

Setup Sheet for Program 1001

JOB DESCRIPTION: Setup5
DOCUMENT PATH: Fixated machined clamp v12

Setup

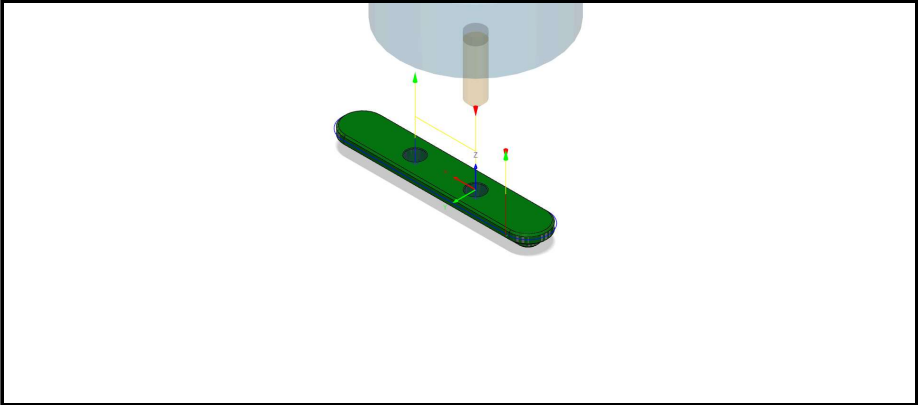
WCS: #0

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

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

STOCK LOWER IN WCS #0:
X: -25mm
Y: -10mm
Z: -9mm

STOCK UPPER IN WCS #0:
X: 45mm
Y: 10mm
Z: 6mm



Total

NUMBER OF OPERATIONS: 2

NUMBER OF TOOLS: 1

TOOLS: T3

MAXIMUM Z: 21mm

MINIMUM Z: -3mm

MAXIMUM FEEDRATE: 1000mm/min

MAXIMUM SPINDLE SPEED: 20000rpm

CUTTING DISTANCE: 179.9mm

RAPID DISTANCE: 112.4mm

ESTIMATED CYCLE TIME: 30s

Tools

T3 D3 L3

TYPE: spot drill

DIAMETER: 6mm

TIP ANGLE: 90°

LENGTH: 22.5mm

FLUTES: 3

DESCRIPTION: 6mm Spot Drill

MINIMUM Z: -3mm

MAXIMUM FEED: 1000mm/min

MAXIMUM SPINDLE SPEED: 20000rpm

CUTTING DISTANCE: 179.9mm

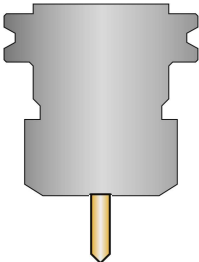
RAPID DISTANCE: 112.4mm

ESTIMATED CYCLE TIME: 15s (50.7%)

HOLDER: Maritool CAT40-ER32-2.35

VENDOR: Maritool

PRODUCT: CAT40-ER32-2.35



Operations

Operation 1/2

DESCRIPTION: 2D Chamfer4

WCS: #0

TOLERANCE: 0.01mm

STOCK TO LEAVE: 0mm

MAXIMUM Z: 21mm

MINIMUM Z: -1mm

MAXIMUM SPINDLE SPEED: 20000rpm

MAXIMUM FEEDRATE: 1000mm/min

CUTTING DISTANCE: 164.3mm

RAPID DISTANCE: 32mm

ESTIMATED CYCLE TIME: 12s (38.4%)

COOLANT: Flood

T3 D3 L3

TYPE: spot drill

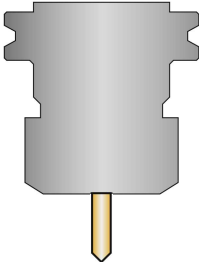
DIAMETER: 6mm

TIP ANGLE: 90°

LENGTH: 22.5mm

FLUTES: 3

DESCRIPTION: 6mm Spot Drill



file:///C:/Users/dmaso/Downloads/Fixated machined clamp v12.html

1/2

Operation 2/2

DESCRIPTION: Drill1 (2)
STRATEGY: Drilling
WCS: #0
TOLERANCE: 0.01mm

MAXIMUM Z: 21mm
MINIMUM Z: -3mm
MAXIMUM SPINDLE SPEED: 20000rpm
MAXIMUM FEEDRATE: 333.333mm/min
CUTTING DISTANCE: 15.6mm
RAPID DISTANCE: 80.4mm
ESTIMATED CYCLE TIME: 4s (12.4%)
COOLANT: Flood

T3 D3 L3
TYPE: spot drill
DIAMETER: 6mm
TIP ANGLE: 90°
LENGTH: 22.5mm
FLUTES: 3
DESCRIPTION: 6mm Spot Drill

