

Setup Sheet for Program 1001

JOB DESCRIPTION: ZAM1

DOCUMENT PATH: PN-MW-40 Mocowanie wału d44 - do poprawy pod Boscha (v1~recovered)

Setup

WCS: #0

Stock:

DX: 42mm

DY: 162mm

DZ: 21mm

PART:

DX: 40mm

DY: 160mm

DZ: 20mm

STOCK LOWER IN WCS #0:

X: 0mm

Y: 0mm

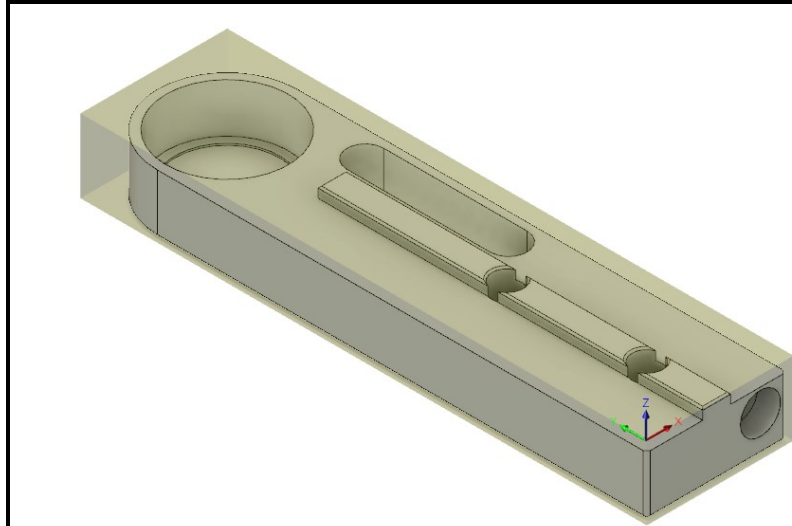
Z: -21mm

STOCK UPPER IN WCS #0:

X: 42mm

Y: 162mm

Z: 0mm



Total

NUMBER OF OPERATIONS: 2

NUMBER OF TOOLS: 2

TOOLS: T1 T8

MAXIMUM Z: 15mm

MINIMUM Z: -21.09mm

MAXIMUM FEEDRATE: 1000mm/min

MAXIMUM SPINDLE SPEED: 5000rpm

CUTTING DISTANCE: 5886.79mm

RAPID DISTANCE: 1668.02mm

ESTIMATED CYCLE TIME: 9m:28s

Tools

T1 D1 L1

TYPE: flat end mill MINIMUM Z: -21.09mm

DIAMETER: 16mm MAXIMUM FEED: 1000mm/min

LENGTH: 80mm MAXIMUM SPINDLE SPEED: 5000rpm

FLUTES: 3 CUTTING DISTANCE: 4490.06mm

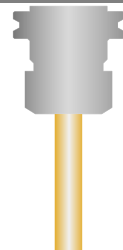
RAPID DISTANCE: 1627.12mm

ESTIMATED CYCLE TIME: 6m:5s (64.3%)

HOLDER: Maritool CAT40-ER32-2.35

VENDOR: Maritool

PRODUCT: CAT40-ER32-2.35



T8 D8 L8

TYPE: flat end mill MINIMUM Z: -15.9mm

DIAMETER: 10mm MAXIMUM FEED: 1000mm/min

LENGTH: 50mm MAXIMUM SPINDLE SPEED: 5000rpm

FLUTES: 4 CUTTING DISTANCE: 1396.73mm

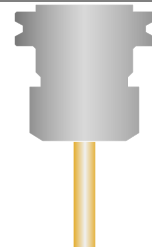
RAPID DISTANCE: 40.9mm

ESTIMATED CYCLE TIME: 2m:53s (30.4%)

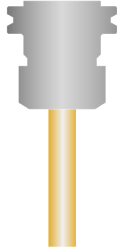
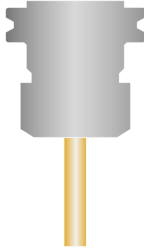
HOLDER: Maritool CAT40-ER32-2.35

VENDOR: Maritool

PRODUCT: CAT40-ER32-2.35



Operations

Operation 1/2		T1 D1 L1	
DESCRIPTION: Adaptive1	MAXIMUM Z: 15mm	TYPE: flat end mill	
STRATEGY: Adaptive	MINIMUM Z: -21.09mm	DIAMETER: 16mm	
WCS: #0	MAXIMUM SPINDLE SPEED: 5000rpm	LENGTH: 80mm	
TOLERANCE: 0.1mm	MAXIMUM FEEDRATE: 1000mm/min	FLUTES: 3	
STOCK TO LEAVE: -0.1mm	CUTTING DISTANCE: 4490.06mm		
MAXIMUM STEPDOWN: 20mm	RAPID DISTANCE: 1627.12mm		
OPTIMAL LOAD: 2mm	ESTIMATED CYCLE TIME: 6m:5s (64.3%)		
LOAD DEVIATION: 0.2mm	COOLANT: Flood		
Operation 2/2		T8 D8 L8	
DESCRIPTION: Slot1	MAXIMUM Z: 15mm	TYPE: flat end mill	
STRATEGY: Slot	MINIMUM Z: -15.9mm	DIAMETER: 10mm	
WCS: #0	MAXIMUM SPINDLE SPEED: 5000rpm	LENGTH: 50mm	
TOLERANCE: 0.01mm	MAXIMUM FEEDRATE: 1000mm/min	FLUTES: 4	
MAXIMUM STEPDOWN: 1mm	CUTTING DISTANCE: 1396.73mm		
MAXIMUM STEPOVER: 5mm	RAPID DISTANCE: 40.9mm		
	ESTIMATED CYCLE TIME: 2m:53s (30.4%)		
	COOLANT: Flood		