

Setup Sheet for Program Arena

DOCUMENT PATH: C:\Users\Omar\Documents\Toy\Arena.SLDPRT

Setup

WCS: #0

Stock:

DX: 260mm
DY: 260mm
DZ: 52mm

PART:

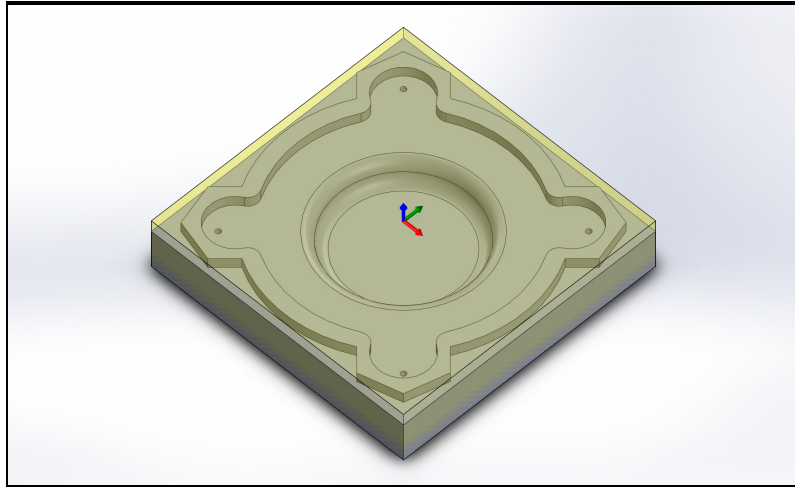
DX: 260mm
DY: 260mm
DZ: 50mm

Stock Lower in WCS #0:

X: -130mm
Y: -130mm
Z: -52mm

Stock Upper in WCS #0:

X: 130mm
Y: 130mm
Z: 0mm



Total

NUMBER OF OPERATIONS: 7

NUMBER OF TOOLS: 7

TOOLS: T1 T3 T4 T5 T8 T9 T10

MAXIMUM Z: 15mm

MINIMUM Z: -31.98mm

MAXIMUM FEEDRATE: 2336.8mm/min

MAXIMUM SPINDLE SPEED: 6500rpm

CUTTING DISTANCE: 51166.36mm

RAPID DISTANCE: 15036.65mm

ESTIMATED CYCLE TIME: 31m:20s

Tools

T1 D1 L1

TYPE: face mill

DIAMETER: 50.8mm

LENGTH: 39.7mm

FLUTES: 5

DESCRIPTION: 2" Face Mill

VENDOR: Maritool

PRODUCT: MSAP16-D050A05R-25.4

MINIMUM Z: -2mm

MAXIMUM FEED: 1651mm/min

MAXIMUM SPINDLE SPEED: 6500rpm

CUTTING DISTANCE: 1319.78mm

RAPID DISTANCE: 331.49mm

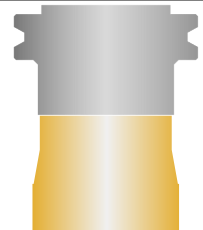
ESTIMATED CYCLE TIME: 52s (2.8%)

HOLDER: Maritool CAT40-FMA1.0-1.5M

COMMENT: Maritool CAT40-FMA1.0-1.5M

VENDOR: Maritool

PRODUCT: CAT40-FMA1.0-1.5M



T3 D3 L3

TYPE: bullnose end mill

DIAMETER: 9.52mm

CORNER RADIUS: 0.38mm

LENGTH: 24.76mm

FLUTES: 3

DESCRIPTION: 3/8" Bullnose Endmill

MINIMUM Z: -31mm

MAXIMUM FEED: 2286mm/min

MAXIMUM SPINDLE SPEED: 3056rpm

CUTTING DISTANCE: 8483.41mm

RAPID DISTANCE: 2718.15mm

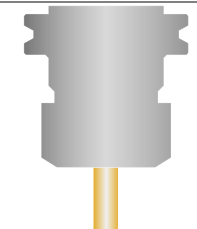
ESTIMATED CYCLE TIME: 4m:15s (13.6%)

HOLDER: Maritool CAT40-ER32-2.35

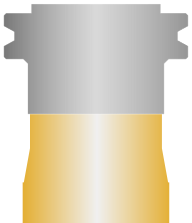
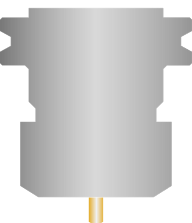
COMMENT: Maritool CAT40-ER32-2.35

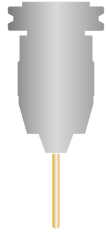
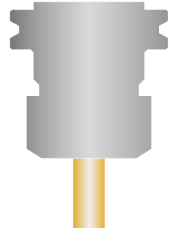
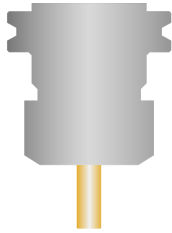
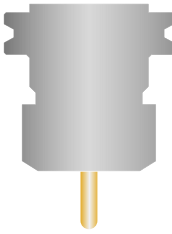
VENDOR: Maritool

PRODUCT: CAT40-ER32-2.35



T4 D4 L4 TYPE: center drill DIAMETER: 4.76mm TIP ANGLE: 118° LENGTH: 9.47mm FLUTES: 2 DESCRIPTION: #2 Center Drill	MINIMUM Z: -4mm MAXIMUM FEED: 736.6mm/min MAXIMUM SPINDLE SPEED: 6110rpm CUTTING DISTANCE: 28mm RAPID DISTANCE: 637.32mm ESTIMATED CYCLE TIME: 10s (0.5%)	HOLDER: Maritool CAT40-ER32-2.35 COMMENT: Maritool CAT40-ER32-2.35 VENDOR: Maritool PRODUCT: CAT40-ER32-2.35	
T5 D5 L5 TYPE: ball end mill DIAMETER: 6.35mm LENGTH: 21.59mm FLUTES: 3 DESCRIPTION: 1/4" Ball Endmill	MINIMUM Z: -31.98mm MAXIMUM FEED: 1524mm/min MAXIMUM SPINDLE SPEED: 4584rpm CUTTING DISTANCE: 4160.65mm RAPID DISTANCE: 71.34mm ESTIMATED CYCLE TIME: 2m:45s (8.8%)	HOLDER: Maritool CAT40-ER32-2.35 COMMENT: Maritool CAT40-ER32-2.35 VENDOR: Maritool PRODUCT: CAT40-ER32-2.35	
T8 D8 L8 TYPE: flat end mill DIAMETER: 6.35mm LENGTH: 21.59mm FLUTES: 3 DESCRIPTION: 1/4" Flat Endmill	MINIMUM Z: -11mm MAXIMUM FEED: 1524mm/min MAXIMUM SPINDLE SPEED: 4584rpm CUTTING DISTANCE: 14575.72mm RAPID DISTANCE: 7180.33mm ESTIMATED CYCLE TIME: 11m:0s (35.1%)	HOLDER: Maritool CAT40-ER32-2.35 COMMENT: Maritool CAT40-ER32-2.35 VENDOR: Maritool PRODUCT: CAT40-ER32-2.35	
T9 D9 L9 TYPE: drill DIAMETER: 4.76mm TIP ANGLE: 118° LENGTH: 50.16mm FLUTES: 1 DESCRIPTION: 3/16	MINIMUM Z: -22mm MAXIMUM FEED: 736.6mm/min MAXIMUM SPINDLE SPEED: 6110rpm CUTTING DISTANCE: 60mm RAPID DISTANCE: 749.32mm ESTIMATED CYCLE TIME: 14s (0.7%)	HOLDER: Maritool CAT40-APU13 Drill Chuck COMMENT: Maritool CAT40-APU13 VENDOR: Maritool PRODUCT: CAT40-APU13	
T10 D10 L10 TYPE: flat end mill DIAMETER: 12.7mm LENGTH: 27.94mm FLUTES: 3 DESCRIPTION: 1/2" Flat Endmill	MINIMUM Z: -31mm MAXIMUM FEED: 2336.8mm/min MAXIMUM SPINDLE SPEED: 2292rpm CUTTING DISTANCE: 22538.8mm RAPID DISTANCE: 3348.72mm ESTIMATED CYCLE TIME: 10m:19s (32.9%)	HOLDER: Maritool CAT40-ER32-2.35 COMMENT: Maritool CAT40-ER32-2.35 VENDOR: Maritool PRODUCT: CAT40-ER32-2.35	

Operations			
Operation 1/7 DESCRIPTION: Face2 STRATEGY: Facing WCS: #0 TOLERANCE: 0.01mm MAXIMUM STEPOVER: 48.26mm	MAXIMUM Z: 15mm MINIMUM Z: -2mm MAXIMUM SPINDLE SPEED: 6500rpm MAXIMUM FEEDRATE: 1651mm/min CUTTING DISTANCE: 1319.78mm RAPID DISTANCE: 331.49mm ESTIMATED CYCLE TIME: 52s (2.8%) COOLANT: Flood	T1 D1 L1 TYPE: face mill DIAMETER: 50.8mm LENGTH: 39.7mm FLUTES: 5 DESCRIPTION: 2" Face Mill VENDOR: Maritool PRODUCT: MSAP16-D050A05R-25.4	
Operation 2/7 DESCRIPTION: Drill1 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm	MAXIMUM Z: 15mm MINIMUM Z: -4mm MAXIMUM SPINDLE SPEED: 6110rpm MAXIMUM FEEDRATE: 736.6mm/min CUTTING DISTANCE: 28mm RAPID DISTANCE: 637.32mm ESTIMATED CYCLE TIME: 10s (0.5%) COOLANT: Flood	T4 D4 L4 TYPE: center drill DIAMETER: 4.76mm TIP ANGLE: 118° LENGTH: 9.47mm FLUTES: 2 DESCRIPTION: #2 Center Drill	

Operation 3/7 DESCRIPTION: Drill2 STRATEGY: Drilling WCS: #0 TOLERANCE: 0.01mm	MAXIMUM Z: 15mm MINIMUM Z: -22mm MAXIMUM SPINDLE SPEED: 6110rpm MAXIMUM FEEDRATE: 736.6mm/min CUTTING DISTANCE: 60mm RAPID DISTANCE: 749.32mm ESTIMATED CYCLE TIME: 14s (0.7%) COOLANT: Flood	T9 D9 L9 TYPE: drill DIAMETER: 4.76mm TIP ANGLE: 118° LENGTH: 50.16mm FLUTES: 1 DESCRIPTION: 3/16	
Operation 4/7 DESCRIPTION: Adaptive2 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.5mm MAXIMUM STEPDOWN: 10mm OPTIMAL LOAD: 5.08mm LOAD DEVIATION: 0.51mm	MAXIMUM Z: 15mm MINIMUM Z: -31mm MAXIMUM SPINDLE SPEED: 2292rpm MAXIMUM FEEDRATE: 2336.8mm/min CUTTING DISTANCE: 22538.8mm RAPID DISTANCE: 3348.72mm ESTIMATED CYCLE TIME: 10m:19s (32.9%) COOLANT: Flood	T10 D10 L10 TYPE: flat end mill DIAMETER: 12.7mm LENGTH: 27.94mm FLUTES: 3 DESCRIPTION: 1/2" Flat Endmill	
Operation 5/7 DESCRIPTION: Adaptive3 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.5mm MAXIMUM STEPDOWN: 10mm OPTIMAL LOAD: 3.81mm LOAD DEVIATION: 0.38mm	MAXIMUM Z: 15mm MINIMUM Z: -31mm MAXIMUM SPINDLE SPEED: 3056rpm MAXIMUM FEEDRATE: 2286mm/min CUTTING DISTANCE: 8483.41mm RAPID DISTANCE: 2718.15mm ESTIMATED CYCLE TIME: 4m:15s (13.6%) COOLANT: Flood	T3 D3 L3 TYPE: bullnose end mill DIAMETER: 9.52mm CORNER RADIUS: 0.38mm LENGTH: 24.76mm FLUTES: 3 DESCRIPTION: 3/8" Bullnose Endmill	
Operation 6/7 DESCRIPTION: Scallop1 STRATEGY: Scallop WCS: #0 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPOVER: 3.17mm	MAXIMUM Z: 15mm MINIMUM Z: -31.98mm MAXIMUM SPINDLE SPEED: 4584rpm MAXIMUM FEEDRATE: 1524mm/min CUTTING DISTANCE: 4160.65mm RAPID DISTANCE: 71.34mm ESTIMATED CYCLE TIME: 2m:45s (8.8%) COOLANT: Flood	T5 D5 L5 TYPE: ball end mill DIAMETER: 6.35mm LENGTH: 21.59mm FLUTES: 3 DESCRIPTION: 1/4" Ball Endmill	
Operation 7/7 DESCRIPTION: Adaptive7 STRATEGY: Adaptive WCS: #0 TOLERANCE: 0.1mm STOCK TO LEAVE: 0.5mm MAXIMUM STEPDOWN: 10mm OPTIMAL LOAD: 2.54mm LOAD DEVIATION: 0.25mm	MAXIMUM Z: 15mm MINIMUM Z: -11mm MAXIMUM SPINDLE SPEED: 4584rpm MAXIMUM FEEDRATE: 1524mm/min CUTTING DISTANCE: 14575.72mm RAPID DISTANCE: 7180.33mm ESTIMATED CYCLE TIME: 11m:0s (35.1%) COOLANT: Flood	T8 D8 L8 TYPE: flat end mill DIAMETER: 6.35mm LENGTH: 21.59mm FLUTES: 3 DESCRIPTION: 1/4" Flat Endmill	