

Setup Sheet for Program 1001

JOB DESCRIPTION: ZAM2

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: -162mm

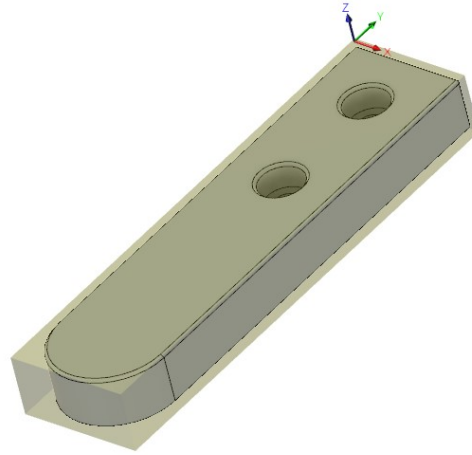
Z: -21mm

STOCK UPPER IN WCS #0:

X: 42mm

Y: 0mm

Z: 0mm



Total

NUMBER OF OPERATIONS: 4

NUMBER OF TOOLS: 4

TOOLS: T1 T3 T5 T8

MAXIMUM FEEDRATE: 1000mm/min

MAXIMUM SPINDLE SPEED: 5000rpm

CUTTING DISTANCE: 1658.35mm

RAPID DISTANCE: 586.13mm

ESTIMATED CYCLE TIME: 2m:47s

Tools

T1 D1 L1

TYPE: flat end mill

MAXIMUM FEED: 1000mm/min

HOLDER: Maritool CAT40-ER32-2.35

DIAMETER: 16mm

MAXIMUM SPINDLE SPEED: 5000rpm

VENDOR: Maritool

LENGTH: 80mm

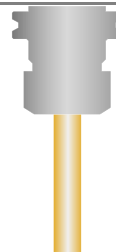
CUTTING DISTANCE: 659.03mm

PRODUCT: CAT40-ER32-2.35

FLUTES: 3

RAPID DISTANCE: 24.4mm

ESTIMATED CYCLE TIME: 40s (23.8%)



T3 D3 L3

TYPE: drill

MAXIMUM FEED: 1000mm/min

HOLDER: Maritool CAT40-ER32-2.35

DIAMETER: 8.5mm

MAXIMUM SPINDLE SPEED: 5000rpm

VENDOR: Maritool

TIP ANGLE: 118°

CUTTING DISTANCE: 68mm

PRODUCT: CAT40-ER32-2.35

LENGTH: 110.5mm

RAPID DISTANCE: 134mm

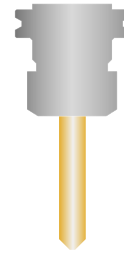
FLUTES: 3

ESTIMATED CYCLE TIME: 6s (3.4%)

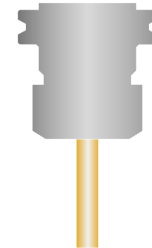


T5 D5 L5

TYPE: chamfer mill MAXIMUM FEED: 1000mm/min HOLDER: Maritool CAT40-ER32-2.35
DIAMETER: 15mm MAXIMUM SPINDLE SPEED: 5000rpm VENDOR: Maritool
TAPER ANGLE: 45° CUTTING DISTANCE: 409.01mm PRODUCT: CAT40-ER32-2.35
LENGTH: 75mm RAPID DISTANCE: 11.5mm
FLUTES: 3 ESTIMATED CYCLE TIME: 26s (15.3%)

**T8 D8 L8**

TYPE: flat end mill MAXIMUM FEED: 1000mm/min HOLDER: Maritool CAT40-ER32-2.35
DIAMETER: 10mm MAXIMUM SPINDLE SPEED: 5000rpm VENDOR: Maritool
LENGTH: 50mm CUTTING DISTANCE: 522.32mm PRODUCT: CAT40-ER32-2.35
FLUTES: 4 RAPID DISTANCE: 416.23mm
ESTIMATED CYCLE TIME: 36s (21.7%)

**Operations****Operation 1/4**

DESCRIPTION: Face4

STRATEGY: Facing

WCS: #0

TOLERANCE: 0.01mm

MAXIMUM STEPOVER: 15.2mm

MAXIMUM SPINDLE SPEED: 5000rpm

MAXIMUM FEEDRATE: 1000mm/min

CUTTING DISTANCE: 659.03mm

RAPID DISTANCE: 24.4mm

ESTIMATED CYCLE TIME: 40s (23.8%)

COOLANT: Flood

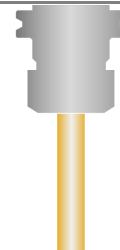
T1 D1 L1

TYPE: flat end mill

DIAMETER: 16mm

LENGTH: 80mm

FLUTES: 3

**Operation 2/4**

DESCRIPTION: Circular1

STRATEGY: Circular

WCS: #0

STOCK TO LEAVE: 0mm

MAXIMUM STEPDOWN: 1mm

MAXIMUM SPINDLE SPEED: 5000rpm

MAXIMUM FEEDRATE: 1000mm/min

CUTTING DISTANCE: 522.32mm

RAPID DISTANCE: 416.23mm

ESTIMATED CYCLE TIME: 36s (21.7%)

COOLANT: Flood

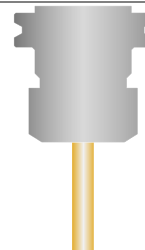
T8 D8 L8

TYPE: flat end mill

DIAMETER: 10mm

LENGTH: 50mm

FLUTES: 4

**Operation 3/4**

DESCRIPTION: 2D Contour3

STRATEGY: Contour 2D

WCS: #0

TOLERANCE: 0.01mm

STOCK TO LEAVE: 0mm

MAXIMUM STEPOVER: 14.25mm

MAXIMUM SPINDLE SPEED: 5000rpm

MAXIMUM FEEDRATE: 1000mm/min

CUTTING DISTANCE: 409.01mm

RAPID DISTANCE: 11.5mm

ESTIMATED CYCLE TIME: 26s (15.3%)

COOLANT: Flood

T5 D5 L5

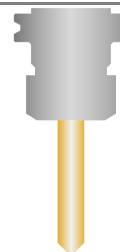
TYPE: chamfer mill

DIAMETER: 15mm

TAPER ANGLE: 45°

LENGTH: 75mm

FLUTES: 3

**Operation 4/4**

DESCRIPTION: Drill1

STRATEGY: Drilling

WCS: #0

TOLERANCE: 0.01mm

MAXIMUM SPINDLE SPEED: 5000rpm

MAXIMUM FEEDRATE: 1000mm/min

CUTTING DISTANCE: 68mm

RAPID DISTANCE: 134mm

ESTIMATED CYCLE TIME: 6s (3.4%)

COOLANT: Flood

T3 D3 L3

TYPE: drill

DIAMETER: 8.5mm

TIP ANGLE: 118°

LENGTH: 110.5mm

FLUTES: 3

