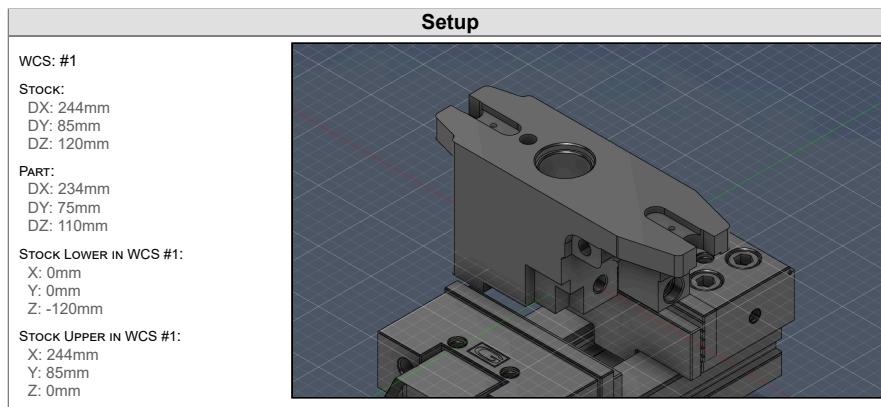


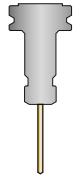
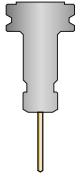
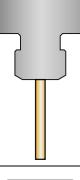
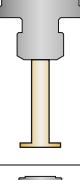
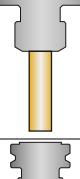
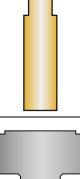
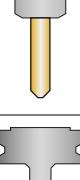
Setup Sheet for Program 1001

JOB DESCRIPTION: Faccia inferiore
DOCUMENT PATH: Pezzo v1



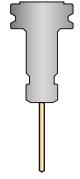
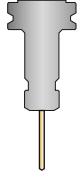
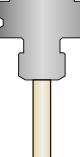
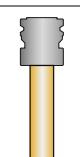
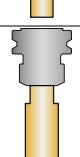
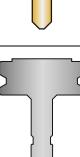
Total	
NUMBER OF OPERATIONS: 21	
NUMBER OF TOOLS: 16	
TOOLS: T10 T20 T30 T40 T50 T60 T70 T80 T90 T100 T110 T120 T130 T140 T150 T160	
MAXIMUM FEEDRATE: 2560mm/min	
MAXIMUM SPINDLE SPEED: 3414rpm	
CUTTING DISTANCE: 12440.16mm	
RAPID DISTANCE: 10431.91mm	
ESTIMATED CYCLE TIME: 17m:1s	

Tools	
T10 D1 L1 TYPE: face mill DIAMETER: 76.2mm CORNER RADIUS: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa per spianare VENDOR: Sandvik PRODUCT: R365-063C6-S15M	MAXIMUM FEED: 2560mm/min MAXIMUM SPINDLE SPEED: 1216rpm CUTTING DISTANCE: 984.88mm RAPID DISTANCE: 22.38mm ESTIMATED CYCLE TIME: 23s (2.3%) HOLDER: CT50 - Blank 2 VENDOR: Lyndex-Nikken
T20 D1 L1 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730	MAXIMUM FEED: 1620mm/min MAXIMUM SPINDLE SPEED: 1448rpm CUTTING DISTANCE: 9771.97mm RAPID DISTANCE: 8522.9mm ESTIMATED CYCLE TIME: 7m:44s (45.5%) HOLDER: BT40 - B4C3-0020
T30 D1 L1 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: 1K334-1000-100-XD 1730	MAXIMUM FEED: 553mm/min MAXIMUM SPINDLE SPEED: 2620rpm CUTTING DISTANCE: 603.31mm RAPID DISTANCE: 144mm ESTIMATED CYCLE TIME: 1m:11s (7%) HOLDER: BT40 - B4C3-0020
T40 D1 L1 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730	MAXIMUM FEED: 1780mm/min MAXIMUM SPINDLE SPEED: 3414rpm CUTTING DISTANCE: 129.2mm RAPID DISTANCE: 158.2mm ESTIMATED CYCLE TIME: 14s (1.3%) HOLDER: BT40 - B4C3-0020
T50 D1 L1 TYPE: drill DIAMETER: 12mm LENGTH: 80mm FLUTES: 2 DESCRIPTION: Punta a forare M12 H8 180° VENDOR: Mitsubishi PRODUCT: VAPDSCB1200	MAXIMUM FEED: 127.2mm/min MAXIMUM SPINDLE SPEED: 530rpm CUTTING DISTANCE: 32mm RAPID DISTANCE: 62mm ESTIMATED CYCLE TIME: 16s (1.6%) HOLDER: BT40 - B4C4-0020
T60 D1 L1 TYPE: spot drill DIAMETER: 7mm TIP ANGLE: 90° LENGTH: 55mm FLUTES: 2 DESCRIPTION: Punta da centrinatura fori piccoli VENDOR: Mitsubishi PRODUCT: DLE0700S070P090	MAXIMUM FEED: 248mm/min MAXIMUM SPINDLE SPEED: 1000rpm CUTTING DISTANCE: 7.77mm RAPID DISTANCE: 91.77mm ESTIMATED CYCLE TIME: 3s (0.3%) HOLDER: BT40 - B4C4-0020

T70 D1 L1 TYPE: drill DIAMETER: 5mm TIP ANGLE: 118° LENGTH: 70mm FLUTES: 2 DESCRIPTION: Punta a forare M5 H8 VENDOR: Mitsubishi PRODUCT: VSDD0500	MAXIMUM FEED: 139.7mm/min MAXIMUM SPINDLE SPEED: 1273rpm CUTTING DISTANCE: 16.25mm RAPID DISTANCE: 100.75mm ESTIMATED CYCLE TIME: 8s (0.8%)	HOLDER: BT40 - B4C4-0020	
T80 D1 L1 TYPE: drill DIAMETER: 4.5mm TIP ANGLE: 118° LENGTH: 55mm FLUTES: 2 DESCRIPTION: Punta a forare M4.5 H8 VENDOR: Mitsubishi PRODUCT: VSDD0450	MAXIMUM FEED: 71.5mm/min MAXIMUM SPINDLE SPEED: 1415rpm CUTTING DISTANCE: 14.45mm RAPID DISTANCE: 118.77mm ESTIMATED CYCLE TIME: 14s (1.3%)	HOLDER: BT40 - B4C4-0020	
T90 D1 L1 TYPE: right hand tap DIAMETER: 6mm LENGTH: 50mm FLUTES: 3 DESCRIPTION: Maschio M6x1 VENDOR: Sandvik PRODUCT: T300-XM100DA-M6 B125	MAXIMUM FEED: 2106.15mm/min MAXIMUM SPINDLE SPEED: 2106rpm CUTTING DISTANCE: 29.5mm RAPID DISTANCE: 84.5mm ESTIMATED CYCLE TIME: 2s (0.2%)	HOLDER: BT40 - B4C3-0020	
T100 D1 L1 TYPE: slot mill DIAMETER: 27.7mm CORNER RADIUS: 0.2mm LENGTH: 60mm FLUTES: 6 DESCRIPTION: Fresa a disco per asole di fissaggio e scalinatura grande VENDOR: Sandvik PRODUCT: 327R12-28 30002-GMM 1025	MAXIMUM FEED: 940.8mm/min MAXIMUM SPINDLE SPEED: 2241rpm CUTTING DISTANCE: 173.25mm RAPID DISTANCE: 339.9mm ESTIMATED CYCLE TIME: 15s (1.5%)	HOLDER: BT40 - B4C3-0020	
T110 D1 L1 TYPE: drill DIAMETER: 34.5mm TIP ANGLE: 176° LENGTH: 180mm FLUTES: 2 DESCRIPTION: Punta a forare per foro grande M34.5 VENDOR: Sandvik PRODUCT: 880-D3450L40-03	MAXIMUM FEED: 180mm/min MAXIMUM SPINDLE SPEED: 1319rpm CUTTING DISTANCE: 107.6mm RAPID DISTANCE: 139.6mm ESTIMATED CYCLE TIME: 38s (3.7%)	HOLDER: BT40 - B4C3-0040	
T120 D1 L1 TYPE: flat end mill DIAMETER: 14mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa per allargamento tasche circolari VENDOR: Sandvik PRODUCT: 2P341-1400-MA 1640	MAXIMUM FEED: 512mm/min MAXIMUM SPINDLE SPEED: 1671rpm CUTTING DISTANCE: 92.48mm RAPID DISTANCE: 46.6mm ESTIMATED CYCLE TIME: 11s (1.1%)	HOLDER: BT40 - B4C3-0020	
T130 D1 L1 TYPE: boring bar DIAMETER: 35mm LENGTH: 120mm FLUTES: 1 DESCRIPTION: Bareno allungatura a foro M35 VENDOR: Sandvik PRODUCT: 825-36TC06-A25	MAXIMUM FEED: 159mm/min MAXIMUM SPINDLE SPEED: 1582rpm CUTTING DISTANCE: 184mm RAPID DISTANCE: 42mm ESTIMATED CYCLE TIME: 1m:10s (6.9%)	HOLDER: BT40 - B4C3-0032	
T140 D1 L1 TYPE: chamfer mill DIAMETER: 12mm TAPER ANGLE: 45° LENGTH: 50mm FLUTES: 6 DESCRIPTION: Fresa per smussature VENDOR: Sandvik PRODUCT: 1C050-0300-045-XB 1620	MAXIMUM FEED: 1719mm/min MAXIMUM SPINDLE SPEED: 2387rpm CUTTING DISTANCE: 206.07mm RAPID DISTANCE: 65.5mm ESTIMATED CYCLE TIME: 8s (0.8%)	HOLDER: BT40 - B4C3-0020	
T150 D1 L1 TYPE: drill DIAMETER: 4.2mm TIP ANGLE: 118° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Punta a forare M4.2 H8 VENDOR: Mitsubishi PRODUCT: VSDD0420	MAXIMUM FEED: 136.5mm/min MAXIMUM SPINDLE SPEED: 1516rpm CUTTING DISTANCE: 37.02mm RAPID DISTANCE: 263.02mm ESTIMATED CYCLE TIME: 19s (1.9%)	HOLDER: BT40 - B4C4-0011	
T160 D1 L1 TYPE: right hand tap DIAMETER: 5mm LENGTH: 50mm FLUTES: 3 DESCRIPTION: Maschiatura M5x0,8 VENDOR: Sandvik PRODUCT: T300-XM100DA-M5 B125	MAXIMUM FEED: 1782.535mm/min MAXIMUM SPINDLE SPEED: 2228rpm CUTTING DISTANCE: 50.4mm RAPID DISTANCE: 230mm ESTIMATED CYCLE TIME: 4s (0.4%)	HOLDER: BT40 - B4C4-0011	

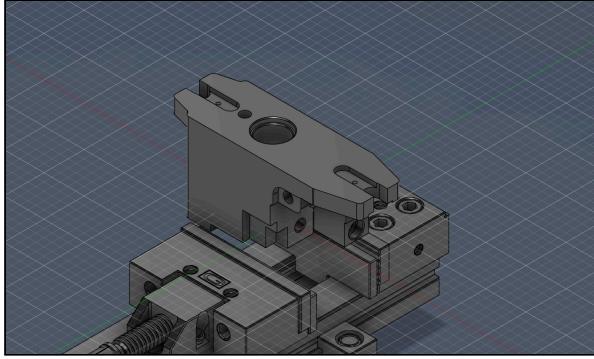
Operations

Operation 1/21 DESCRIPTION: 1 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 42.5mm	MAXIMUM SPINDLE SPEED: 1216rpm MAXIMUM FEEDRATE: 2560mm/min CUTTING DISTANCE: 984.88mm RAPID DISTANCE: 22.38mm ESTIMATED CYCLE TIME: 23s (2.3%) COOLANT: Flood	T10 D1 L1 TYPE: face mill DIAMETER: 76.2mm CORNER RADIUS: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa per spianare VENDOR: Sandvik PRODUCT: R365-063C6-S15M	
Operation 2/21 DESCRIPTION: 2 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 17mm MAXIMUM STEPOVER: 7.15mm	MAXIMUM SPINDLE SPEED: 1448rpm MAXIMUM FEEDRATE: 1620mm/min CUTTING DISTANCE: 3890.86mm RAPID DISTANCE: 3777.77mm ESTIMATED CYCLE TIME: 3m:9s (18.6%) COOLANT: Flood	T20 D1 L1 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730	
Operation 3/21 DESCRIPTION: 3 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 17mm MAXIMUM STEPOVER: 7.15mm	MAXIMUM SPINDLE SPEED: 1448rpm MAXIMUM FEEDRATE: 1620mm/min CUTTING DISTANCE: 3890.86mm RAPID DISTANCE: 3777.77mm ESTIMATED CYCLE TIME: 3m:9s (18.6%) COOLANT: Flood	T20 D1 L1 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730	
Operation 4/21 DESCRIPTION: 4.1 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 11mm MAXIMUM STEPOVER: 10mm	MAXIMUM SPINDLE SPEED: 1448rpm MAXIMUM FEEDRATE: 1620mm/min CUTTING DISTANCE: 1990.25mm RAPID DISTANCE: 967.36mm ESTIMATED CYCLE TIME: 1m:25s (8.4%) COOLANT: Flood	T20 D1 L1 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730	
Operation 5/21 DESCRIPTION: 4.2 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 6.65mm	MAXIMUM SPINDLE SPEED: 3414rpm MAXIMUM FEEDRATE: 1780mm/min CUTTING DISTANCE: 129.2mm RAPID DISTANCE: 158.2mm ESTIMATED CYCLE TIME: 14s (1.3%) COOLANT: Flood	T40 D1 L1 TYPE: bullnose end mill DIAMETER: 8mm CORNER RADIUS: 0.5mm LENGTH: 55mm FLUTES: 4 DESCRIPTION: Fresa integrale per finitura raggi VENDOR: Sandvik PRODUCT: 1K377-0800-050-XD 1730	
Operation 6/21 DESCRIPTION: 5.1 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 6mm	MAXIMUM SPINDLE SPEED: 2620rpm MAXIMUM FEEDRATE: 553mm/min CUTTING DISTANCE: 135.65mm RAPID DISTANCE: 29mm ESTIMATED CYCLE TIME: 15s (1.5%) COOLANT: Flood	T30 D1 L1 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: 1K334-1000-100-XD 1730	
Operation 7/21 DESCRIPTION: 5.2 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 6.5mm MAXIMUM STEPOVER: 6mm	MAXIMUM SPINDLE SPEED: 2496rpm MAXIMUM FEEDRATE: 494mm/min CUTTING DISTANCE: 166mm RAPID DISTANCE: 43mm ESTIMATED CYCLE TIME: 21s (2%) COOLANT: Flood	T30 D1 L1 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: 1K334-1000-100-XD 1730	
Operation 8/21 DESCRIPTION: 6.1 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 6mm	MAXIMUM SPINDLE SPEED: 2620rpm MAXIMUM FEEDRATE: 553mm/min CUTTING DISTANCE: 135.65mm RAPID DISTANCE: 29mm ESTIMATED CYCLE TIME: 15s (1.5%) COOLANT: Flood	T30 D1 L1 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: 1K334-1000-100-XD 1730	
Operation 9/21 DESCRIPTION: 6.2 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 6.5mm MAXIMUM STEPOVER: 6mm	MAXIMUM SPINDLE SPEED: 2496rpm MAXIMUM FEEDRATE: 494mm/min CUTTING DISTANCE: 166mm RAPID DISTANCE: 43mm ESTIMATED CYCLE TIME: 21s (2%) COOLANT: Flood	T30 D1 L1 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: 1K334-1000-100-XD 1730	
Operation 10/21 DESCRIPTION: 7.1 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 530rpm MAXIMUM FEEDRATE: 127.2mm/min CUTTING DISTANCE: 32mm RAPID DISTANCE: 62mm ESTIMATED CYCLE TIME: 16s (1.6%) COOLANT: Flood	T50 D1 L1 TYPE: drill DIAMETER: 12mm LENGTH: 80mm FLUTES: 2 DESCRIPTION: Punta a forare M12 H8 180° VENDOR: Mitsubishi PRODUCT: VAPDSCBD1200	
Operation 11/21 DESCRIPTION: 7.2 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1000rpm MAXIMUM FEEDRATE: 248mm/min CUTTING DISTANCE: 7.77mm RAPID DISTANCE: 91.77mm ESTIMATED CYCLE TIME: 3s (0.3%) COOLANT: Flood	T60 D1 L1 TYPE: spot drill DIAMETER: 7mm TIP ANGLE: 90° LENGTH: 55mm FLUTES: 2 DESCRIPTION: Punta da centrinatura fori piccoli VENDOR: Mitsubishi PRODUCT: DLE0700S070P090	

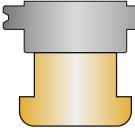
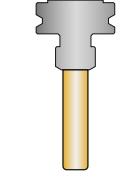
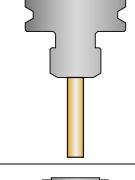
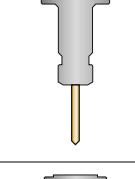
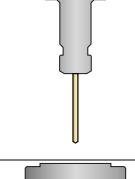
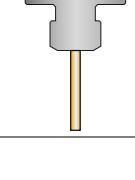
Operation 12/21 DESCRIPTION: 7.3 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1273rpm MAXIMUM FEEDRATE: 139.7mm/min CUTTING DISTANCE: 16.25mm RAPID DISTANCE: 100.75mm ESTIMATED CYCLE TIME: 8s (0.8%) COOLANT: Flood	T70 D1 L1 TYPE: drill DIAMETER: 5mm TIP ANGLE: 118° LENGTH: 70mm FLUTES: 2 DESCRIPTION: Punta a forare M5 H8 VENDOR: Mitsubishi PRODUCT: VSDD0500	
Operation 13/21 DESCRIPTION: 7.4 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1415rpm MAXIMUM FEEDRATE: 71.5mm/min CUTTING DISTANCE: 14.45mm RAPID DISTANCE: 118.77mm ESTIMATED CYCLE TIME: 14s (1.3%) COOLANT: Flood	T80 D1 L1 TYPE: drill DIAMETER: 4.5mm TIP ANGLE: 118° LENGTH: 55mm FLUTES: 2 DESCRIPTION: Punta a forare M4.5 H8 VENDOR: Mitsubishi PRODUCT: VSDD0450	
Operation 14/21 DESCRIPTION: 7.5 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 2106rpm MAXIMUM FEEDRATE: 2106.15mm/min CUTTING DISTANCE: 29.5mm RAPID DISTANCE: 84.5mm ESTIMATED CYCLE TIME: 2s (0.2%) COOLANT: Flood	T90 D1 L1 TYPE: right hand tap DIAMETER: 6mm LENGTH: 50mm FLUTES: 3 DESCRIPTION: Maschio M6x1 VENDOR: Sandvik PRODUCT: T300-XM100DA-M6 B125	
Operation 15/21 DESCRIPTION: 8 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 16.62mm	MAXIMUM SPINDLE SPEED: 2241rpm MAXIMUM FEEDRATE: 940.8mm/min CUTTING DISTANCE: 173.25mm RAPID DISTANCE: 339.9mm ESTIMATED CYCLE TIME: 15s (1.5%) COOLANT: Flood	T100 D1 L1 TYPE: slot mill DIAMETER: 27.7mm CORNER RADIUS: 0.2mm LENGTH: 60mm FLUTES: 6 DESCRIPTION: Fresa a disco per asole di fissaggio e scalanatura grande VENDOR: Sandvik PRODUCT: 327R12-28 30002-GMM 1025	
Operation 16/21 DESCRIPTION: 9.1 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1319rpm MAXIMUM FEEDRATE: 180mm/min CUTTING DISTANCE: 107.6mm RAPID DISTANCE: 139.6mm ESTIMATED CYCLE TIME: 38s (3.7%) COOLANT: Flood	T110 D1 L1 TYPE: drill DIAMETER: 34.5mm TIP ANGLE: 176° LENGTH: 180mm FLUTES: 2 DESCRIPTION: Punta a forare per foro grande M34.5 VENDOR: Sandvik PRODUCT: 880-D3450L40-03	
Operation 17/21 DESCRIPTION: 9.2 STRATEGY: Circular WCS: #1 STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 3.9mm	MAXIMUM SPINDLE SPEED: 1671rpm MAXIMUM FEEDRATE: 512mm/min CUTTING DISTANCE: 92.48mm RAPID DISTANCE: 46.6mm ESTIMATED CYCLE TIME: 11s (1.1%) COOLANT: Flood	T120 D1 L1 TYPE: flat end mill DIAMETER: 14mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa per allargamento tasche circolari VENDOR: Sandvik PRODUCT: 2P341-1400-MA 1640	
Operation 18/21 DESCRIPTION: 9.3 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1582rpm MAXIMUM FEEDRATE: 159mm/min CUTTING DISTANCE: 184mm RAPID DISTANCE: 42mm ESTIMATED CYCLE TIME: 1m:10s (6.9%) COOLANT: Flood	T130 D1 L1 TYPE: boring bar DIAMETER: 35mm LENGTH: 120mm FLUTES: 1 DESCRIPTION: Bareno allargatura a foro M35 VENDOR: Sandvik PRODUCT: 825-36TC06-A25	
Operation 19/21 DESCRIPTION: 10 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 11.4mm	MAXIMUM SPINDLE SPEED: 2387rpm MAXIMUM FEEDRATE: 1719mm/min CUTTING DISTANCE: 206.07mm RAPID DISTANCE: 65.5mm ESTIMATED CYCLE TIME: 8s (0.8%) COOLANT: Flood	T140 D1 L1 TYPE: chamfer mill DIAMETER: 12mm TAPER ANGLE: 45° LENGTH: 50mm FLUTES: 6 DESCRIPTION: Fresa per smussature VENDOR: Sandvik PRODUCT: 1C050-0300-045-XB 1620	
Operation 20/21 DESCRIPTION: 11.1 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1516rpm MAXIMUM FEEDRATE: 136.5mm/min CUTTING DISTANCE: 37.02mm RAPID DISTANCE: 263.02mm ESTIMATED CYCLE TIME: 19s (1.9%) COOLANT: Flood	T150 D1 L1 TYPE: drill DIAMETER: 4.2mm TIP ANGLE: 118° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Punta a forare M4.2 H8 VENDOR: Mitsubishi PRODUCT: VSDD0420	
Operation 21/21 DESCRIPTION: 11.2 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 2228rpm MAXIMUM FEEDRATE: 1782.535mm/min CUTTING DISTANCE: 50.4mm RAPID DISTANCE: 230mm ESTIMATED CYCLE TIME: 4s (0.4%) COOLANT: Flood	T160 D1 L1 TYPE: right hand tap DIAMETER: 5mm LENGTH: 50mm FLUTES: 3 DESCRIPTION: Maschiatura M5x0,8 VENDOR: Sandvik PRODUCT: T300-XM100DA-M5 B125	

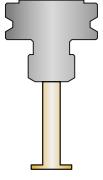
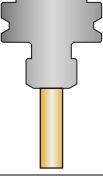
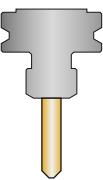
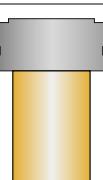
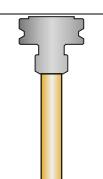
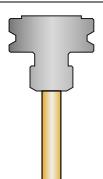
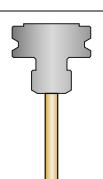
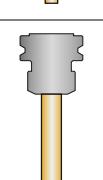
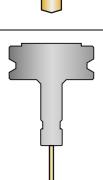
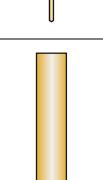
Setup Sheet for Program 1002

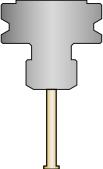
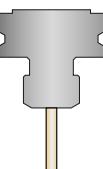
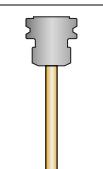
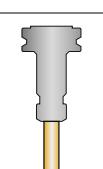
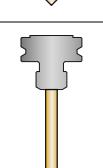
JOB DESCRIPTION: Faccia superiore
 DOCUMENT PATH: Pezzo v1

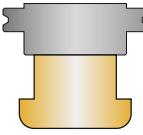
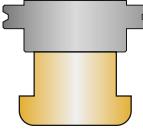
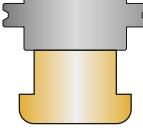
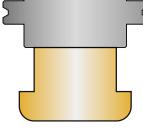
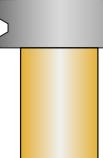
Setup	
WCS: #1 STOCK: DX: 244mm DY: 85mm DZ: 120mm PART: DX: 234mm DY: 75mm DZ: 110mm STOCK LOWER IN WCS #1: X: 0mm Y: 0mm Z: -120mm STOCK UPPER IN WCS #1: X: 244mm Y: 85mm Z: 0mm	

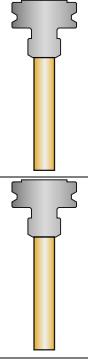
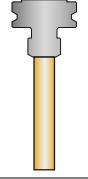
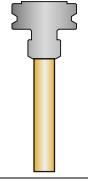
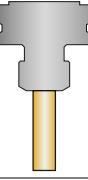
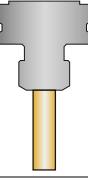
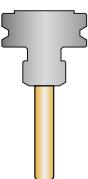
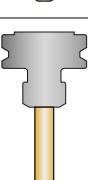
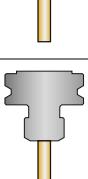
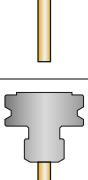
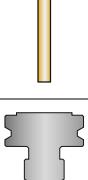
Total	
NUMBER OF OPERATIONS: 37	
NUMBER OF TOOLS: 21	
TOOLS: T10 T20 T30 T60 T70 T90 T100 T120 T140 T170 T180 T190 T200 T210 T220 T230 T240 T250 T260 T270 T280	
MAXIMUM FEEDRATE: 2560mm/min	
MAXIMUM SPINDLE SPEED: 7979rpm	
CUTTING DISTANCE: 12185.42mm	
RAPID DISTANCE: 8164.64mm	
ESTIMATED CYCLE TIME: 19m:52s	

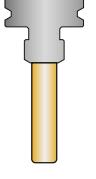
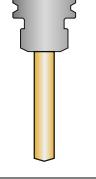
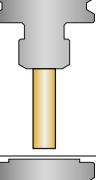
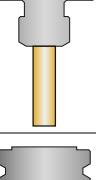
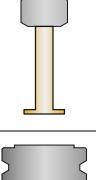
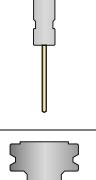
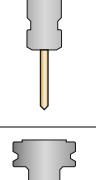
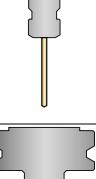
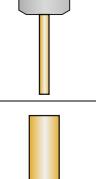
Tools			
T10 D1 L1 Type: face mill Diameter: 76.2mm Corner Radius: 10mm Length: 50mm Flutes: 4 Description: Fresa per spianare Vendor: Sandvik Product: R365-063C6-S15M	MAXIMUM FEED: 2560mm/min MAXIMUM SPINDLE SPEED: 1328rpm CUTTING DISTANCE: 3399.49mm RAPID DISTANCE: 93mm ESTIMATED CYCLE TIME: 1m:30s (7.5%)	HOLDER: CT50 - Blank 2 VENDOR: Lyndex-Nikken	
T20 D1 L1 Type: bullnose end mill Diameter: 20mm Corner Radius: 3mm Length: 80mm Flutes: 4 Description: Fresa integrale torica per lavorazioni grandi raggiate Vendor: Sandvik Product: 1K335-2000-300-XD 1730	MAXIMUM FEED: 1620mm/min MAXIMUM SPINDLE SPEED: 1448rpm CUTTING DISTANCE: 495.23mm RAPID DISTANCE: 117mm ESTIMATED CYCLE TIME: 20s (1.7%)	HOLDER: BT40 - B4C3-0020	
T30 D1 L1 Type: flat end mill Diameter: 10mm Length: 50mm Flutes: 4 Description: Fresa integrale per tasche piccole Vendor: Sandvik Product: 1K334-1000-100-XD 1730	MAXIMUM FEED: 673mm/min MAXIMUM SPINDLE SPEED: 2731rpm CUTTING DISTANCE: 33.42mm RAPID DISTANCE: 99mm ESTIMATED CYCLE TIME: 4s (0.3%)	HOLDER: BT40 - B4C3-0020	
T60 D1 L1 Type: spot drill Diameter: 7mm Tip Angle: 90° Length: 55mm Flutes: 2 Description: Punta da centrinatura fori piccoli Vendor: Mitsubishi Product: DLE0700S070P090	MAXIMUM FEED: 248mm/min MAXIMUM SPINDLE SPEED: 1000rpm CUTTING DISTANCE: 46.62mm RAPID DISTANCE: 339.18mm ESTIMATED CYCLE TIME: 15s (1.3%)	HOLDER: BT40 - B4C4-0020	
T70 D1 L1 Type: drill Diameter: 5mm Tip Angle: 118° Length: 70mm Flutes: 2 Description: Punta a forare M5 H8 Vendor: Mitsubishi Product: VSDD0500	MAXIMUM FEED: 139.7mm/min MAXIMUM SPINDLE SPEED: 1273rpm CUTTING DISTANCE: 175.46mm RAPID DISTANCE: 658.12mm ESTIMATED CYCLE TIME: 1m:23s (7%)	HOLDER: BT40 - B4C4-0020	
T90 D1 L1 Type: right hand tap Diameter: 6mm Length: 50mm Flutes: 3 Description: Maschio M6x1 Vendor: Sandvik Product: T300-XM100DA-M6 B125	MAXIMUM FEED: 2106.15mm/min MAXIMUM SPINDLE SPEED: 2106rpm CUTTING DISTANCE: 250.98mm RAPID DISTANCE: 295.59mm ESTIMATED CYCLE TIME: 11s (0.9%)	HOLDER: BT40 - B4C3-0020	

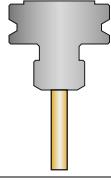
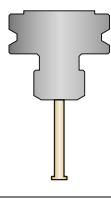
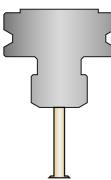
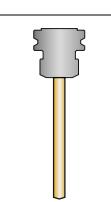
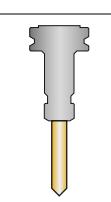
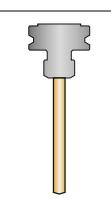
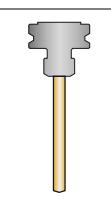
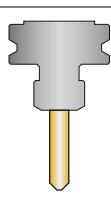
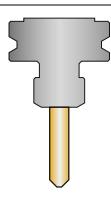
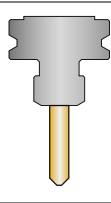
T100 D1 L1 TYPE: slot mill DIAMETER: 27.7mm CORNER RADIUS: 0.2mm LENGTH: 60mm FLUTES: 6 DESCRIPTION: Fresa a disco per asole di fissaggio e scalnatura grande VENDOR: Sandvik PRODUCT: 327R12-28 30002-GMM 1025	MAXIMUM FEED: 940.8mm/min MAXIMUM SPINDLE SPEED: 2241rpm CUTTING DISTANCE: 86.17mm RAPID DISTANCE: 54mm ESTIMATED CYCLE TIME: 6s (0.5%)	HOLDER: BT40 - B4C3-0020	
T120 D1 L1 TYPE: flat end mill DIAMETER: 14mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa per allargamento tasche circolari VENDOR: Sandvik PRODUCT: 2P341-1400-MA 1640	MAXIMUM FEED: 512mm/min MAXIMUM SPINDLE SPEED: 1671rpm CUTTING DISTANCE: 1316.5mm RAPID DISTANCE: 582.97mm ESTIMATED CYCLE TIME: 3m:9s (15.9%)	HOLDER: BT40 - B4C3-0020	
T140 D1 L1 TYPE: chamfer mill DIAMETER: 12mm TAPER ANGLE: 45° LENGTH: 50mm FLUTES: 6 DESCRIPTION: Fresa per smussature VENDOR: Sandvik PRODUCT: 1C050-0300-045-XB 1620	MAXIMUM FEED: 1719mm/min MAXIMUM SPINDLE SPEED: 2387rpm CUTTING DISTANCE: 536mm RAPID DISTANCE: 167.54mm ESTIMATED CYCLE TIME: 21s (1.7%)	HOLDER: BT40 - B4C3-0020	
T170 D1 L1 TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 1.2mm LENGTH: 60mm FLUTES: 3 DESCRIPTION: Fresa per lavorazione grossa tasca centrale VENDOR: Sandvik PRODUCT: R390-040C4-18M060	MAXIMUM FEED: 1032mm/min MAXIMUM SPINDLE SPEED: 2483rpm CUTTING DISTANCE: 2223.64mm RAPID DISTANCE: 2146.72mm ESTIMATED CYCLE TIME: 2m:35s (13%)	HOLDER: BT40 - Blank	
T180 D1 L1 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730	MAXIMUM FEED: 690mm/min MAXIMUM SPINDLE SPEED: 1416rpm CUTTING DISTANCE: 648.26mm RAPID DISTANCE: 551.43mm ESTIMATED CYCLE TIME: 1m:5s (5.4%)	HOLDER: BT40 - B4C3-0020	
T190 D1 L1 TYPE: bullnose end mill DIAMETER: 14mm CORNER RADIUS: 3mm LENGTH: 70mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per tasche VENDOR: Sandvik PRODUCT: R216.24-14050GAK26P 1620	MAXIMUM FEED: 1704mm/min MAXIMUM SPINDLE SPEED: 1789rpm CUTTING DISTANCE: 1267.78mm RAPID DISTANCE: 859.46mm ESTIMATED CYCLE TIME: 55s (4.6%)	HOLDER: BT40 - B4C3-0020	
T200 D1 L1 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216.24-10050CCK22P 1620	MAXIMUM FEED: 1265mm/min MAXIMUM SPINDLE SPEED: 2158rpm CUTTING DISTANCE: 1371.4mm RAPID DISTANCE: 785.93mm ESTIMATED CYCLE TIME: 1m:14s (6.2%)	HOLDER: BT40 - B4C3-0020	
T210 D1 L1 TYPE: drill DIAMETER: 20mm TIP ANGLE: 147° LENGTH: 110mm FLUTES: 2 DESCRIPTION: Punta a forare M20 H8 VENDOR: Sandvik PRODUCT: 860.1-2000-077A1-PM P1BM	MAXIMUM FEED: 293mm/min MAXIMUM SPINDLE SPEED: 1109rpm CUTTING DISTANCE: 65.6mm RAPID DISTANCE: 151.6mm ESTIMATED CYCLE TIME: 15s (1.3%)	HOLDER: BT40 - B4C3-0032	
T220 D1 L1 TYPE: drill DIAMETER: 3mm TIP ANGLE: 118° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Punta a forare M3 H8 VENDOR: Mitsubishi PRODUCT: VSDD0300	MAXIMUM FEED: 998mm/min MAXIMUM SPINDLE SPEED: 7979rpm CUTTING DISTANCE: 16.28mm RAPID DISTANCE: 69.03mm ESTIMATED CYCLE TIME: 2s (0.2%)	HOLDER: BT40 - B4C4-0011	
T230 D1 L1 TYPE: drill DIAMETER: 16mm TIP ANGLE: 147° LENGTH: 90mm FLUTES: 2 DESCRIPTION: Punta a forare M16 H8 VENDOR: Sandvik PRODUCT: 860.1-1400-115A1-PM P1BM	MAXIMUM FEED: 376mm/min MAXIMUM SPINDLE SPEED: 1413rpm CUTTING DISTANCE: 44.37mm RAPID DISTANCE: 136.37mm ESTIMATED CYCLE TIME: 9s (0.7%)		

T240 D1 L1 TYPE: slot mill DIAMETER: 9.7mm CORNER RADIUS: 0.2mm LENGTH: 50mm FLUTES: 5 DESCRIPTION: Fresa a disco per scanalature piccole VENDOR: Sandvik PRODUCT: 327R06-10 20002-GM 1025	MAXIMUM FEED: 1927mm/min MAXIMUM SPINDLE SPEED: 6563rpm CUTTING DISTANCE: 40.45mm RAPID DISTANCE: 99.03mm ESTIMATED CYCLE TIME: 3s (0.2%)	HOLDER: BT40 - B4C3-0020	
T250 D1 L1 TYPE: dovetail mill DIAMETER: 11.7mm TAPER ANGLE: 45° LENGTH: 40mm FLUTES: 3 DESCRIPTION: Fresa a disco per smussi interni scanalature VENDOR: Sandvik PRODUCT: 327R06-12 12045-CH 1025	MAXIMUM FEED: 392mm/min MAXIMUM SPINDLE SPEED: 3265rpm CUTTING DISTANCE: 35.43mm RAPID DISTANCE: 94.83mm ESTIMATED CYCLE TIME: 7s (0.6%)	HOLDER: BT40 - B4C3-0020	
T260 D1 L1 TYPE: drill DIAMETER: 14mm TIP ANGLE: 147° LENGTH: 150mm FLUTES: 2 DESCRIPTION: Punta a forare M14 H8 VENDOR: Sandvik PRODUCT: 860.1-1400-115A1-PM P1BM	MAXIMUM FEED: 446mm/min MAXIMUM SPINDLE SPEED: 1619rpm CUTTING DISTANCE: 25.03mm RAPID DISTANCE: 255.03mm ESTIMATED CYCLE TIME: 6s (0.5%)	HOLDER: BT40 - B4C3-0032	
T270 D1 L1 TYPE: spot drill DIAMETER: 16mm TIP ANGLE: 90° LENGTH: 80mm FLUTES: 2 DESCRIPTION: Punta da centrinatura per fori grandi VENDOR: Sandvik PRODUCT: DLE1600S160P090	MAXIMUM FEED: 60mm/min MAXIMUM SPINDLE SPEED: 500rpm CUTTING DISTANCE: 12mm RAPID DISTANCE: 242mm ESTIMATED CYCLE TIME: 15s (1.3%)	HOLDER: BT40 - B4C4-0020	
T280 D1 L1 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 120mm FLUTES: 2 DESCRIPTION: Punta a forare M12 H8 VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM	MAXIMUM FEED: 446mm/min MAXIMUM SPINDLE SPEED: 1889rpm CUTTING DISTANCE: 95.31mm RAPID DISTANCE: 366.81mm ESTIMATED CYCLE TIME: 17s (1.4%)	HOLDER: BT40 - B4C3-0020	

Operations			
Operation 1/37 DESCRIPTION: 12.1 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 42.5mm	MAXIMUM SPINDLE SPEED: 1216rpm MAXIMUM FEEDRATE: 2560mm/min CUTTING DISTANCE: 989.98mm RAPID DISTANCE: 20mm ESTIMATED CYCLE TIME: 23s (2%) COOLANT: Flood	T10 D1 L1 TYPE: face mill DIAMETER: 76.2mm CORNER RADIUS: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa per spianare VENDOR: Sandvik PRODUCT: R365-063C6-S15M	
Operation 2/37 DESCRIPTION: 12.2 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 45.72mm	MAXIMUM SPINDLE SPEED: 1328rpm MAXIMUM FEEDRATE: 1540mm/min CUTTING DISTANCE: 573.22mm RAPID DISTANCE: 33mm ESTIMATED CYCLE TIME: 23s (1.9%) COOLANT: Flood	T10 D1 L1 TYPE: face mill DIAMETER: 76.2mm CORNER RADIUS: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa per spianare VENDOR: Sandvik PRODUCT: R365-063C6-S15M	
Operation 3/37 DESCRIPTION: 12.3 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 42.5mm	MAXIMUM SPINDLE SPEED: 1216rpm MAXIMUM FEEDRATE: 2560mm/min CUTTING DISTANCE: 918.15mm RAPID DISTANCE: 20mm ESTIMATED CYCLE TIME: 22s (1.8%) COOLANT: Flood	T10 D1 L1 TYPE: face mill DIAMETER: 76.2mm CORNER RADIUS: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa per spianare VENDOR: Sandvik PRODUCT: R365-063C6-S15M	
Operation 4/37 DESCRIPTION: 12.4 STRATEGY: Facing WCS: #1 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 42.5mm	MAXIMUM SPINDLE SPEED: 1216rpm MAXIMUM FEEDRATE: 2560mm/min CUTTING DISTANCE: 918.14mm RAPID DISTANCE: 20mm ESTIMATED CYCLE TIME: 22s (1.8%) COOLANT: Flood	T10 D1 L1 TYPE: face mill DIAMETER: 76.2mm CORNER RADIUS: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa per spianare VENDOR: Sandvik PRODUCT: R365-063C6-S15M	
Operation 5/37 DESCRIPTION: 12.5 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 11.67mm MAXIMUM STEPOVER: 14.4mm	MAXIMUM SPINDLE SPEED: 2483rpm MAXIMUM FEEDRATE: 1032mm/min CUTTING DISTANCE: 2223.64mm RAPID DISTANCE: 2146.72mm ESTIMATED CYCLE TIME: 2m:35s (13%) COOLANT: Flood	T170 D1 L1 TYPE: face mill DIAMETER: 40mm CORNER RADIUS: 1.2mm LENGTH: 60mm FLUTES: 3 DESCRIPTION: Fresa per lavorazione grossa tasca centrale VENDOR: Sandvik PRODUCT: R390-040C4-18M060	

Operation 6/37 DESCRIPTION: 13.1 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 45mm MAXIMUM STEPOVER: 19mm	MAXIMUM SPINDLE SPEED: 1276rpm MAXIMUM FEEDRATE: 690mm/min CUTTING DISTANCE: 435.43mm RAPID DISTANCE: 470.43mm ESTIMATED CYCLE TIME: 44s (3.7%) COOLANT: Flood	T180 D1 L1 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730	
Operation 7/37 DESCRIPTION: 13.2 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 19mm	MAXIMUM SPINDLE SPEED: 1416rpm MAXIMUM FEEDRATE: 636mm/min CUTTING DISTANCE: 102.57mm RAPID DISTANCE: 31mm ESTIMATED CYCLE TIME: 10s (0.8%) COOLANT: Flood	T180 D1 L1 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730	
Operation 8/37 DESCRIPTION: 13.3 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 12mm	MAXIMUM SPINDLE SPEED: 1416rpm MAXIMUM FEEDRATE: 636mm/min CUTTING DISTANCE: 110.27mm RAPID DISTANCE: 50mm ESTIMATED CYCLE TIME: 11s (0.9%) COOLANT: Flood	T180 D1 L1 TYPE: flat end mill DIAMETER: 20mm LENGTH: 110mm FLUTES: 5 DESCRIPTION: Fresa integrale per particolari lunghi VENDOR: Sandvik PRODUCT: 1K365-2000-XD 1730	
Operation 9/37 DESCRIPTION: 14.1 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 9.6mm	MAXIMUM SPINDLE SPEED: 1321rpm MAXIMUM FEEDRATE: 421mm/min CUTTING DISTANCE: 531.14mm RAPID DISTANCE: 259.57mm ESTIMATED CYCLE TIME: 1m:19s (6.6%) COOLANT: Flood	T120 D1 L1 TYPE: flat end mill DIAMETER: 14mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa per allungamento tasche circolari VENDOR: Sandvik PRODUCT: 2P341-1400-MA 1640	
Operation 10/37 DESCRIPTION: 14.2 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 9.6mm	MAXIMUM SPINDLE SPEED: 1321rpm MAXIMUM FEEDRATE: 421mm/min CUTTING DISTANCE: 576.47mm RAPID DISTANCE: 192.8mm ESTIMATED CYCLE TIME: 1m:24s (7.1%) COOLANT: Flood	T120 D1 L1 TYPE: flat end mill DIAMETER: 14mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa per allungamento tasche circolari VENDOR: Sandvik PRODUCT: 2P341-1400-MA 1640	
Operation 11/37 DESCRIPTION: 14.3 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 10mm	MAXIMUM SPINDLE SPEED: 1789rpm MAXIMUM FEEDRATE: 1704mm/min CUTTING DISTANCE: 678.5mm RAPID DISTANCE: 355.26mm ESTIMATED CYCLE TIME: 28s (2.4%) COOLANT: Flood	T190 D1 L1 TYPE: bullnose end mill DIAMETER: 14mm CORNER RADIUS: 3mm LENGTH: 70mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per tasche VENDOR: Sandvik PRODUCT: R216.24-14050GAK26P 1620	
Operation 12/37 DESCRIPTION: 14.4 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 10mm	MAXIMUM SPINDLE SPEED: 1789rpm MAXIMUM FEEDRATE: 1704mm/min CUTTING DISTANCE: 589.28mm RAPID DISTANCE: 504.21mm ESTIMATED CYCLE TIME: 27s (2.2%) COOLANT: Flood	T190 D1 L1 TYPE: bullnose end mill DIAMETER: 14mm CORNER RADIUS: 3mm LENGTH: 70mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per tasche VENDOR: Sandvik PRODUCT: R216.24-14050GAK26P 1620	
Operation 13/37 DESCRIPTION: 15.1 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 6mm	MAXIMUM SPINDLE SPEED: 2158rpm MAXIMUM FEEDRATE: 1265mm/min CUTTING DISTANCE: 470.94mm RAPID DISTANCE: 96.39mm ESTIMATED CYCLE TIME: 23s (2%) COOLANT: Flood	T200 D1 L1 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216.24-10050CCK22P 1620	
Operation 14/37 DESCRIPTION: 15.2 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 6mm	MAXIMUM SPINDLE SPEED: 2158rpm MAXIMUM FEEDRATE: 1265mm/min CUTTING DISTANCE: 480.19mm RAPID DISTANCE: 106.81mm ESTIMATED CYCLE TIME: 24s (2%) COOLANT: Flood	T200 D1 L1 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216.24-10050CCK22P 1620	
Operation 15/37 DESCRIPTION: 15.3 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 9.31mm	MAXIMUM SPINDLE SPEED: 2158rpm MAXIMUM FEEDRATE: 1265mm/min CUTTING DISTANCE: 264.13mm RAPID DISTANCE: 254.93mm ESTIMATED CYCLE TIME: 16s (1.3%) COOLANT: Flood	T200 D1 L1 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216.24-10050CCK22P 1620	
Operation 16/37 DESCRIPTION: 15.4 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 9.31mm	MAXIMUM SPINDLE SPEED: 2158rpm MAXIMUM FEEDRATE: 1265mm/min CUTTING DISTANCE: 156.13mm RAPID DISTANCE: 327.8mm ESTIMATED CYCLE TIME: 11s (1%) COOLANT: Flood	T200 D1 L1 TYPE: bullnose end mill DIAMETER: 10mm CORNER RADIUS: 0.1mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole distanti VENDOR: Sandvik PRODUCT: R216.24-10050CCK22P 1620	

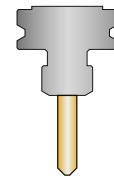
Operation 17/37 DESCRIPTION: 16 STRATEGY: Pocket 2D WCS: #1 TOLERANCE: 0.1mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 12mm MAXIMUM STEP OVER: 12mm	MAXIMUM SPINDLE SPEED: 1448rpm MAXIMUM FEEDRATE: 1620mm/min CUTTING DISTANCE: 495.23mm RAPID DISTANCE: 117mm ESTIMATED CYCLE TIME: 20s (1.7%) COOLANT: Flood	T20 D1 L1 TYPE: bullnose end mill DIAMETER: 20mm CORNER RADIUS: 3mm LENGTH: 80mm FLUTES: 4 DESCRIPTION: Fresa integrale torica per lavorazioni grandi raggiate VENDOR: Sandvik PRODUCT: 1K335-2000-300-XD 1730	
Operation 18/37 DESCRIPTION: 17.1 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1109rpm MAXIMUM FEEDRATE: 293mm/min CUTTING DISTANCE: 65.6mm RAPID DISTANCE: 151.6mm ESTIMATED CYCLE TIME: 15s (1.3%) COOLANT: Flood	T210 D1 L1 TYPE: drill DIAMETER: 20mm TIP ANGLE: 147° LENGTH: 110mm FLUTES: 2 DESCRIPTION: Punta a forare M20 H8 VENDOR: Sandvik PRODUCT: 860.1-2000-077A1-PM P1BM	
Operation 19/37 DESCRIPTION: 17.2 STRATEGY: Circular WCS: #1 STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1671rpm MAXIMUM FEEDRATE: 512mm/min CUTTING DISTANCE: 76.77mm RAPID DISTANCE: 76.6mm ESTIMATED CYCLE TIME: 10s (0.8%) COOLANT: Flood	T120 D1 L1 TYPE: flat end mill DIAMETER: 14mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa per allargamento tasche circolari VENDOR: Sandvik PRODUCT: 2P341-1400-MA 1640	
Operation 20/37 DESCRIPTION: 18.1 STRATEGY: Circular WCS: #1 STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1671rpm MAXIMUM FEEDRATE: 512mm/min CUTTING DISTANCE: 132.13mm RAPID DISTANCE: 54mm ESTIMATED CYCLE TIME: 16s (1.4%) COOLANT: Flood	T120 D1 L1 TYPE: flat end mill DIAMETER: 14mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa per allargamento tasche circolari VENDOR: Sandvik PRODUCT: 2P341-1400-MA 1640	
Operation 21/37 DESCRIPTION: 18.2 STRATEGY: Circular WCS: #1 STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 2241rpm MAXIMUM FEEDRATE: 940.8mm/min CUTTING DISTANCE: 86.17mm RAPID DISTANCE: 54mm ESTIMATED CYCLE TIME: 6s (0.5%) COOLANT: Flood	T100 D1 L1 TYPE: slot mill DIAMETER: 27.7mm CORNER RADIUS: 0.2mm LENGTH: 60mm FLUTES: 6 DESCRIPTION: Fresa a disco per asole di fissaggio e scalatura grande VENDOR: Sandvik PRODUCT: 327R12-28 30002-GMM 1025	
Operation 22/37 DESCRIPTION: 19 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 7979rpm MAXIMUM FEEDRATE: 998mm/min CUTTING DISTANCE: 16.28mm RAPID DISTANCE: 69.03mm ESTIMATED CYCLE TIME: 2s (0.2%) COOLANT: Flood	T220 D1 L1 TYPE: drill DIAMETER: 3mm TIP ANGLE: 118° LENGTH: 50mm FLUTES: 2 DESCRIPTION: Punta a forare M3 H8 VENDOR: Mitsubishi PRODUCT: VSDD0300	
Operation 23/37 DESCRIPTION: 20.1 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1000rpm MAXIMUM FEEDRATE: 248mm/min CUTTING DISTANCE: 46.62mm RAPID DISTANCE: 339.18mm ESTIMATED CYCLE TIME: 15s (1.3%) COOLANT: Flood	T60 D1 L1 TYPE: spot drill DIAMETER: 7mm TIP ANGLE: 90° LENGTH: 55mm FLUTES: 2 DESCRIPTION: Punta da centrinatura fori piccoli VENDOR: Mitsubishi PRODUCT: DLE0700S070P090	
Operation 24/37 DESCRIPTION: 20.2 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1273rpm MAXIMUM FEEDRATE: 139.7mm/min CUTTING DISTANCE: 175.46mm RAPID DISTANCE: 658.12mm ESTIMATED CYCLE TIME: 1m:23s (7%) COOLANT: Flood	T70 D1 L1 TYPE: drill DIAMETER: 5mm TIP ANGLE: 118° LENGTH: 70mm FLUTES: 2 DESCRIPTION: Punta a forare M5 H8 VENDOR: Mitsubishi PRODUCT: VSDD0500	
Operation 25/37 DESCRIPTION: 20.3 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 2106rpm MAXIMUM FEEDRATE: 2106.15mm/min CUTTING DISTANCE: 250.98mm RAPID DISTANCE: 295.59mm ESTIMATED CYCLE TIME: 11s (0.9%) COOLANT: Flood	T90 D1 L1 TYPE: right hand tap DIAMETER: 6mm LENGTH: 50mm FLUTES: 3 DESCRIPTION: Maschio M6x1 VENDOR: Sandvik PRODUCT: T300-XM100DA-M6 B125	
Operation 26/37 DESCRIPTION: 21.1 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1413rpm MAXIMUM FEEDRATE: 376mm/min CUTTING DISTANCE: 44.37mm RAPID DISTANCE: 136.37mm ESTIMATED CYCLE TIME: 9s (0.7%) COOLANT: Flood	T230 D1 L1 TYPE: drill DIAMETER: 16mm TIP ANGLE: 147° LENGTH: 90mm FLUTES: 2 DESCRIPTION: Punta a forare M16 H8 VENDOR: Sandvik PRODUCT: 860.1-1400-115A1-PM P1BM	

Operation 27/37 DESCRIPTION: 21.2 STRATEGY: Circular WCS: #1 STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 2.12mm	MAXIMUM SPINDLE SPEED: 2731rpm MAXIMUM FEEDRATE: 673mm/min CUTTING DISTANCE: 33.42mm RAPID DISTANCE: 99mm ESTIMATED CYCLE TIME: 4s (0.3%) COOLANT: Flood	T30 D1 L1 TYPE: flat end mill DIAMETER: 10mm LENGTH: 50mm FLUTES: 4 DESCRIPTION: Fresa integrale per tasche piccole VENDOR: Sandvik PRODUCT: 1K334-1000-100-XD 1730	
Operation 28/37 DESCRIPTION: 21.3 STRATEGY: Circular WCS: #1 STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 6563rpm MAXIMUM FEEDRATE: 1927mm/min CUTTING DISTANCE: 40.45mm RAPID DISTANCE: 99.03mm ESTIMATED CYCLE TIME: 3s (0.2%) COOLANT: Flood	T240 D1 L1 TYPE: slot mill DIAMETER: 9.7mm CORNER RADIUS: 0.2mm LENGTH: 50mm FLUTES: 5 DESCRIPTION: Fresa a disco per scanalature piccole VENDOR: Sandvik PRODUCT: 327R06-10 20002-GM 1025	
Operation 29/37 DESCRIPTION: 21.4 STRATEGY: Circular WCS: #1 STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 1mm	MAXIMUM SPINDLE SPEED: 3265rpm MAXIMUM FEEDRATE: 392mm/min CUTTING DISTANCE: 35.43mm RAPID DISTANCE: 94.83mm ESTIMATED CYCLE TIME: 7s (0.6%) COOLANT: Flood	T250 D1 L1 TYPE: dovetail mill DIAMETER: 11.7mm TAPER ANGLE: 45° LENGTH: 40mm FLUTES: 3 DESCRIPTION: Fresa a disco per smussi interni scanalature VENDOR: Sandvik PRODUCT: 327R06-12 12045-CH 1025	
Operation 30/37 DESCRIPTION: 21.5 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1619rpm MAXIMUM FEEDRATE: 446mm/min CUTTING DISTANCE: 25.03mm RAPID DISTANCE: 255.03mm ESTIMATED CYCLE TIME: 6s (0.5%) COOLANT: Flood	T260 D1 L1 TYPE: drill DIAMETER: 14mm TIP ANGLE: 147° LENGTH: 150mm FLUTES: 2 DESCRIPTION: Punta a forare M14 H8 VENDOR: Sandvik PRODUCT: 860.1-1400-115A1-PM P1BM	
Operation 31/37 DESCRIPTION: 22.1 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 500rpm MAXIMUM FEEDRATE: 60mm/min CUTTING DISTANCE: 12mm RAPID DISTANCE: 242mm ESTIMATED CYCLE TIME: 15s (1.3%) COOLANT: Flood	T270 D1 L1 TYPE: spot drill DIAMETER: 16mm TIP ANGLE: 90° LENGTH: 80mm FLUTES: 2 DESCRIPTION: Punta da centrinatura per fori grandi VENDOR: Sandvik PRODUCT: DLE1600S160P090	
Operation 32/37 DESCRIPTION: 22.2 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1889rpm MAXIMUM FEEDRATE: 446mm/min CUTTING DISTANCE: 26.53mm RAPID DISTANCE: 255.03mm ESTIMATED CYCLE TIME: 7s (0.6%) COOLANT: Flood	T280 D1 L1 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 120mm FLUTES: 2 DESCRIPTION: Punta a forare M12 H8 VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM	
Operation 33/37 DESCRIPTION: 23 STRATEGY: Drilling WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 1889rpm MAXIMUM FEEDRATE: 446mm/min CUTTING DISTANCE: 68.78mm RAPID DISTANCE: 111.78mm ESTIMATED CYCLE TIME: 11s (0.9%) COOLANT: Flood	T280 D1 L1 TYPE: drill DIAMETER: 12mm TIP ANGLE: 147° LENGTH: 120mm FLUTES: 2 DESCRIPTION: Punta a forare M12 H8 VENDOR: Sandvik PRODUCT: 860.1-1200-098A1-PM P1BM	
Operation 34/37 DESCRIPTION: 24.1 WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 2387rpm MAXIMUM FEEDRATE: 1719mm/min CUTTING DISTANCE: 55.52mm RAPID DISTANCE: 26mm ESTIMATED CYCLE TIME: 2s (0.2%) COOLANT: Flood	T140 D1 L1 TYPE: chamfer mill DIAMETER: 12mm TAPER ANGLE: 45° LENGTH: 50mm FLUTES: 6 DESCRIPTION: Fresa per smussature VENDOR: Sandvik PRODUCT: 1C050-0300-045-XB 1620	
Operation 35/37 DESCRIPTION: 24.2 WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm	MAXIMUM SPINDLE SPEED: 2387rpm MAXIMUM FEEDRATE: 1719mm/min CUTTING DISTANCE: 158.19mm RAPID DISTANCE: 46.54mm ESTIMATED CYCLE TIME: 6s (0.5%) COOLANT: Flood	T140 D1 L1 TYPE: chamfer mill DIAMETER: 12mm TAPER ANGLE: 45° LENGTH: 50mm FLUTES: 6 DESCRIPTION: Fresa per smussature VENDOR: Sandvik PRODUCT: 1C050-0300-045-XB 1620	
Operation 36/37 DESCRIPTION: 24.3 STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 11.4mm	MAXIMUM SPINDLE SPEED: 2387rpm MAXIMUM FEEDRATE: 1719mm/min CUTTING DISTANCE: 258.48mm RAPID DISTANCE: 67mm ESTIMATED CYCLE TIME: 10s (0.8%) COOLANT: Flood	T140 D1 L1 TYPE: chamfer mill DIAMETER: 12mm TAPER ANGLE: 45° LENGTH: 50mm FLUTES: 6 DESCRIPTION: Fresa per smussature VENDOR: Sandvik PRODUCT: 1C050-0300-045-XB 1620	

Operation 37/37
DESCRIPTION: 24.4
WCS: #1
TOLERANCE: 0.01mm
STOCK TO LEAVE: 0mm

MAXIMUM SPINDLE SPEED: 2387rpm
MAXIMUM FEEDRATE: 1719mm/min
CUTTING DISTANCE: 63.81mm
RAPID DISTANCE: 28mm
ESTIMATED CYCLE TIME: 3s (0.2%)
COOLANT: Flood

T140 D1 L1
TYPE: chamfer mill
DIAMETER: 12mm
TAPER ANGLE: 45°
LENGTH: 50mm
FLUTES: 6
DESCRIPTION: Fresa per smussature
VENDOR: Sandvik
PRODUCT: [1C050-0300-045-XB 1620](#)



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