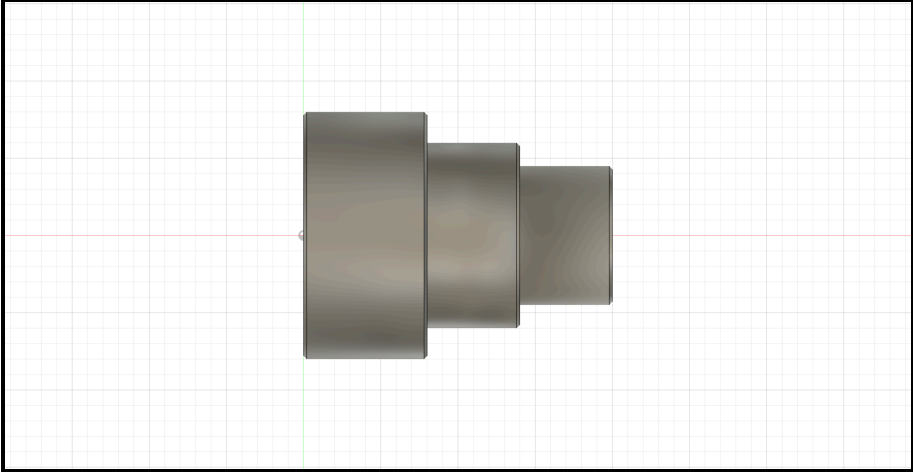



Setup Sheet for Program 1001

JOB DESCRIPTION: Setup1
DOCUMENT PATH: SHAFT 1

Setup	
<div><div>WCS: #0</div><div>STOCK:<div>DX: 84mm</div><div>DY: 84mm</div><div>DZ: 104mm</div></div><div>PART:<div>DX: 80mm</div><div>DY: 80mm</div><div>DZ: 100mm</div></div><div>STOCK LOWER IN WCS #0:<div>X: -42mm</div><div>Y: -42mm</div><div>Z: 0mm</div></div><div>STOCK UPPER IN WCS #0:<div>X: 42mm</div><div>Y: 42mm</div><div>Z: 104mm</div></div></div>	

Total
<div>NUMBER OF OPERATIONS: 3</div> <div>NUMBER OF TOOLS: 1</div> <div>TOOLS: T1</div> <div>MAXIMUM Z: 109mm</div> <div>MINIMUM Z: 1.66mm</div> <div>MAXIMUM FEEDRATE: 5000mm/min</div> <div>MAXIMUM SPINDLE SPEED: 5000rpm</div> <div>CUTTING DISTANCE: 1335.16mm</div> <div>RAPID DISTANCE: 1554.77mm</div> <div>ESTIMATED CYCLE TIME: 1m:54s</div>

Tools			
<div>T1 D1</div> <div>Type: general turning</div> <div>INSERT: ISO V 35deg</div> <div>EDGE LENGTH: 9.69mm</div> <div>NOSE RADIUS: 0.2mm</div> <div>CROSS SECTION: T</div> <div>TOLERANCE: M</div> <div>RELIEF: N 0deg</div> <div>COMPENSATION: Tip tangent</div> <div>DESCRIPTION: VNMT Right Hand</div>	<div>TOOL ORIENTATION IN TURRET: Radial</div> <div>MINIMUM Z: 1.66mm</div> <div>MAXIMUM FEED: 5000mm/min</div> <div>MAXIMUM SPINDLE SPEED: 5000rpm</div> <div>CUTTING DISTANCE: 1335.16mm</div> <div>RAPID DISTANCE: 1554.77mm</div> <div>ESTIMATED CYCLE TIME: 1m:39s (86.8%)</div>	<div>HOLDER: ISO L Right</div>	

Operations			
<div>Operation 1/3</div> <div>DESCRIPTION: Profile Roughing1</div> <div>WCS: #0</div> <div>TOLERANCE: 0.01mm</div> <div>MAXIMUM STEPOVER: 1mm</div>	<div>MAXIMUM Z: 109mm</div> <div>MINIMUM Z: 1.66mm</div> <div>SURFACE SPEED: 200m/min</div> <div>FEEDRATE PER REV: 1mm</div> <div>CUTTING DISTANCE: 1150.36mm</div> <div>RAPID DISTANCE: 1309.28mm</div> <div>ESTIMATED CYCLE TIME: 1m:29s (77.8%)</div> <div>COOLANT: Flood</div>	<div>T1 D1</div> <div>Type: general turning</div> <div>INSERT: ISO V 35deg</div> <div>EDGE LENGTH: 9.69mm</div> <div>NOSE RADIUS: 0.2mm</div> <div>CROSS SECTION: T</div> <div>TOLERANCE: M</div> <div>RELIEF: N 0deg</div> <div>COMPENSATION: Tip tangent</div> <div>DESCRIPTION: VNMT Right Hand</div>	
<div>Operation 2/3</div> <div>DESCRIPTION: Face1</div> <div>STRATEGY: Turning Face</div> <div>WCS: #0</div> <div>TOLERANCE: 0.01mm</div> <div>MAXIMUM STEPOVER: 1mm</div>	<div>MAXIMUM Z: 109mm</div> <div>MINIMUM Z: 102mm</div> <div>SURFACE SPEED: 200m/min</div> <div>FEEDRATE PER REV: 1mm</div> <div>CUTTING DISTANCE: 92.4mm</div> <div>RAPID DISTANCE: 122.74mm</div> <div>ESTIMATED CYCLE TIME: 5s (4.5%)</div> <div>COOLANT: Flood</div>	<div>T1 D1</div> <div>Type: general turning</div> <div>INSERT: ISO V 35deg</div> <div>EDGE LENGTH: 9.69mm</div> <div>NOSE RADIUS: 0.2mm</div> <div>CROSS SECTION: T</div> <div>TOLERANCE: M</div> <div>RELIEF: N 0deg</div> <div>COMPENSATION: Tip tangent</div> <div>DESCRIPTION: VNMT Right Hand</div>	
<div>Operation 3/3</div> <div>DESCRIPTION: Face2</div> <div>STRATEGY: Turning Face</div> <div>WCS: #0</div> <div>TOLERANCE: 0.01mm</div> <div>MAXIMUM STEPOVER: 1mm</div>	<div>MAXIMUM Z: 109mm</div> <div>MINIMUM Z: 102mm</div> <div>SURFACE SPEED: 200m/min</div> <div>FEEDRATE PER REV: 1mm</div> <div>CUTTING DISTANCE: 92.4mm</div> <div>RAPID DISTANCE: 122.74mm</div> <div>ESTIMATED CYCLE TIME: 5s (4.5%)</div> <div>COOLANT: Flood</div>	<div>T1 D1</div> <div>Type: general turning</div> <div>INSERT: ISO V 35deg</div> <div>EDGE LENGTH: 9.69mm</div> <div>NOSE RADIUS: 0.2mm</div> <div>CROSS SECTION: T</div> <div>TOLERANCE: M</div> <div>RELIEF: N 0deg</div> <div>COMPENSATION: Tip tangent</div> <div>DESCRIPTION: VNMT Right Hand</div>	