Mastercam

Setup Sheet Report

Lathe Default

GENERAL INFORMATION

PROJECT NAME:	ABC Test Project	
CUSTOMER NAME:	ABC Manufactoring Company	
PROGRAMMER:	Mick George	
DRAWING:	12345	REVISION: A
DATE:	Tuesday, May 23, 2017	
TIME:	2:04 PM	

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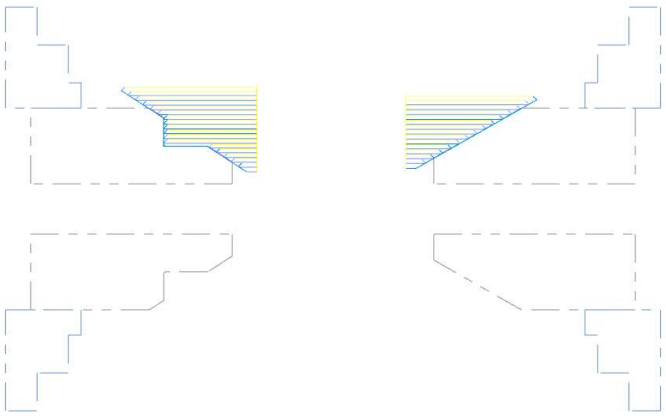

COMMENTS

CHUCK / STOCK

CHUCK (LEFT):	YES
GRIP LENGTH:	0.0
HEIGHT:	2.0
WIDTH:	1.5
THICKNESS:	0.625
REFERENCE:	X-3.0, Z2.0
HSTEP:	0.25
VSTEP:	0.5

CHUCK (RIGHT):	YES
GRIP LENGTH:	0.0
HEIGHT:	2.0
WIDTH:	1.5
THICKNESS:	0.625
REFERENCE:	X7.0, Z2.0
HSTEP:	0.25
VSTEP:	0.5

STOCK (LEFT):	YES
OUTSIDE DIAMETER:	4.0
INSIDE DIAMETER:	1.0
LENGTH:	4.0
Z REFERENCE:	0.0

STOCK (RIGHT):	YES
OUTSIDE DIAMETER:	4.0
INSIDE DIAMETER:	1.0
LENGTH:	4.0
Z REFERENCE:	4.0

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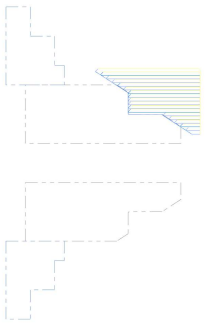
CYCLE TIME: 0 HOURS, 23 MINUTES, 21 SECONDS

OPERATION LIST

OPERATION INFO ***1 - Lathe Rough***

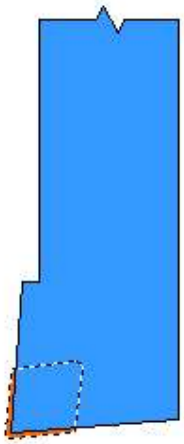
CYCLE TIME:	0 HOURS, 13 MINUTES, 40 SECONDS
COMMENT:	

SPINDLE SPEED:	200 CSS
FAST FEED:	0.01 inch/rev
SLOW FEED:	0.005 inch/rev
STOCK TO LEAVE (X):	0.01
STOCK TO LEAVE (Z):	0.01
RETRACT ACTIVE:	NO
ENTRY ACTIVE:	NO
COOLANT:	Flood



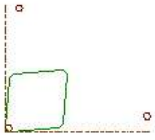
TOOL INFO ***T0101: General Turning Tool - OD ROUGH RIGHT - 80 DEG.***

TOP TURRET:	YES
ACTIVE SPINDLE:	Left
SPINDLE DIRECTION:	CCW
SPINDLE SPEED:	200 CSS
FAST FEED:	0.01 inch/rev
SLOW FEED:	0.005 inch/rev
OFFSET:	1
OFFSET (BACK):	NA
INSERT UP:	NO
COOLANT:	Flood
TIME:	00:13:40



HOLDER:	DCGNR-164D	
LENGTH:	6.0	
WIDTH:	1.25	
ORIENTATION:	Vertical	ANGLE: 0.0
HAND:	Right	

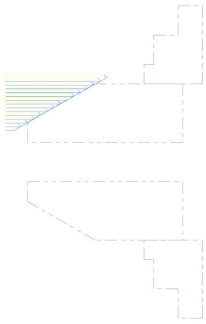
INSERT:	CNMG-432
SHAPE:	C (80 deg. diamond)
RADIUS:	0.0313
MATERIAL:	Carbide



OPERATION INFO ***2 - Lathe Rough***

CYCLE TIME:	0 HOURS, 9 MINUTES, 41 SECONDS
COMMENT:	

SPINDLE SPEED:	200 CSS
FAST FEED:	0.01 inch/rev
SLOW FEED:	0.005 inch/rev
STOCK TO LEAVE (X):	0.01
STOCK TO LEAVE (Z):	0.01
RETRACT ACTIVE:	NO
ENTRY ACTIVE:	NO
COOLANT:	Off



TOOL INFO ***T0202: General Turning Tool - OD FINISH RIGHT - 35 DEG.***

TOP TURRET:	YES
ACTIVE SPINDLE:	Right
SPINDLE DIRECTION:	CCW
SPINDLE SPEED:	200 CSS
FAST FEED:	0.01 inch/rev
SLOW FEED:	0.005 inch/rev
OFFSET:	2
OFFSET (BACK):	NA
INSERT UP:	YES
COOLANT:	Off
TIME:	00:09:41

HOLDER:	MVJNR-164D	
LENGTH:	6.0	
WIDTH:	1.25	
ORIENTATION:	Vertical	ANGLE: 0.0
HAND:	Right	

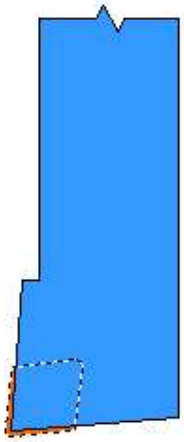
INSERT:	VNMG-431
SHAPE:	V (35 deg. diamond)
RADIUS:	0.0156
MATERIAL:	Carbide

TOOL LIST

Sorted: NO

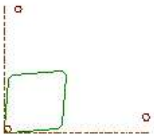
TOOL INFO ***T0101: General Turning Tool - OD ROUGH RIGHT - 80 DEG.***

TOP TURRET:	YES
ACTIVE SPINDLE:	Left
SPINDLE DIRECTION:	CCW
SPINDLE SPEED:	200 CSS
FAST FEED:	0.01 inch/rev
SLOW FEED:	0.005 inch/rev
OFFSET:	1
OFFSET (BACK):	NA
INSERT UP:	NO
COOLANT:	Flood
TIME:	00:13:40



HOLDER:	DCGNR-164D
LENGTH:	6.0
WIDTH:	1.25
ORIENTATION:	Vertical ANGLE: 0.0
HAND:	Right

INSERT:	CNMG-432
SHAPE:	C (80 deg. diamond)
RADIUS:	0.0313
MATERIAL:	Carbide



USED BY OPERATION: # 1 1 - Lathe Rough

TOOL INFO ***T0202: General Turning Tool - OD FINISH RIGHT - 35 DEG.***

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ACTIVE SPINDLE:	Right
SPINDLE DIRECTION:	CCW
SPINDLE SPEED:	200 CSS
FAST FEED:	0.01 inch/rev
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OFFSET:	2
OFFSET (BACK):	NA
INSERT UP:	YES
COOLANT:	Off
TIME:	00:09:41

HOLDER:	MVJNR-164D
LENGTH:	6.0
WIDTH:	1.25
ORIENTATION:	Vertical ANGLE: 0.0
HAND:	Right

INSERT:	VNMG-431
SHAPE:	V (35 deg. diamond)
RADIUS:	0.0156
MATERIAL:	Carbide

USED BY OPERATION: # 2 2 - Lathe Rough

WORK OFFSETS

OFFSET INFO

NUMBER: -1 PLANE: ORIGIN: X0.0, Z0.0

USED BY OPERATION: # 1 1 - Lathe Rough

USED BY OPERATION: # 2 2 - Lathe Rough