

Setup Sheet for Program 1001

JOB DESCRIPTION: Setup1  
DOCUMENT PATH: Fixated machined clamp v12

Setup

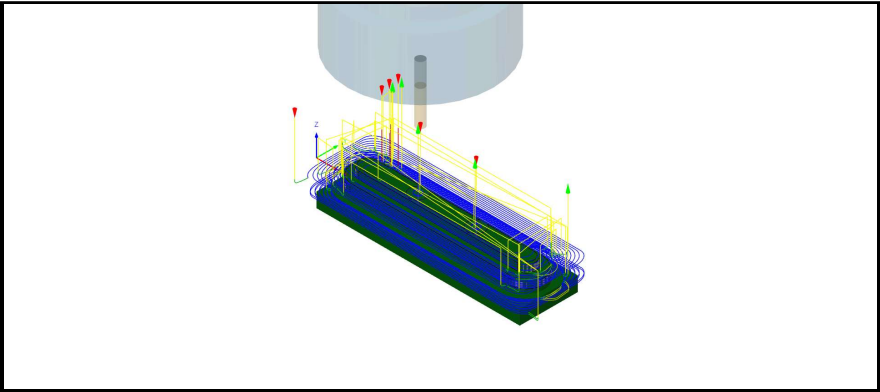
WCS: #0

Stock:  
DX: 70mm  
DY: 20mm  
DZ: 15mm

PART:  
DX: 66.9mm  
DY: 12.4mm  
DZ: 6mm

Stock LOWER IN WCS #0:  
X: 0mm  
Y: 0mm  
Z: -15mm

Stock UPPER IN WCS #0:  
X: 70mm  
Y: 20mm  
Z: 0mm



Total

NUMBER OF OPERATIONS: 6

NUMBER OF TOOLS: 3

TOOLS: T1 T2 T3

MAXIMUM Z: 15mm

MINIMUM Z: -10mm

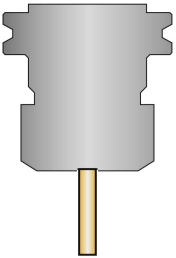
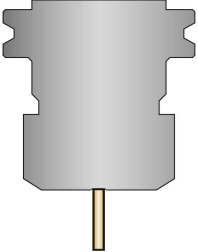
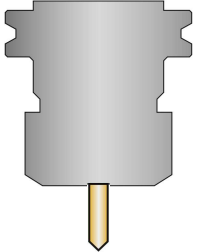
MAXIMUM FEEDRATE: 1500mm/min

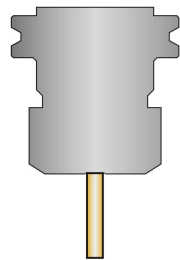
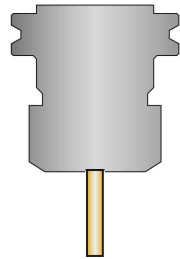
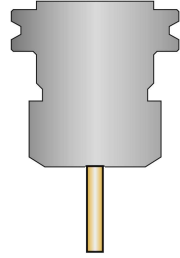
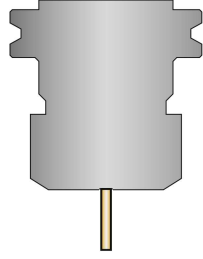
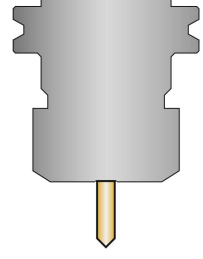
MAXIMUM SPINDLE SPEED: 24000rpm

CUTTING DISTANCE: 7265.78mm

RAPID DISTANCE: 1393.87mm

ESTIMATED CYCLE TIME: 6m:17s

Tools			
<b>T1 D1 L1</b> TYPE: flat end mill DIAMETER: 6mm LENGTH: 32mm FLUTES: 1 DESCRIPTION: 6mm Flat single flute Endmill	MINIMUM Z: -10mm MAXIMUM FEED: 1500mm/min MAXIMUM SPINDLE SPEED: 24000rpm CUTTING DISTANCE: 6331.14mm RAPID DISTANCE: 1180.07mm ESTIMATED CYCLE TIME: 4m:29s (71.3%)	HOLDER: Maritool CAT40-ER32-2.35 VENDOR: Maritool PRODUCT: CAT40-ER32-2.35	
<b>T2 D2 L2</b> TYPE: flat end mill DIAMETER: 3mm LENGTH: 20mm FLUTES: 1 DESCRIPTION: 3mm Flat single flute Endmill	MINIMUM Z: -9.8mm MAXIMUM FEED: 1000mm/min MAXIMUM SPINDLE SPEED: 16000rpm CUTTING DISTANCE: 604.32mm RAPID DISTANCE: 80.32mm ESTIMATED CYCLE TIME: 37s (9.9%)	HOLDER: Maritool CAT40-ER32-2.35 VENDOR: Maritool PRODUCT: CAT40-ER32-2.35	
<b>T3 D3 L3</b> TYPE: spot drill DIAMETER: 6mm TIP ANGLE: 90° LENGTH: 22.5mm FLUTES: 3 DESCRIPTION: 6mm Spot Drill	MINIMUM Z: -7.5mm MAXIMUM FEED: 1000mm/min MAXIMUM SPINDLE SPEED: 20000rpm CUTTING DISTANCE: 330.31mm RAPID DISTANCE: 133.49mm ESTIMATED CYCLE TIME: 26s (6.9%)	HOLDER: Maritool CAT40-ER32-2.35 VENDOR: Maritool PRODUCT: CAT40-ER32-2.35	

Operations			
<b>Operation 1/6</b> <b>DESCRIPTION:</b> Adaptive1 <b>STRATEGY:</b> Adaptive <b>WCS:</b> #0 <b>TOLERANCE:</b> 0.1mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPDOWN:</b> 5mm <b>OPTIMAL LOAD:</b> 0.6mm <b>LOAD DEVIATION:</b> 0.06mm	<b>MAXIMUM Z:</b> 15mm <b>MINIMUM Z:</b> -10mm <b>MAXIMUM SPINDLE SPEED:</b> 24000rpm <b>MAXIMUM FEEDRATE:</b> 1500mm/min <b>CUTTING DISTANCE:</b> 5987.95mm <b>RAPID DISTANCE:</b> 1109.27mm <b>ESTIMATED CYCLE TIME:</b> 4m:13s (67.1%) <b>COOLANT:</b> Flood	<b>T1 D1 L1</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 6mm <b>LENGTH:</b> 32mm <b>FLUTES:</b> 1 <b>DESCRIPTION:</b> 6mm Flat single flute Endmill	
<b>Operation 2/6</b> <b>DESCRIPTION:</b> 2D Contour1 <b>STRATEGY:</b> Contour 2D <b>WCS:</b> #0 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPOVER:</b> 5.7mm	<b>MAXIMUM Z:</b> 15mm <b>MINIMUM Z:</b> -10mm <b>MAXIMUM SPINDLE SPEED:</b> 24000rpm <b>MAXIMUM FEEDRATE:</b> 1500mm/min <b>CUTTING DISTANCE:</b> 183.18mm <b>RAPID DISTANCE:</b> 37.4mm <b>ESTIMATED CYCLE TIME:</b> 9s (2.3%) <b>COOLANT:</b> Flood	<b>T1 D1 L1</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 6mm <b>LENGTH:</b> 32mm <b>FLUTES:</b> 1 <b>DESCRIPTION:</b> 6mm Flat single flute Endmill	
<b>Operation 3/6</b> <b>DESCRIPTION:</b> 2D Contour1 (2) <b>STRATEGY:</b> Contour 2D <b>WCS:</b> #0 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm <b>MAXIMUM STEPOVER:</b> 5.7mm	<b>MAXIMUM Z:</b> 15mm <b>MINIMUM Z:</b> -6mm <b>MAXIMUM SPINDLE SPEED:</b> 24000rpm <b>MAXIMUM FEEDRATE:</b> 1500mm/min <b>CUTTING DISTANCE:</b> 160.01mm <b>RAPID DISTANCE:</b> 33.4mm <b>ESTIMATED CYCLE TIME:</b> 7s (2%) <b>COOLANT:</b> Flood	<b>T1 D1 L1</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 6mm <b>LENGTH:</b> 32mm <b>FLUTES:</b> 1 <b>DESCRIPTION:</b> 6mm Flat single flute Endmill	
<b>Operation 4/6</b> <b>DESCRIPTION:</b> Bore1 <b>STRATEGY:</b> Bore <b>WCS:</b> #0 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm	<b>MAXIMUM Z:</b> 15mm <b>MINIMUM Z:</b> -9.8mm <b>MAXIMUM SPINDLE SPEED:</b> 16000rpm <b>MAXIMUM FEEDRATE:</b> 1000mm/min <b>CUTTING DISTANCE:</b> 604.32mm <b>RAPID DISTANCE:</b> 80.32mm <b>ESTIMATED CYCLE TIME:</b> 37s (9.9%) <b>COOLANT:</b> Flood	<b>T2 D2 L2</b> <b>TYPE:</b> flat end mill <b>DIAMETER:</b> 3mm <b>LENGTH:</b> 20mm <b>FLUTES:</b> 1 <b>DESCRIPTION:</b> 3mm Flat single flute Endmill	
<b>Operation 5/6</b> <b>DESCRIPTION:</b> 2D Chamfer1 <b>WCS:</b> #0 <b>TOLERANCE:</b> 0.01mm <b>STOCK TO LEAVE:</b> 0mm	<b>MAXIMUM Z:</b> 15mm <b>MINIMUM Z:</b> -7.5mm <b>MAXIMUM SPINDLE SPEED:</b> 20000rpm <b>MAXIMUM FEEDRATE:</b> 1000mm/min <b>CUTTING DISTANCE:</b> 314.71mm <b>RAPID DISTANCE:</b> 65.09mm <b>ESTIMATED CYCLE TIME:</b> 22s (5.9%) <b>COOLANT:</b> Flood	<b>T3 D3 L3</b> <b>TYPE:</b> spot drill <b>DIAMETER:</b> 6mm <b>TIP ANGLE:</b> 90° <b>LENGTH:</b> 22.5mm <b>FLUTES:</b> 3 <b>DESCRIPTION:</b> 6mm Spot Drill	
<b>Operation 6/6</b> <b>DESCRIPTION:</b> Drill1 <b>STRATEGY:</b> Drilling <b>WCS:</b> #0 <b>TOLERANCE:</b> 0.01mm	<b>MAXIMUM Z:</b> 15mm <b>MINIMUM Z:</b> -6mm <b>MAXIMUM SPINDLE SPEED:</b> 20000rpm <b>MAXIMUM FEEDRATE:</b> 333.333mm/min <b>CUTTING DISTANCE:</b> 15.6mm <b>RAPID DISTANCE:</b> 68.4mm <b>ESTIMATED CYCLE TIME:</b> 4s (1%) <b>COOLANT:</b> Flood	<b>T3 D3 L3</b> <b>TYPE:</b> spot drill <b>DIAMETER:</b> 6mm <b>TIP ANGLE:</b> 90° <b>LENGTH:</b> 22.5mm <b>FLUTES:</b> 3 <b>DESCRIPTION:</b> 6mm Spot Drill	