

Setup Sheet for Program SA_Card_Holder

DOCUMENT PATH: D:\Lab5-6\SA_Card_Holder.SLDPRT

Setup

WCS: #0

STOCK:

DX: 3in

DY: 3in

DZ: 2in

PART:

DX: 3in

DY: 3in

DZ: 2in

STOCK LOWER IN WCS #0:

X: 0in

Y: -3in

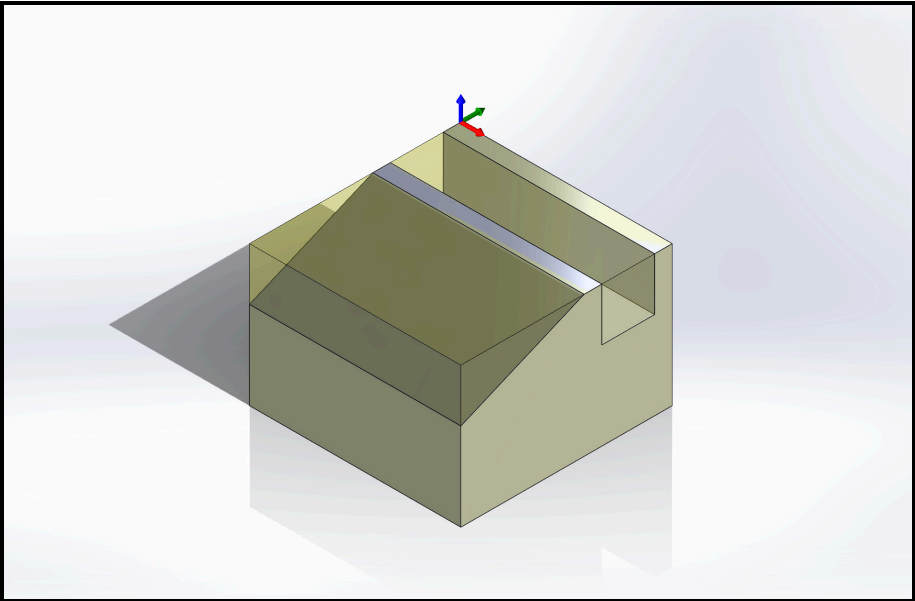
Z: -2in

STOCK UPPER IN WCS #0:

X: 3in

Y: 0in

Z: 0in



Total

NUMBER OF OPERATIONS: 2

NUMBER OF TOOLS: 2

TOOLS: T3 T8

MAXIMUM Z: 0.6in

MINIMUM Z: -0.745in

MAXIMUM FEEDRATE: 40in/min

MAXIMUM SPINDLE SPEED: 5000rpm

CUTTING DISTANCE: 1004.595in

RAPID DISTANCE: 572.224in

ESTIMATED CYCLE TIME: 26m:32s

Tools

T3 D3 L3

MANUAL TOOL CHANGE

TYPE: flat end mill

DIAMETER: 0.25in

LENGTH: 1.2in

FLUTES: 3

VENDOR: SGS Tool

PRODUCT: 30786

MINIMUM Z: -0.709in

MAXIMUM FEED: 40in/min

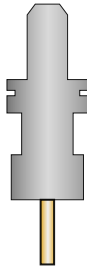
MAXIMUM SPINDLE SPEED: 5000rpm

CUTTING DISTANCE: 169.253in

RAPID DISTANCE: 109.894in

ESTIMATED CYCLE TIME: 4m:15s (16%)

HOLDER: TTS Collet



T8 D8 L8

MANUAL TOOL CHANGE

TYPE: ball end mill

DIAMETER: 0.125in

CORNER RADIUS: 0.062in

LENGTH: 0.85in

FLUTES: 3

VENDOR: Melin Tool

PRODUCT: 47825

MINIMUM Z: -0.745in

MAXIMUM FEED: 40in/min

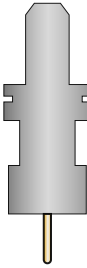
MAXIMUM SPINDLE SPEED: 5000rpm

CUTTING DISTANCE: 835.342in

RAPID DISTANCE: 462.33in

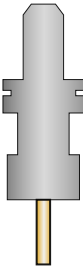
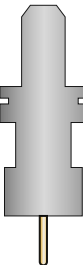
ESTIMATED CYCLE TIME: 21m:47s (82.1%)

HOLDER: TTS Collet



file:///D:/Lab5-6/SA_Card_Holder.html

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Operations			
Operation 1/2		T3 D3 L3	
DESCRIPTION: Adaptive1	MAXIMUM Z: 0.6in	MANUAL TOOL CHANGE	
STRATEGY: Adaptive	MINIMUM Z: -0.709in	TYPE: flat end mill	
WCS: #0	MAXIMUM SPINDLE SPEED: 5000rpm	DIAMETER: 0.25in	
TOLERANCE: 0.004in	MAXIMUM FEEDRATE: 40in/min	LENGTH: 1.2in	
STOCK TO LEAVE: 0.02in	CUTTING DISTANCE: 169.253in	FLUTES: 3	
MAXIMUM STEPDOWN: 0.394in	RAPID DISTANCE: 109.894in	VENDOR: SGS Tool	
OPTIMAL LOAD: 0.1in	ESTIMATED CYCLE TIME: 4m:15s (16%)	PRODUCT: 30786	
LOAD DEVIATION: 0.01in	COOLANT: Flood		
Operation 2/2		T8 D8 L8	
DESCRIPTION: Scallop1	MAXIMUM Z: 0.6in	MANUAL TOOL CHANGE	
STRATEGY: Scallop	MINIMUM Z: -0.745in	TYPE: ball end mill	
WCS: #0	MAXIMUM SPINDLE SPEED: 5000rpm	DIAMETER: 0.125in	
TOLERANCE: 0in	MAXIMUM FEEDRATE: 40in/min	CORNER RADIUS: 0.062in	
STOCK TO LEAVE: 0in	CUTTING DISTANCE: 835.342in	LENGTH: 0.85in	
MAXIMUM STEPOVER: 0.009in	RAPID DISTANCE: 462.33in	FLUTES: 3	
	ESTIMATED CYCLE TIME: 21m:47s (82.1%)	VENDOR: Melin Tool	
	COOLANT: Flood	PRODUCT: 47825	