDVIK</p> <p>PRODUCT: 1P240-0450-XA 1630</p>	
<p>Operation 11/16</p> <p>DESCRIPTION: Wall2</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 17.5mm</p> <p>MAXIMUM STEPOVER: 7.6mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1620mm/min</p> <p>CUTTING DISTANCE: 276.42mm</p> <p>RAPID DISTANCE: 243.73mm</p> <p>ESTIMATED CYCLE TIME: 20s (1.1%)</p> <p>COOLANT: Flood</p>	<p>T20001 D20001 L20001</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 8mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: sgrossature tasche</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 2P342-0800-PA 1730</p>	
<p>Operation 12/16</p> <p>DESCRIPTION: Wall3</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 4.87mm</p> <p>MAXIMUM STEPOVER: 3.8mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1525.299mm/min</p> <p>CUTTING DISTANCE: 165.57mm</p> <p>RAPID DISTANCE: 134.29mm</p> <p>ESTIMATED CYCLE TIME: 13s (0.7%)</p> <p>COOLANT: Flood</p>	<p>T19010 D19010 L19010</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 6mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 57mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 1K335-0600-100-XD 1730</p>	
<p>Operation 13/16</p> <p>DESCRIPTION: Wall4</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 4.87mm</p> <p>MAXIMUM STEPOVER: 3.8mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1525.299mm/min</p> <p>CUTTING DISTANCE: 191.1mm</p> <p>RAPID DISTANCE: 151.32mm</p> <p>ESTIMATED CYCLE TIME: 14s (0.8%)</p> <p>COOLANT: Flood</p>	<p>T19010 D19010 L19010</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 6mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 57mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 1K335-0600-100-XD 1730</p>	

<p>Operation 14/16</p> <p>DESCRIPTION: Wall5</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 4.87mm</p> <p>MAXIMUM STEPOVER: 3.8mm</p>	<p>MAXIMUM Z: 12mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1525.299mm/min</p> <p>CUTTING DISTANCE: 118.52mm</p> <p>RAPID DISTANCE: 117.7mm</p> <p>ESTIMATED CYCLE TIME: 11s (0.6%)</p> <p>COOLANT: Flood</p>	<p>T19010 D19010 L19010</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 6mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 57mm</p> <p>FLUTES: 5</p> <p>DESCRIPTION: Fresa a candela CoroMill Dura in metallo duro integrale</p> <p>VENDOR: sandvik</p> <p>PRODUCT: 1K335-0600-100-XD 1730</p>	
<p>Operation 15/16</p> <p>DESCRIPTION: Freeform</p> <p>STRATEGY: Contour</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 0.56mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -15.82mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1900mm/min</p> <p>CUTTING DISTANCE: 853.56mm</p> <p>RAPID DISTANCE: 557.83mm</p> <p>ESTIMATED CYCLE TIME: 45s (2.4%)</p> <p>COOLANT: Flood</p>	<p>T22014 D22014 L22014</p> <p>TYPE: ball end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 4mm</p> <p>LENGTH: 20mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: nervatura tonda</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: fresa a punta tonda VQ4SVBR04000</p>	
<p>Operation 16/16</p> <p>DESCRIPTION: Freeform1</p> <p>STRATEGY: Scallop</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPOVER: 0.28mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -7.08mm</p> <p>MAXIMUM SPINDLE SPEED: 8100rpm</p> <p>MAXIMUM FEEDRATE: 1900mm/min</p> <p>CUTTING DISTANCE: 417.03mm</p> <p>RAPID DISTANCE: 98.69mm</p> <p>ESTIMATED CYCLE TIME: 21s (1.1%)</p> <p>COOLANT: Flood</p>	<p>T22014 D22014 L22014</p> <p>TYPE: ball end mill</p> <p>DIAMETER: 8mm</p> <p>CORNER RADIUS: 4mm</p> <p>LENGTH: 20mm</p> <p>FLUTES: 4</p> <p>DESCRIPTION: nervatura tonda</p> <p>VENDOR: mitsubishi</p> <p>PRODUCT: fresa a punta tonda VQ4SVBR04000</p>	