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%)

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%)

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%)
### Operations

<table>
<thead>
<tr>
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</tr>
</thead>
<tbody>
<tr>
<td><strong>1/6</strong></td>
<td>Face1</td>
<td>Facing</td>
<td>#0</td>
<td>0.01mm</td>
<td>2mm</td>
<td>22.8mm</td>
<td>8mm</td>
<td>0.8mm</td>
<td>321.87mm</td>
<td>40.35mm</td>
<td>13s (4.7%)</td>
<td>T25</td>
<td>2</td>
<td>Sandvik Coromant 25mm ALU</td>
</tr>
<tr>
<td><strong>2/6</strong></td>
<td>2D Adaptive3</td>
<td>Adaptive 2D</td>
<td>#0</td>
<td>0.1mm</td>
<td>0.3mm/0mm</td>
<td>11.4mm</td>
<td>8mm</td>
<td>13.2mm</td>
<td>3092.32mm</td>
<td>108.47mm</td>
<td>1m:48s (39.7%)</td>
<td>T12</td>
<td>2</td>
<td>Flat End Mill 12mm ALU</td>
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<tr>
<td><strong>3/6</strong></td>
<td>2D Contour1</td>
<td>Contour 2D</td>
<td>#0</td>
<td>0.01mm</td>
<td>0mm</td>
<td>4.75mm</td>
<td>8mm</td>
<td>&lt;13.2mm</td>
<td>279.41mm</td>
<td>29.5mm</td>
<td>1m:0s (22.2%)</td>
<td>T55</td>
<td>2</td>
<td>Chamfer</td>
</tr>
<tr>
<td><strong>4/6</strong></td>
<td>2D Contour6</td>
<td>Contour 2D</td>
<td>#0</td>
<td>0.01mm</td>
<td>0mm</td>
<td>4.75mm</td>
<td>8mm</td>
<td>&lt;13.2mm</td>
<td>121.55mm</td>
<td>36mm</td>
<td>10s (3.8%)</td>
<td>T55</td>
<td>2</td>
<td>Chamfer</td>
</tr>
<tr>
<td><strong>5/6</strong></td>
<td>2D Contour7</td>
<td>Contour 2D</td>
<td>#0</td>
<td>0.01mm</td>
<td>0mm</td>
<td>4.75mm</td>
<td>8mm</td>
<td>&lt;13.2mm</td>
<td>110.62mm</td>
<td>34.5mm</td>
<td>19s (6.9%)</td>
<td>T55</td>
<td>2</td>
<td>Chamfer</td>
</tr>
<tr>
<td><strong>6/6</strong></td>
<td>2D Contour9</td>
<td>Contour 2D</td>
<td>#0</td>
<td>0.01mm</td>
<td>0mm</td>
<td>4.75mm</td>
<td>8mm</td>
<td>&lt;13.2mm</td>
<td>110.62mm</td>
<td>34.5mm</td>
<td>17s (6.3%)</td>
<td>T55</td>
<td>2</td>
<td>Chamfer</td>
</tr>
</tbody>
</table>

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