

Setup Sheet for Program 1001

Job Description: Setup1
Document Path: Test_model v1

Setup

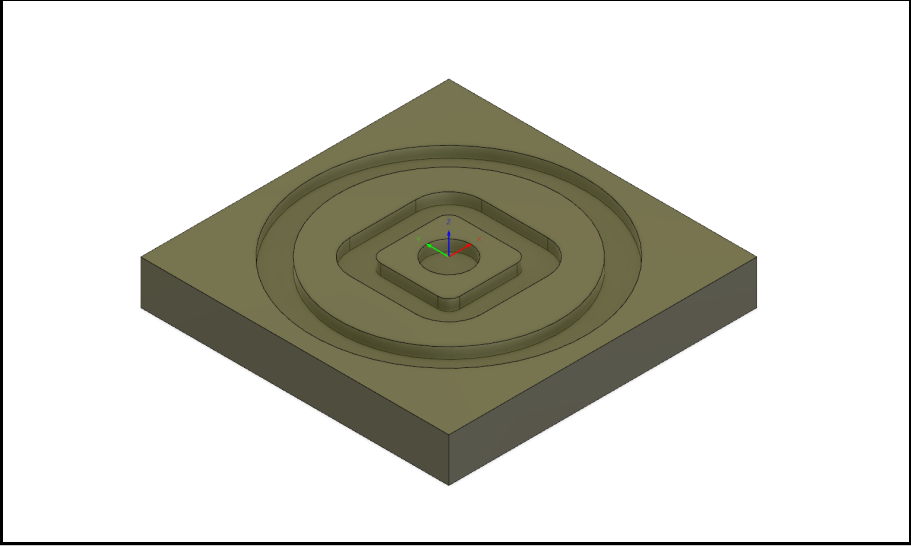
WCS: #1

Stock:
DX: 140mm
DY: 140mm
DZ: 20mm

Part:
DX: 140mm
DY: 140mm
DZ: 20mm

Stock Lower in WCS #1:
X: -70mm
Y: -70mm
Z: -20mm

Stock Upper in WCS #1:
X: 70mm
Y: 70mm
Z: 0mm



Total

Number of Operations: 3

Number of Tools: 1

Tools: T1

Maximum Z: 15mm

Minimum Z: -5mm

Maximum Feedrate: 300mm/min

Maximum Spindle Speed: 5000rpm

Cutting Distance: 1987.36mm

Rapid Distance: 171.66mm

Estimated Cycle Time: 7m:35s

Tools

T1 D1 L1

Type: flat end mill

Diameter: 10mm

Length: 50mm

Flutes: 4

Minimum Z: -5mm

Maximum Feed: 300mm/min

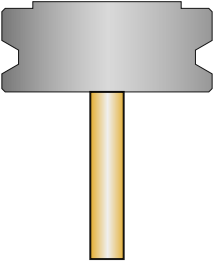
Maximum Spindle Speed: 5000rpm

Cutting Distance: 1987.36mm

Rapid Distance: 171.66mm

Estimated Cycle Time: 7m:20s (96.7%)

Holder: BT40 - Blank1



Operations

Operation 1/3

Description: 2D Pocket1

Strategy: Pocket 2D

WCS: #1

Tolerance: 0.1mm

Stock to Leave: 0mm

Maximum StepoVer: 6mm

Maximum Z: 15mm

Minimum Z: -5mm

Maximum Spindle Speed: 5000rpm

Maximum Feedrate: 300mm/min

Cutting Distance: 221.89mm

Rapid Distance: 29mm

Estimated Cycle Time: 53s (11.7%)

Coolant: Flood

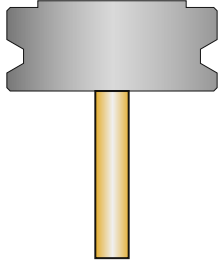
T1 D1 L1

Type: flat end mill

Diameter: 10mm

Length: 50mm

Flutes: 4



Operation 2/3

Description: 2D Pocket2

Strategy: Pocket 2D

WCS: #1

Tolerance: 0.1mm

Stock to Leave: 0mm

Maximum StepoVer: 6mm

Maximum Z: 15mm

Minimum Z: -5mm

Maximum Spindle Speed: 5000rpm

Maximum Feedrate: 300mm/min

Cutting Distance: 705.71mm

Rapid Distance: 96.04mm

Estimated Cycle Time: 2m:39s (34.8%)

Coolant: Flood

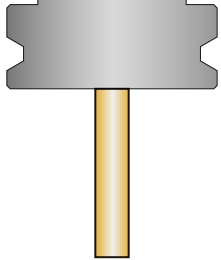
T1 D1 L1

Type: flat end mill

Diameter: 10mm

Length: 50mm

Flutes: 4



Operation 3/3

Description: 2D Pocket3

Strategy: Pocket 2D

WCS: #1

Tolerance: 0.1mm

Stock to Leave: 0mm

Maximum StepoVer: 6mm

Maximum Z: 15mm

Minimum Z: -5mm

Maximum Spindle Speed: 5000rpm

Maximum Feedrate: 300mm/min

Cutting Distance: 1059.76mm

Rapid Distance: 46.62mm

Estimated Cycle Time: 3m:49s (50.2%)

Coolant: Flood

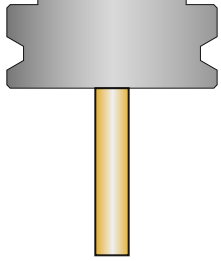
T1 D1 L1

Type: flat end mill

Diameter: 10mm

Length: 50mm

Flutes: 4



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