

# Setup Sheet for Program 1007

JOB DESCRIPTION: Top

DOCUMENT PATH: TryCNC v6

## Setup

WCS: #0

STOCK:

DX: 40mm  
DY: 40mm  
DZ: 30mm

PART:

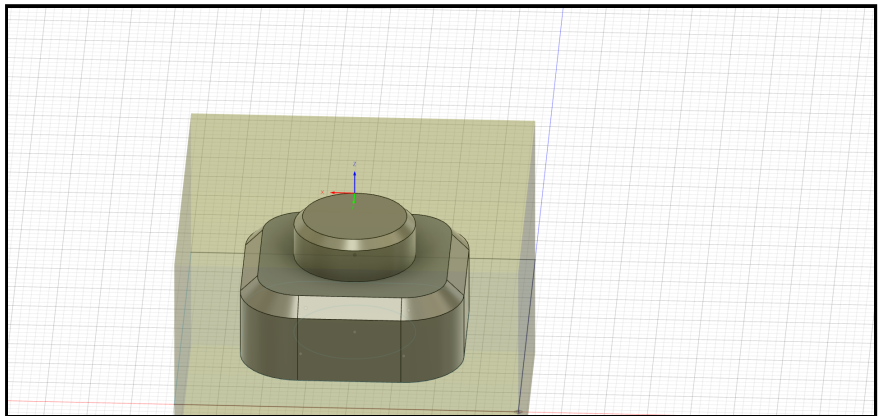
DX: 26mm  
DY: 26mm  
DZ: 15mm

STOCK LOWER IN WCS #0:

X: -20mm  
Y: -20mm  
Z: -30mm

STOCK UPPER IN WCS #0:

X: 20mm  
Y: 20mm  
Z: 0mm



## Total

NUMBER OF OPERATIONS: 6

NUMBER OF TOOLS: 3

TOOLS: T12 T25 T55

MAXIMUM Z: 15mm

MINIMUM Z: -18mm

MAXIMUM FEEDRATE: 3000mm/min

MAXIMUM SPINDLE SPEED: 6000rpm

CUTTING DISTANCE: 3990.12mm

RAPID DISTANCE: 860.85mm

ESTIMATED CYCLE TIME: 4m:33s

## Tools

### T12 D12 L12

TYPE: flat end mill

DIAMETER: 12mm

LENGTH: 32mm

FLUTES: 2

DESCRIPTION: Flat End Mill 12mm ALU

MINIMUM Z: -18mm

MAXIMUM FEED: 3000mm/min

MAXIMUM SPINDLE SPEED: 6000rpm

CUTTING DISTANCE: 279.41mm

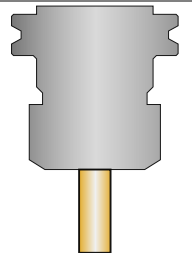
RAPID DISTANCE: 108.47mm

ESTIMATED CYCLE TIME: 1m:0s (22.2%)

HOLDER: Maritool CAT40-ER32-2.35

VENDOR: Maritool

PRODUCT: CAT40-ER32-2.35



### T25 D25 L25

TYPE: face mill

DIAMETER: 25mm

CORNER RADIUS: 0.5mm

LENGTH: 75mm

FLUTES: 2

DESCRIPTION: Sandvik Coromant 25mm ALU

MINIMUM Z: -18mm

MAXIMUM FEED: 2000mm/min

MAXIMUM SPINDLE SPEED: 6000rpm

CUTTING DISTANCE: 3414.19mm

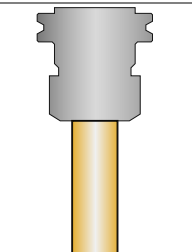
RAPID DISTANCE: 652.38mm

ESTIMATED CYCLE TIME: 2m:1s (44.3%)

HOLDER: Maritool CAT40-ER32-2.35

VENDOR: Maritool

PRODUCT: CAT40-ER32-2.35



### T55 D55 L55

TYPE: chamfer mill

DIAMETER: 5mm

TAPER ANGLE: 45°

LENGTH: 24mm

FLUTES: 2

DESCRIPTION: Chamfer

MINIMUM Z: -11.5mm

MAXIMUM FEED: 500mm/min

MAXIMUM SPINDLE SPEED: 6000rpm

CUTTING DISTANCE: 296.53mm

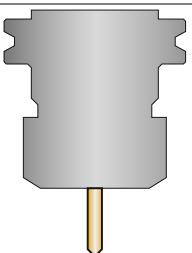
RAPID DISTANCE: 100mm

ESTIMATED CYCLE TIME: 46s (17%)

HOLDER: Maritool CAT40-ER32-2.35

VENDOR: Maritool

PRODUCT: CAT40-ER32-2.35



## Operations

<p>Operation 1/6  <b>DESCRIPTION:</b> Face1  <b>STRATEGY:</b> Facing  <b>WCS:</b> #0  <b>TOLERANCE:</b> 0.01mm  <b>MAXIMUM STEPDOWN:</b> 2mm  <b>MAXIMUM STEPOVER:</b> 22.8mm</p>	<p><b>MAXIMUM Z:</b> 15mm  <b>MINIMUM Z:</b> -3mm  <b>MAXIMUM SPINDLE SPEED:</b> 6000rpm  <b>MAXIMUM FEEDRATE:</b> 2000mm/min  <b>CUTTING DISTANCE:</b> 321.87mm  <b>RAPID DISTANCE:</b> 40.35mm  <b>ESTIMATED CYCLE TIME:</b> 13s (4.7%)  <b>COOLANT:</b> Flood</p>	<p><b>T25 D25 L25</b>  <b>TYPE:</b> face mill  <b>DIAMETER:</b> 25mm  <b>CORNER RADIUS:</b> 0.5mm  <b>LENGTH:</b> 75mm  <b>FLUTES:</b> 2  <b>DESCRIPTION:</b> Sandvik Coromant 25mm ALU</p>	
<p>Operation 2/6  <b>DESCRIPTION:</b> 2D Adaptive3  <b>STRATEGY:</b> Adaptive 2D  <b>WCS:</b> #0  <b>TOLERANCE:</b> 0.1mm  <b>STOCK TO LEAVE:</b> 0.3mm/0mm  <b>MAXIMUM STEPDOWN:</b> 2mm  <b>OPTIMAL LOAD:</b> 8mm  <b>LOAD DEVIATION:</b> 0.8mm</p>	<p><b>MAXIMUM Z:</b> 15mm  <b>MINIMUM Z:</b> -18mm  <b>MAXIMUM SPINDLE SPEED:</b> 6000rpm  <b>MAXIMUM FEEDRATE:</b> 2000mm/min  <b>CUTTING DISTANCE:</b> 3092.32mm  <b>RAPID DISTANCE:</b> 612.03mm  <b>ESTIMATED CYCLE TIME:</b> 1m:48s (39.7%)  <b>COOLANT:</b> Flood</p>	<p><b>T25 D25 L25</b>  <b>TYPE:</b> face mill  <b>DIAMETER:</b> 25mm  <b>CORNER RADIUS:</b> 0.5mm  <b>LENGTH:</b> 75mm  <b>FLUTES:</b> 2  <b>DESCRIPTION:</b> Sandvik Coromant 25mm ALU</p>	
<p>Operation 3/6  <b>DESCRIPTION:</b> 2D Contour1  <b>STRATEGY:</b> Contour 2D  <b>WCS:</b> #0  <b>TOLERANCE:</b> 0.01mm  <b>STOCK TO LEAVE:</b> 0mm  <b>MAXIMUM STEPOVER:</b> 11.4mm  <b>COMPENSATION:</b> control (left)  <b>SAFE TOOL DIAMETER:</b> &lt; 13.2mm</p>	<p><b>MAXIMUM Z:</b> 15mm  <b>MINIMUM Z:</b> -18mm  <b>MAXIMUM SPINDLE SPEED:</b> 6000rpm  <b>MAXIMUM FEEDRATE:</b> 3000mm/min  <b>CUTTING DISTANCE:</b> 279.41mm  <b>RAPID DISTANCE:</b> 108.47mm  <b>ESTIMATED CYCLE TIME:</b> 1m:0s (22.2%)  <b>COOLANT:</b> Flood</p>	<p><b>T12 D12 L12</b>  <b>TYPE:</b> flat end mill  <b>DIAMETER:</b> 12mm  <b>LENGTH:</b> 32mm  <b>FLUTES:</b> 2  <b>DESCRIPTION:</b> Flat End Mill 12mm ALU</p>	
<p>Operation 4/6  <b>DESCRIPTION:</b> 2D Contour6  <b>STRATEGY:</b> Contour 2D  <b>WCS:</b> #0  <b>TOLERANCE:</b> 0.01mm  <b>STOCK TO LEAVE:</b> 0mm  <b>MAXIMUM STEPOVER:</b> 4.75mm</p>	<p><b>MAXIMUM Z:</b> 15mm  <b>MINIMUM Z:</b> -5mm  <b>MAXIMUM SPINDLE SPEED:</b> 6000rpm  <b>MAXIMUM FEEDRATE:</b> 500mm/min  <b>CUTTING DISTANCE:</b> 64.35mm  <b>RAPID DISTANCE:</b> 29.5mm  <b>ESTIMATED CYCLE TIME:</b> 10s (3.8%)  <b>COOLANT:</b> Flood</p>	<p><b>T55 D55 L55</b>  <b>TYPE:</b> chamfer mill  <b>DIAMETER:</b> 5mm  <b>TAPER ANGLE:</b> 45°  <b>LENGTH:</b> 24mm  <b>FLUTES:</b> 2  <b>DESCRIPTION:</b> Chamfer</p>	
<p>Operation 5/6  <b>DESCRIPTION:</b> 2D Contour7  <b>STRATEGY:</b> Contour 2D  <b>WCS:</b> #0  <b>TOLERANCE:</b> 0.01mm  <b>STOCK TO LEAVE:</b> 0mm  <b>MAXIMUM STEPOVER:</b> 4.75mm</p>	<p><b>MAXIMUM Z:</b> 15mm  <b>MINIMUM Z:</b> -11.5mm  <b>MAXIMUM SPINDLE SPEED:</b> 6000rpm  <b>MAXIMUM FEEDRATE:</b> 500mm/min  <b>CUTTING DISTANCE:</b> 121.55mm  <b>RAPID DISTANCE:</b> 36mm  <b>ESTIMATED CYCLE TIME:</b> 19s (6.9%)  <b>COOLANT:</b> Flood</p>	<p><b>T55 D55 L55</b>  <b>TYPE:</b> chamfer mill  <b>DIAMETER:</b> 5mm  <b>TAPER ANGLE:</b> 45°  <b>LENGTH:</b> 24mm  <b>FLUTES:</b> 2  <b>DESCRIPTION:</b> Chamfer</p>	
<p>Operation 6/6  <b>DESCRIPTION:</b> 2D Contour9  <b>STRATEGY:</b> Contour 2D  <b>WCS:</b> #0  <b>TOLERANCE:</b> 0.01mm  <b>STOCK TO LEAVE:</b> 0mm  <b>MAXIMUM STEPOVER:</b> 4.75mm</p>	<p><b>MAXIMUM Z:</b> 15mm  <b>MINIMUM Z:</b> -10mm  <b>MAXIMUM SPINDLE SPEED:</b> 6000rpm  <b>MAXIMUM FEEDRATE:</b> 500mm/min  <b>CUTTING DISTANCE:</b> 110.62mm  <b>RAPID DISTANCE:</b> 34.5mm  <b>ESTIMATED CYCLE TIME:</b> 17s (6.3%)  <b>COOLANT:</b> Flood</p>	<p><b>T55 D55 L55</b>  <b>TYPE:</b> chamfer mill  <b>DIAMETER:</b> 5mm  <b>TAPER ANGLE:</b> 45°  <b>LENGTH:</b> 24mm  <b>FLUTES:</b> 2  <b>DESCRIPTION:</b> Chamfer</p>	