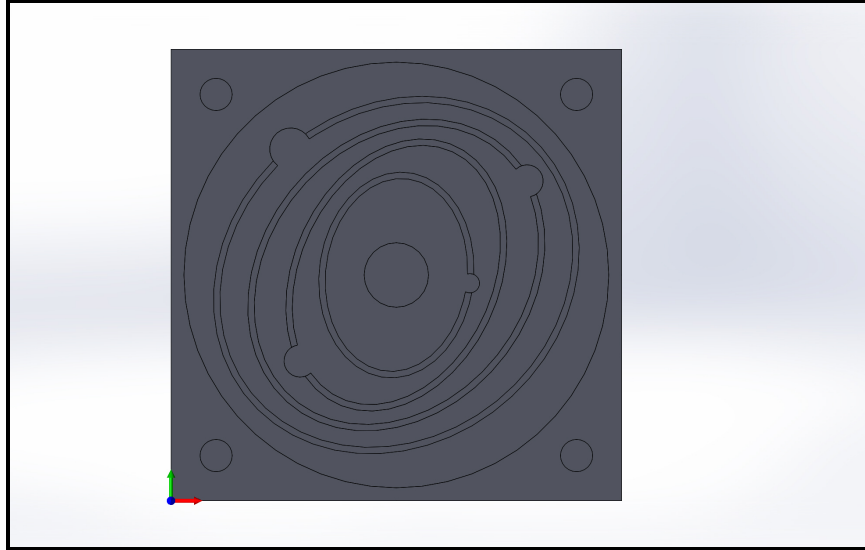


Setup Sheet for Program MAZE

DOCUMENT PATH: C:\Users\Omar\Documents\MAZE Assignment\MAZE.SLDPRT

Setup



Total

NUMBER OF OPERATIONS: 7
NUMBER OF TOOLS: 7
TOOLS: **T1 T2 T3 T4 T5 T7 T10**
MAXIMUM Z: 0.6in
MINIMUM Z: -0.3in
MAXIMUM FEEDRATE: 68.7551in/min
MAXIMUM SPINDLE SPEED: 10000rpm
CUTTING DISTANCE: 742.221in
RAPID DISTANCE: 101.544in
ESTIMATED CYCLE TIME: 36m:37s

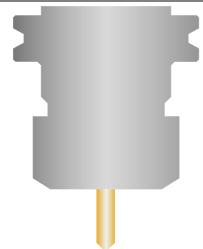
Tools

T1 D1 L1

TYPE: spot drill
DIAMETER: 0.25in
TIP ANGLE: 90°
LENGTH: 0.85in
FLUTES: 3
DESCRIPTION: 1/4" Spot Drill

MINIMUM Z: -0.2in
MAXIMUM FEED: 30in/min
MAXIMUM SPINDLE SPEED: 1528rpm
CUTTING DISTANCE: 0.8in
RAPID DISTANCE: 11.6in
ESTIMATED CYCLE TIME: 2s (0.1%)

HOLDER: Maritool CAT40-ER32-2.35
COMMENT: Maritool CAT40-ER32-2.35
VENDOR: Maritool
PRODUCT: CAT40-ER32-2.35

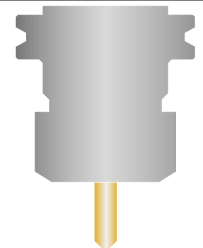


T2 D2 L2

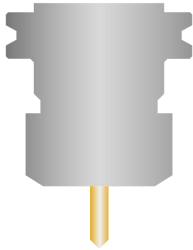


TYPE: spot drill
DIAMETER: 0.313in
TIP ANGLE: 90°
LENGTH: 0.975in
FLUTES: 3
DESCRIPTION: 5/16" Spot Drill

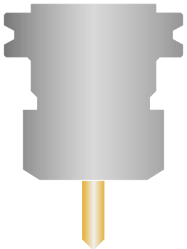
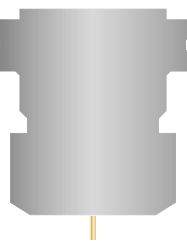
MINIMUM Z: -0.15in
MAXIMUM FEED: 30in/min
MAXIMUM SPINDLE SPEED: 1222rpm
CUTTING DISTANCE: 0.2in
RAPID DISTANCE: 1.3in
ESTIMATED CYCLE TIME: 0s (0%)

HOLDER: Maritool CAT40-ER32-2.35
COMMENT: Maritool CAT40-ER32-2.35
VENDOR: Maritool
PRODUCT: CAT40-ER32-2.35



| | | | |
|---------------------------------|---------------------------------------|-----------------------------------|---------------------------------------------------------------------------------------|
| T3 D3 L3 | | |  |
| TYPE: spot drill | MINIMUM Z: -0.25in | HOLDER: Maritool CAT40-ER32-2.35 | |
| DIAMETER: 0.25in | MAXIMUM FEED: 30in/min | COMMENT: Maritool CAT40-ER32-2.35 |  |
| TIP ANGLE: 90° | MAXIMUM SPINDLE SPEED: 1528rpm | VENDOR: Maritool | |
| LENGTH: 0.85in | CUTTING DISTANCE: 0.4in | PRODUCT: CAT40-ER32-2.35 |  |
| FLUTES: 3 | RAPID DISTANCE: 4.349in | | |
| DESCRIPTION: 1/4" Spot Drill | ESTIMATED CYCLE TIME: 1s (0%) | |  |
| T4 D4 L4 | MINIMUM Z: -0.3in | HOLDER: Maritool CAT40-ER32-2.35 | |
| TYPE: spot drill | MAXIMUM FEED: 30in/min | COMMENT: Maritool CAT40-ER32-2.35 |  |
| DIAMETER: 0.187in | MAXIMUM SPINDLE SPEED: 2037rpm | VENDOR: Maritool | |
| TIP ANGLE: 90° | CUTTING DISTANCE: 0.2in | PRODUCT: CAT40-ER32-2.35 |  |
| LENGTH: 0.725in | RAPID DISTANCE: 1.6in | | |
| FLUTES: 3 | ESTIMATED CYCLE TIME: 0s (0%) | |  |
| DESCRIPTION: 3/16" Spot Drill | | | |
| T5 D5 L5 | MINIMUM Z: -0.3in | HOLDER: Maritool CAT40-ER32-2.35 |  |
| TYPE: flat end mill | MAXIMUM FEED: 68.7551in/min | COMMENT: Maritool CAT40-ER32-2.35 | |
| DIAMETER: 0.25in | MAXIMUM SPINDLE SPEED: 4584rpm | VENDOR: Maritool | |
| LENGTH: 0.85in | CUTTING DISTANCE: 146.612in | PRODUCT: CAT40-ER32-2.35 | |
| FLUTES: 3 | RAPID DISTANCE: 30.485in | | |
| DESCRIPTION: 1/4" Flat Endmill | ESTIMATED CYCLE TIME: 2m:8s (5.8%) | | |
| T7 D7 L7 | MINIMUM Z: -0.3in | HOLDER: Maritool CAT40-ER32-2.35 | |
| TYPE: flat end mill | MAXIMUM FEED: 27.502in/min | COMMENT: Maritool CAT40-ER32-2.35 | |
| DIAMETER: 0.125in | MAXIMUM SPINDLE SPEED: 9167rpm | VENDOR: Maritool | |
| LENGTH: 0.6in | CUTTING DISTANCE: 228.803in | PRODUCT: CAT40-ER32-2.35 | |
| FLUTES: 3 | RAPID DISTANCE: 22.949in | | |
| DESCRIPTION: 1/8" Flat Endmill | ESTIMATED CYCLE TIME: 8m:19s (22.7%) | | |
| T10 D10 L10 | MINIMUM Z: -0.3in | HOLDER: Maritool CAT40-ER32-2.35 | |
| TYPE: flat end mill | MAXIMUM FEED: 15in/min | COMMENT: Maritool CAT40-ER32-2.35 | |
| DIAMETER: 0.062in | MAXIMUM SPINDLE SPEED: 10000rpm | VENDOR: Maritool | |
| LENGTH: 0.288in | CUTTING DISTANCE: 365.206in | PRODUCT: CAT40-ER32-2.35 | |
| FLUTES: 3 | RAPID DISTANCE: 29.261in | | |
| DESCRIPTION: 1/16" Flat Endmill | ESTIMATED CYCLE TIME: 24m:21s (66.5%) | | |

| Operations | | |  |
|---------------------|---------------------------------|------------------------------|---------------------------------------------------------------------------------------|
| Operation 1/7 | | T1 D1 L1 | |
| DESCRIPTION: Drill3 | MAXIMUM Z: 0.6in | TYPE: spot drill |  |
| STRATEGY: Drilling | MINIMUM Z: -0.2in | DIAMETER: 0.25in | |
| WCS: #0 | MAXIMUM SPINDLE SPEED: 1528rpm | TIP ANGLE: 90° |  |
| TOLERANCE: 0in | MAXIMUM FEEDRATE: 30in/min | LENGTH: 0.85in | |
| | CUTTING DISTANCE: 0.8in | FLUTES: 3 | |
| | RAPID DISTANCE: 11.6in | DESCRIPTION: 1/4" Spot Drill | |
| | ESTIMATED CYCLE TIME: 2s (0.1%) | | |
| | COOLANT: Flood | | |

| | | | |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|
| Operation 2/7 DESCRIPTION: Drill4 STRATEGY: Drilling WCS: #0 TOLERANCE: 0in | MAXIMUM Z: 0.6in MINIMUM Z: -0.15in MAXIMUM SPINDLE SPEED: 1222rpm MAXIMUM FEEDRATE: 30in/min CUTTING DISTANCE: 0.2in RAPID DISTANCE: 1.3in ESTIMATED CYCLE TIME: 0s (0%) COOLANT: Flood | T2 D2 L2 TYPE: spot drill DIAMETER: 0.313in TIP ANGLE: 90° LENGTH: 0.975in FLUTES: 3 DESCRIPTION: 5/16" Spot Drill |  |
| Operation 3/7 DESCRIPTION: Drill5 STRATEGY: Drilling WCS: #0 TOLERANCE: 0in | MAXIMUM Z: 0.6in MINIMUM Z: -0.25in MAXIMUM SPINDLE SPEED: 1528rpm MAXIMUM FEEDRATE: 30in/min CUTTING DISTANCE: 0.4in RAPID DISTANCE: 4.349in ESTIMATED CYCLE TIME: 1s (0%) COOLANT: Flood | T3 D3 L3 TYPE: spot drill DIAMETER: 0.25in TIP ANGLE: 90° LENGTH: 0.85in FLUTES: 3 DESCRIPTION: 1/4" Spot Drill |  |
| Operation 4/7 DESCRIPTION: Drill6 STRATEGY: Drilling WCS: #0 TOLERANCE: 0in | MAXIMUM Z: 0.6in MINIMUM Z: -0.3in MAXIMUM SPINDLE SPEED: 2037rpm MAXIMUM FEEDRATE: 30in/min CUTTING DISTANCE: 0.2in RAPID DISTANCE: 1.6in ESTIMATED CYCLE TIME: 0s (0%) COOLANT: Flood | T4 D4 L4 TYPE: spot drill DIAMETER: 0.187in TIP ANGLE: 90° LENGTH: 0.725in FLUTES: 3 DESCRIPTION: 3/16" Spot Drill |  |
| Operation 5/7 DESCRIPTION: Horizontal2 STRATEGY: Horizontal WCS: #0 TOLERANCE: 0.001in STOCK TO LEAVE: 0in MAXIMUM STEPOVER: 0.238in | MAXIMUM Z: 0.6in MINIMUM Z: -0.3in MAXIMUM SPINDLE SPEED: 4584rpm MAXIMUM FEEDRATE: 68.7551in/min CUTTING DISTANCE: 146.612in RAPID DISTANCE: 30.485in ESTIMATED CYCLE TIME: 2m:8s (5.8%) COOLANT: Flood | T5 D5 L5 TYPE: flat end mill DIAMETER: 0.25in LENGTH: 0.85in FLUTES: 3 DESCRIPTION: 1/4" Flat Endmill |  |
| Operation 6/7 DESCRIPTION: Horizontal1 STRATEGY: Horizontal WCS: #0 TOLERANCE: 0in STOCK TO LEAVE: 0in MAXIMUM STEPOVER: 0.119in | MAXIMUM Z: 0.6in MINIMUM Z: -0.3in MAXIMUM SPINDLE SPEED: 9167rpm MAXIMUM FEEDRATE: 27.502in/min CUTTING DISTANCE: 228.803in RAPID DISTANCE: 22.949in ESTIMATED CYCLE TIME: 8m:19s (22.7%) COOLANT: Flood | T7 D7 L7 TYPE: flat end mill DIAMETER: 0.125in LENGTH: 0.6in FLUTES: 3 DESCRIPTION: 1/8" Flat Endmill |  |
| Operation 7/7 DESCRIPTION: Horizontal3 STRATEGY: Horizontal WCS: #0 TOLERANCE: 0in STOCK TO LEAVE: 0in MAXIMUM STEPOVER: 0.059in | MAXIMUM Z: 0.6in MINIMUM Z: -0.3in MAXIMUM SPINDLE SPEED: 10000rpm MAXIMUM FEEDRATE: 15in/min CUTTING DISTANCE: 365.206in RAPID DISTANCE: 29.261in ESTIMATED CYCLE TIME: 24m:21s (66.5%) COOLANT: Flood | T10 D10 L10 TYPE: flat end mill DIAMETER: 0.062in LENGTH: 0.288in FLUTES: 3 DESCRIPTION: 1/16" Flat Endmill |  |