



SET-UP SCHEDULE GENERAL DATA

User
07.04.2023
TruTops Laser
V08.01.01

MACHINE:	TruLaser 3030 (L20) (MAX. LASER POWER 5000 WATT)
CONTROL:	Sin 840D
FIRMA:	Trumpf
JOB NAME:	Unnamed
NC PROGRAM PATH:	/ TRUMPF.NET/ Workfiles/ User1/ PETER/ TEST_progra_izvoz/ 1560-P00-594_SAP 320417_XK.LST
PROGRAM NAME:	TEST_1 ()
MATERIAL (SHEET):	St37-30 (1.0038)
MATERIAL (TT):	St37-30 (1.0038)
STORAGE ITEM DESIGNATION:	
STORAGE LOCATION	
BLANK:	2906.15 x 818.07 x 3.00 mm
MINIMUM BLANK:	2886.15 x 798.07 mm
GRAIN:	X
WEIGHT:	55.99 kg
MACHINING TIME:	0 : 11 : 58 [h:min:s] (PierceLine: 0 : 11 : 37 [h:min:s])
STORAGE REQUIREMENT:	29996 CHARACTERS
TOTAL CUTTING LENGTH:	43787.3 mm
NUMBER OF PROGRAMME RUNS:	1
SCRAP:	65.69 %

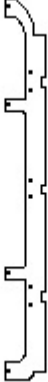
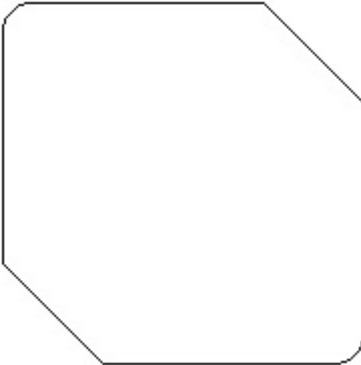

MACHINING INSTRUCTIONS

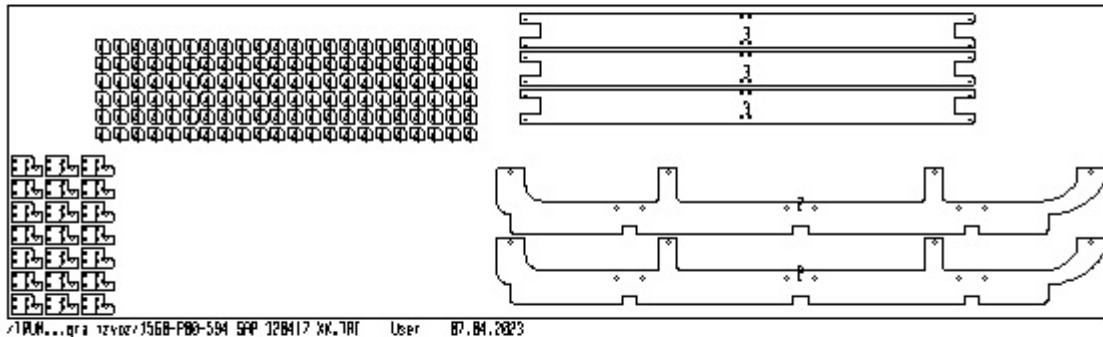
SHEET STOP:	
MICROJOINTS, CHANGEABLE ON THE MACHINE:	not set
NAME OF SLAT ASSIGNMENT:	Standard machine, every second set
DISTANCE OF SUPPORT POINTS ON THE SLAT:	38 mm
SLAT DISTANCE:	67 mm
ANTICIPATE PROCESSINGS:	without
Contours programmed with path correction!	
REMARKS:	

INFORMATION ON SINGLE PART

	PART NUMBER:	1
	DRAWING NUMBER:	NOID_1
	NAME OF DRAWING:	
	CUSTOMER NAME:	none
	NUMBER:	21 <i>← STEVILLO</i>
	DIMENSIONS:	82.541 x 50.541 mm <i>← 2x2x17.5</i>
	SURFACE:	3199.04 mm ² <i>← INVAJUNATI ZA PARVANJE</i>
	RULE NAME:	5P
	SUBROUTINE NUMBER:	SP1TEST_1
	MACHINING TIME:	0.12 min (PierceLine: 0.12 min) <i>← 2x2x17.5</i>
	CUTTING LENGTH:	399.311 mm
	WEIGHT:	0.075 kg <i>← MASA</i>
	NUMBER OF PIERCING POINTS:	6
	PIERCING TIME	0.60 (PierceLine: 0.20) s
	GEOFILE NAME:	/ TRUMPF.NET/ Workfiles/ User1/ PETER/ TEST_progra_izvoz/ 2016-R13-35_317486_XK.GEO

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	PART NUMBER:	2
	DRAWING NUMBER:	NOID_2
	NAME OF DRAWING:	
	CUSTOMER NAME:	none
	NUMBER:	2
	DIMENSIONS:	173.482 x 1600.000 mm
	SURFACE:	143388.55 mm2
	RULE NAME:	5P
	SUBROUTINE NUMBER:	SP2TEST_1
	MACHINING TIME:	1.00 min (PierceLine: 0.98 min)
	CUTTING LENGTH:	4337.27 mm
	WEIGHT:	3.377 kg
	NUMBER OF PIERCING POINTS:	11
	PIERCING TIME	1.10 (PierceLine: 0.37) s
	GEOFILE NAME:	/ TRUMPF.NET/ Workfiles/ User1/ PETER/ TEST_progra_izvoz/ 2015- R07-242_r.01_120k.GEO
	PART NUMBER:	4
	DRAWING NUMBER:	NOID_4
	NAME OF DRAWING:	
	CUSTOMER NAME:	none
	NUMBER:	132
	DIMENSIONS:	36.000 x 36.000 mm
	SURFACE:	1192.14 mm2
	RULE NAME:	5P
	SUBROUTINE NUMBER:	SP3TEST_1
	MACHINING TIME:	0.03 min (PierceLine: 0.03 min)
	CUTTING LENGTH:	134.395 mm
	WEIGHT:	0.028 kg
	NUMBER OF PIERCING POINTS:	1
	PIERCING TIME	0.10 (PierceLine: 0.03) s
	GEOFILE NAME:	/ TRUMPF.NET/ Workfiles/ User1/ PETER/ TEST_progra_izvoz/ 1560-P00-594_SAP 320417_XK.GEO
	PART NUMBER:	3
	DRAWING NUMBER:	NOID_3
	NAME OF DRAWING:	
	CUSTOMER NAME:	none
	NUMBER:	3
	DIMENSIONS:	88.988 x 1192.988 mm
	SURFACE:	101493.87 mm2
	RULE NAME:	5P
	SUBROUTINE NUMBER:	SP4TEST_1
	MACHINING TIME:	0.68 min (PierceLine: 0.68 min)
	CUTTING LENGTH:	2995.72 mm
	WEIGHT:	2.390 kg
	NUMBER OF PIERCING POINTS:	9
	PIERCING TIME	0.90 (PierceLine: 0.30) s
	GEOFILE NAME:	/ TRUMPF.NET/ Workfiles/ User1/ PETER/ TEST_progra_izvoz/ 2015- R07-204_r.02_105k.GEO



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