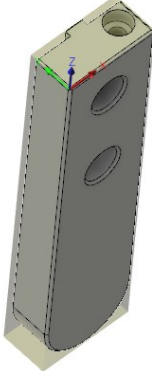


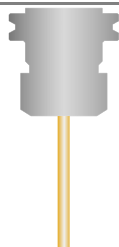
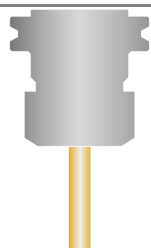
# Setup Sheet for Program 1001

JOB DESCRIPTION: ZAM3

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

Setup	
<p>WCS: #0</p> <p>Stock:</p> <p>DX: 40mm</p> <p>DY: 20mm</p> <p>DZ: 160mm</p> <p>PART:</p> <p>DX: 40mm</p> <p>DY: 20mm</p> <p>DZ: 160mm</p> <p>Stock LOWER IN WCS #0:</p> <p>X: 0mm</p> <p>Y: 0mm</p> <p>Z: -160mm</p> <p>Stock UPPER IN WCS #0:</p> <p>X: 40mm</p> <p>Y: 20mm</p> <p>Z: 0mm</p>	

Total
<p>NUMBER OF OPERATIONS: 2</p> <p>NUMBER OF TOOLS: 2</p> <p>TOOLS: <b>T3 T8</b></p> <p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -71.88mm</p> <p>MAXIMUM FEEDRATE: 700mm/min</p> <p>MAXIMUM SPINDLE SPEED: 2800rpm</p> <p>CUTTING DISTANCE: 132.99mm</p> <p>RAPID DISTANCE: 856mm</p> <p>ESTIMATED CYCLE TIME: 1m:20s</p>

Tools			
<b>T3 D3 L3</b>			
TYPE: drill	MINIMUM Z: -71.88mm	HOLDER: Maritool CAT40-ER32-2.35	
DIAMETER: 7mm	MAXIMUM FEED: 140mm/min	VENDOR: Maritool	
TIP ANGLE: 118°	MAXIMUM SPINDLE SPEED: 1400rpm	PRODUCT: CAT40-ER32-2.35	
LENGTH: 80mm	CUTTING DISTANCE: 77.75mm		
FLUTES: 3	RAPID DISTANCE: 726mm		
	ESTIMATED CYCLE TIME: 42s (52.7%)		
<b>T8 D8 L8</b>			
TYPE: flat end mill	MINIMUM Z: -6.5mm	HOLDER: Maritool CAT40-ER32-2.35	
DIAMETER: 10mm	MAXIMUM FEED: 700mm/min	VENDOR: Maritool	
LENGTH: 50mm	MAXIMUM SPINDLE SPEED: 2800rpm	PRODUCT: CAT40-ER32-2.35	
FLUTES: 4	CUTTING DISTANCE: 55.23mm		
	RAPID DISTANCE: 130mm		
	ESTIMATED CYCLE TIME: 8s (9.7%)		

Operations

Operation 1/2		<b>T3 D3 L3</b>	
DESCRIPTION: Drill3	MAXIMUM Z: 15mm	TYPE: drill	
STRATEGY: Drilling	MINIMUM Z: -71.88mm	DIAMETER: 7mm	
WCS: #0	MAXIMUM SPINDLE SPEED: 1400rpm	TIP ANGLE: 118°	
TOLERANCE: 0.01mm	MAXIMUM FEEDRATE: 140mm/min	LENGTH: 80mm	
	CUTTING DISTANCE: 77.75mm	FLUTES: 3	
	RAPID DISTANCE: 726mm		
	ESTIMATED CYCLE TIME: 42s (52.7%)		
	COOLANT: Flood		
Operation 2/2		<b>T8 D8 L8</b>	
DESCRIPTION: Circular1 (2)	MAXIMUM Z: 9mm	TYPE: flat end mill	
STRATEGY: Circular	MINIMUM Z: -6.5mm	DIAMETER: 10mm	
WCS: #0	MAXIMUM SPINDLE SPEED: 2800rpm	LENGTH: 50mm	
STOCK TO LEAVE: 0mm	MAXIMUM FEEDRATE: 700mm/min	FLUTES: 4	
MAXIMUM STEPDOWN: 1mm	CUTTING DISTANCE: 55.23mm		
	RAPID DISTANCE: 130mm		
	ESTIMATED CYCLE TIME: 8s (9.7%)		
	COOLANT: Flood		

