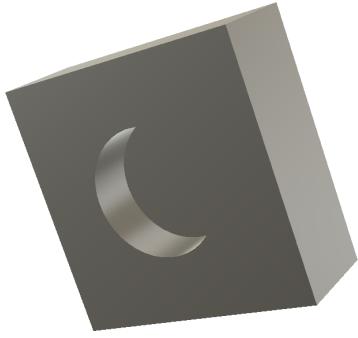


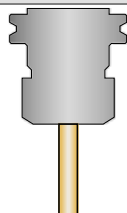
# Setup Sheet for Program 1001

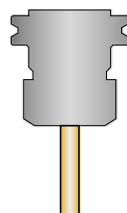
JOB DESCRIPTION: Setup1

DOCUMENT PATH: 222 v1

Setup	
<p>WCS: #0</p> <p>STOCK:</p> <p>DX: 52mm</p> <p>DY: 52mm</p> <p>DZ: 21mm</p> <p>PART:</p> <p>DX: 50mm</p> <p>DY: 50mm</p> <p>DZ: 20mm</p> <p>STOCK LOWER IN WCS #0:</p> <p>X: -26mm</p> <p>Y: -26mm</p> <p>Z: -21mm</p> <p>STOCK UPPER IN WCS #0:</p> <p>X: 26mm</p> <p>Y: 26mm</p> <p>Z: 0mm</p>	

Total
<p>NUMBER OF OPERATIONS: 2</p> <p>NUMBER OF TOOLS: 1</p> <p>TOOLS: T1</p> <p>MAXIMUM Z: 29mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM FEEDRATE: 3000mm/min</p> <p>MAXIMUM SPINDLE SPEED: 12000rpm</p> <p>CUTTING DISTANCE: 15756.48mm</p> <p>RAPID DISTANCE: 3036.78mm</p> <p>ESTIMATED CYCLE TIME: 6m:7s</p>

Tools		
<p><b>T1 D1 L1</b></p> <p><b>MANUAL TOOL CHANGE</b></p> <p>TYPE: flat end mill</p> <p>DIAMETER: 10mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 1</p>	<p>MINIMUM Z: -16mm</p> <p>MAXIMUM FEED: 3000mm/min</p> <p>MAXIMUM SPINDLE SPEED: 12000rpm</p> <p>CUTTING DISTANCE: 15756.48mm</p> <p>RAPID DISTANCE: 3036.78mm</p> <p>ESTIMATED CYCLE TIME: 5m:52s (95.9%)</p>	<p>HOLDER: Maritool CAT40-ER32-2.35</p> <p>VENDOR: Maritool</p> <p>PRODUCT: CAT40-ER32-2.35</p> 

Operations			
<p>Operation 1/2</p> <p>DESCRIPTION: Face1</p> <p>STRATEGY: Facing</p> <p>WCS: #0</p> <p>TOLERANCE: 0mm</p> <p>MAXIMUM STEPDOWN: 0.5mm</p> <p>MAXIMUM STEPOVER: 9.5mm</p>	<p>MAXIMUM Z: 29mm</p> <p>MINIMUM Z: 0.1mm</p> <p>MAXIMUM SPINDLE SPEED: 12000rpm</p> <p>MAXIMUM FEEDRATE: 3000mm/min</p> <p>CUTTING DISTANCE: 2591.57mm</p> <p>RAPID DISTANCE: 2925.54mm</p> <p>ESTIMATED CYCLE TIME: 1m:27s (23.7%)</p> <p>COOLANT: Flood</p>	<p><b>T1 D1 L1</b></p> <p><b>MANUAL TOOL CHANGE</b></p> <p>TYPE: flat end mill</p> <p>DIAMETER: 10mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 1</p>	
<p>Operation 2/2</p> <p>DESCRIPTION: Bore1</p> <p>STRATEGY: Bore</p> <p>WCS: #0</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPOVER: 1mm</p>	<p>MAXIMUM Z: 15mm</p> <p>MINIMUM Z: -16mm</p> <p>MAXIMUM SPINDLE SPEED: 12000rpm</p> <p>MAXIMUM FEEDRATE: 3000mm/min</p> <p>CUTTING DISTANCE: 13164.91mm</p> <p>RAPID DISTANCE: 111.24mm</p> <p>ESTIMATED CYCLE TIME: 4m:25s (72.2%)</p> <p>COOLANT: Off</p>	<p><b>T1 D1 L1</b></p> <p><b>MANUAL TOOL CHANGE</b></p> <p>TYPE: flat end mill</p> <p>DIAMETER: 10mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 1</p>	