

Setup Sheet for Program 1001

JOB DESCRIPTION: Setup4  
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

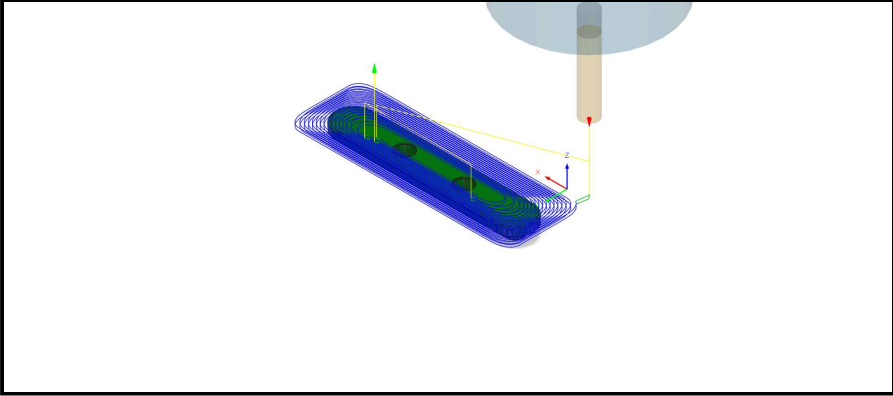
Z: -15mm

STOCK UPPER IN WCS #0:

X: 70mm

Y: 20mm

Z: 0mm



Total

NUMBER OF OPERATIONS: 1

NUMBER OF TOOLS: 1

TOOLS: T1

MAXIMUM Z: 15mm

MINIMUM Z: -6mm

MAXIMUM FEEDRATE: 1500mm/min

MAXIMUM SPINDLE SPEED: 24000rpm

CUTTING DISTANCE: 4977.01mm

RAPID DISTANCE: 225.27mm

ESTIMATED CYCLE TIME: 3m:37s

Tools

**T1 D1 L1**

TYPE: flat end mill

DIAMETER: 6mm

LENGTH: 32mm

FLUTES: 1

DESCRIPTION: 6mm Flat single flute Endmill

MINIMUM Z: -6mm

MAXIMUM FEED: 1500mm/min

MAXIMUM SPINDLE SPEED: 24000rpm

CUTTING DISTANCE: 4977.01mm

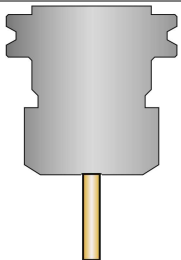
RAPID DISTANCE: 225.27mm

ESTIMATED CYCLE TIME: 3m:22s

HOLDER: Maritool CAT40-ER32-2.35

VENDOR: Maritool

PRODUCT: CAT40-ER32-2.35



Operations

Operation 1/1

DESCRIPTION: Adaptive3

STRATEGY: Adaptive

WCS: #0

TOLERANCE: 0.1mm

STOCK TO LEAVE: 0mm

MAXIMUM STEPDOWN: 5mm

OPTIMAL LOAD: 0.6mm

LOAD DEVIATION: 0.06mm

MAXIMUM Z: 15mm

MINIMUM Z: -6mm

MAXIMUM SPINDLE SPEED: 24000rpm

MAXIMUM FEEDRATE: 1500mm/min

CUTTING DISTANCE: 4977.01mm

RAPID DISTANCE: 225.27mm

ESTIMATED CYCLE TIME: 3m:22s

COOLANT: Flood

**T1 D1 L1**

TYPE: flat end mill

DIAMETER: 6mm

LENGTH: 32mm

FLUTES: 1

DESCRIPTION: 6mm Flat single flute Endmill

