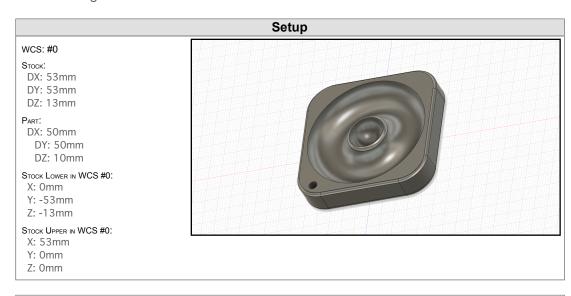
Setup Sheet for Program 1001

JOB DESCRIPTION: Setup3

DOCUMENT PATH: ringbox v4



Total

Number Of Operations: 11

Number Of Tools: 7

Tools: T101 T108 T114 T117 T132 T134 T171

Махімим **Z**: 15mm Міхімим **Z**: -13mm

MAXIMUM FEEDRATE: 5486.4mm/min
MAXIMUM SPINDLE SPEED: 12000rpm
CUTTING DISTANCE: 22852.19mm
RAPID DISTANCE: 1881.16mm
ESTIMATED CYCLE TIME: 14m:19s

Tools

T101 D101 L101

Type: spot drill
DIAMETER: 3.17mm
TIP ANGLE: 60°
LENGTH: 26.01mm
FLUTES: 2

DESCRIPTION: 1/8" Spot Drill

COMMENT: How to make a hole: spot drill, drill, tap or ream

VENDOR: MSC PRODUCT: 985085 Мінімим Z: -13mm

MAXIMUM FEED: 155.245mm/min
MAXIMUM SPINDLE SPEED: 12000rpm
CUTTING DISTANCE: 31.5mm

RAPID DISTANCE: 76.5mm
ESTIMATED CYCLE TIME: 13s (1.5%)

Holder: CAT40 Heat Shrink 1/8" - Haimer

VENDOR: MSC PRODUCT: 82213117



T108 D108 L108

Type: ball end mill
DIAMETER: 3.17mm
CORNER RADIUS: 1.59mm
LENGTH: 18.15mm
FLUTES: 3

DESCRIPTION: 1/8" Ball EM Long
COMMENT: Max Depth of Cut = 0.005"

VENDOR: MSC PRODUCT: 85183374 **М**імімим **Z**: -9mm

MAXIMUM FEED: 1828.8mm/min
MAXIMUM SPINDLE SPEED: 12000rpm
CUTTING DISTANCE: 15301.2mm
RAPID DISTANCE: 293.88mm

ESTIMATED CYCLE TIME: 8m:37s (60.3%)

HOLDER: CAT40 Heat Shrink 1/8" - Haimer

VENDOR: MSC PRODUCT: 82213117



T114 D114 L114

Type: flat end mill DIAMETER: 6.35mm LENGTH: 29.96mm

FLUTES: 3

DESCRIPTION: 1/4" EM Short

COMMENT: For pocket toolpaths, max depth of cut = 0.075"

VENDOR: MSC PRODUCT: 65249823 MINIMUM Z: -1 mm

MAXIMUM FEED: 2540mm/min
MAXIMUM SPINDLE SPEED: 12000rpm

CUTTING DISTANCE: 551.51mm

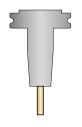
RAPID DISTANCE: 25.37mm

ESTIMATED CYCLE TIME: 14s (1.7%)

HOLDER: CAT40 Heat Shrink 1/4" - Haimer

VENDOR: MSC PRODUCT: 61772273

PRODUCT: 61772273



T117 D117 L117

Type: ball end mill
Diameter: 6.35mm
Corner Radius: 3.17mm
Length: 20.14mm

DESCRIPTION: 1/4" Ball EM Short

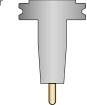
Comment: Max Depth of Cut = 0.020"

VENDOR: MSC PRODUCT: 85183440 Мимим Z: -10.99mm

MAXIMUM FEED: 5486.4mm/min
MAXIMUM SPINDLE SPEED: 12000rpm
CUTTING DISTANCE: 5128.74mm

RAPID DISTANCE: 1353.54mm ESTIMATED CYCLE TIME: 2m:11s (15.2%)

Holder: CAT40 Heat Shrink 1/4" - Haimer Vendor: MSC



T132 D132 L132

Type: bullnose end mill Diameter: 12.7mm Corner Radius: 0.51mm Length: 28.38mm

FLUTES: 3

FLUTES: 3

DESCRIPTION: 1/2" Rough EM Short

COMMENT: For pocket toolpaths, max depth of cut = 0.125"

VENDOR: MSC PRODUCT: 97290019 Мінімим Z: -10.49mm

MAXIMUM FEED: 4114.8mm/min
MAXIMUM SPINDLE SPEED: 12000rpm
CUTTING DISTANCE: 1401.39mm

RAPID DISTANCE: 66.91mm ESTIMATED CYCLE TIME: 22S (2.6%) Holder: CAT40 Heat Shrink 1/2" - Haimer

VENDOR: MSC PRODUCT: 61772216



T134 D134 L134

Type: flat end mill DIAMETER: 12.7mm LENGTH: 35.33mm

FLUTES: 3

DESCRIPTION: 1/2" EM Short

COMMENT: For pocket toolpaths, max depth of cut = 0.125"

VENDOR: MSC PRODUCT: 65250177 Мінімим Z: -9mm

MAXIMUM FEED: 4114.8mm/min
MAXIMUM SPINDLE SPEED: 12000rpm

CUTTING DISTANCE: 245mm
RAPID DISTANCE: 43.46mm
ESTIMATED CYCLE TIME: 4S (0.5%)

Holder: CAT40 Heat Shrink 1/2" - Haimer

VENDOR: MSC PRODUCT: 61772216



T171 D171 L171

Type: face mill
DIAMETER: 49.97mm
CORNER RADIUS: 0.38mm
LENGTH: 35.33mm
FILUTES: 5

DESCRIPTION: 2" Face Mill

Operation 1/11

DESCRIPTION: Face 1

STRATEGY: Facing

TOLERANCE: 0.01mm

MAXIMUM STEPOVER: 46.75mm

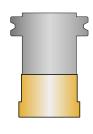
WCS: #0

COMMENT: Aluminum Only Max Depth of Cut = 0.100"

Vendor: MariTool Face Mill Holder MSAP16-D050A05Rx25.4

PRODUCT: Aluminum Only Inserts APET160508PDFRSN-DLC100

MINIMUM Z: -1.5mm Holder: CAT40 Arbor
MAXIMUM FEED: 2667mm/min



MAXIMUM Z: 15mm MINIMUM Z: -1.5mm

MAXIMUM SPINDLE SPEED: 7000rpm
MAXIMUM FEEDRATE: 2667mm/min
CUTTING DISTANCE: 192.85mm

RAPID DISTANCE: 21.5mm
ESTIMATED CYCLE TIME: 6S (0.7%)

COOLANT: Flood

Operations

MAXIMUM SPINDLE SPEED: 7000rpm

CUTTING DISTANCE: 192.85mm

ESTIMATED CYCLE TIME: 6S (0.7%)

RAPID DISTANCE: 21.5mm

T171 D171 L171

Type: face mill

DIAMETER: 49.97mm

CORNER RADIUS: 0.38mm

LENGTH: 35.33mm

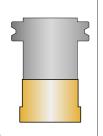
FLUTES: 5

Description: 2" Face Mill

COMMENT: Aluminum Only Max Depth of Cut = 0.100"

Vendor: MariTool Face Mill Holder MSAP16-D050A05Rx25.4

PRODUCT: Aluminum Only Inserts APET160508PDFRSN-DLC100



T117 D117 L117 Operation 2/11 Type: ball end mill Description: Adaptive 1 MAXIMUM Z: 15mm DIAMETER: 6.35mm Strategy: Adaptive Мимим Z: -10.99mm CORNER RADIUS: 3.17mm MAXIMUM SPINDLE SPEED: 12000rpm WCS: #0 LENGTH: 20.14mm Tolerance: 0.1mm MAXIMUM FEEDRATE: 5486,4mm/min STOCK TO LEAVE: 0.5mm FLUTES: 3 CUTTING DISTANCE: 4235.35mm DESCRIPTION: 1/4" Ball EM Short MAXIMUM STEPDOWN: 9.52mm RAPID DISTANCE: 1318.68mm Estimated Cycle Time: 1m:46s (12.4%) Comment: Max Depth of Cut = 0.020" OPTIMAL LOAD: 2.54mm VENDOR: MSC LOAD DEVIATION: 0.25mm COOLANT: Flood PRODUCT: 85183440 **T117** D117 L117 Operation 3/11 Type: ball end mill Description: Pocket2 MAXIMUM Z: 15mm DIAMETER: 6.35mm STRATEGY: Pocket **М**імімим **Z**: -7.5mm CORNER RADIUS: 3.17mm WCS: #0 MAXIMUM SPINDLE SPEED: 12000rpm Length: 20.14mm Tolerance: 0.1mm MAXIMUM FEEDRATE: 5486.4mm/min FILITES: 3 STOCK TO LEAVE: OMM CUTTING DISTANCE: 893.4mm DESCRIPTION: 1/4" Ball EM Short MAXIMUM STEPDOWN: 1mm RAPID DISTANCE: 34.87mm COMMENT: Max Depth of Cut = 0.020" MAXIMUM STEPOVER: 1.27mm ESTIMATED CYCLE TIME: 24S (2.8%) VENDOR: MSC COOLANT: Flood PRODUCT: 85183440 Operation 4/11 T108 D108 L108 DESCRIPTION: Steep and Shallow1 MAXIMUM Z: 15mm Type: ball end mill DIAMETER: 3.17mm wcs: #0 **М**імімим **Z**: -9mm CORNER RADIUS: 1.59mm TOLERANCE: 0.01mm MAXIMUM SPINDLE SPEED: 12000rpm LENGTH: 18.15mm STOCK TO LEAVE: OMM MAXIMUM FEEDRATE: 1828.8mm/min FLUTES: 3 MAXIMUM STEPDOWN: 0.16mm CUTTING DISTANCE: 14366.84mm DESCRIPTION: 1/8" Ball EM Long MAXIMUM STEPOVER: 0.16mm RAPID DISTANCE: 230.16mm COMMENT: Max Depth of Cut = 0.005" ESTIMATED CYCLE TIME: 8m:5s (56.5%) VENDOR: MSC COOLANT: Flood PRODUCT: 85183374 **T101** D101 L101 Operation 5/11 Type: spot drill DESCRIPTION: Drill1 MAXIMUM Z: 15mm DIAMETER: 3.17mm STRATEGY: Drilling **М**імімим **Z**: -13mm TIP ANGLE: 60° WCS: #0 MAXIMUM SPINDLE SPEED: 12000rpm TOLERANCE: 0.01mm MAXIMUM FEEDRATE: 155.245mm/min LENGTH: 26.01mm CUTTING DISTANCE: 16.5mm Flutes: 2 DESCRIPTION: 1/8" Spot Drill RAPID DISTANCE: 39.5mm COMMENT: How to make a hole: spot drill, drill, tap or ream ESTIMATED CYCLE TIME: 7S (0.8%) VENDOR: MSC COOLANT: Flood Ркорист: 985085 T134 D134 L134 Operation 6/11 Type: flat end mill Description: 2D Adaptive4 MAXIMUM Z: 15mm DIAMETER: 12.7mm STRATEGY: Adaptive 2D Мінімим Z: -9mm **LENGTH: 35.33mm** MAXIMUM SPINDLE SPEED: 12000rpm wcs: #0 FLUTES: 3 Tolerance: 0.1mm MAXIMUM FEEDRATE: 4114.8mm/min DESCRIPTION: 1/2" EM Short STOCK TO LEAVE: 0.5mm CUTTING DISTANCE: 245mm OPTIMAL LOAD: 5.08mm RAPID DISTANCE: 43.46mm COMMENT: For pocket toolpaths, max depth of cut = 0.125" LOAD DEVIATION: 0.51mm ESTIMATED CYCLE TIME: 4S (0.5%) PRODUCT: 65250177 COOLANT: Flood T108 D108 L108 Operation 7/11 Type: ball end mill DESCRIPTION: Ramp1 MAXIMUM Z: 15mm STRATEGY: Ramp Мінімим Z: -3.5mm DIAMETER: 3.17mm CORNER RADIUS: 1.59mm WCS: #0 MAXIMUM SPINDLE SPEED: 12000rpm TOLERANCE: 0.01mm MAXIMUM FEEDRATE: 1828.8mm/min LENGTH: 18.15mm FLUTES: 3 STOCK TO LEAVE: OMM CUTTING DISTANCE: 573.76mm DESCRIPTION: 1/8" Ball EM Long RAPID DISTANCE: 33.43mm MAXIMUM STEPDOWN: 1mm COMMENT: Max Depth of Cut = 0.005" ESTIMATED CYCLE TIME: 20s (2.3%) VENDOR: MSC COOLANT: Flood PRODUCT: 85183374

T132 D132 L132 Operation 8/11 Type: bullnose end mill Description: Adaptive 2 MAXIMUM Z: 15mm DIAMETER: 12.7mm Strategy: Adaptive Мимим Z: -10.49mm CORNER RADIUS: 0.51mm WCS: #0 MAXIMUM SPINDLE SPEED: 12000rpm LENGTH: 28.38mm Tolerance: 0.1mm MAXIMUM FEEDRATE: 4114.8mm/min FLUTES: 3 STOCK TO LEAVE: 0.5mm CUTTING DISTANCE: 1401.39mm RAPID DISTANCE: 66.91mm DESCRIPTION: 1/2" Rough EM Short MAXIMUM STEPDOWN: 10mm COMMENT: For pocket toolpaths, max depth of cut = 0.125" OPTIMAL LOAD: 5.08mm ESTIMATED CYCLE TIME: 22s (2.6%) VENDOR: MSC LOAD DEVIATION: 0.51mm COOLANT: Flood Ркорист: 97290019 **T114** D114 L114 Operation 9/11 Type: flat end mill Description: Face 2 MAXIMUM Z: 15mm DIAMETER: 6.35mm STRATEGY: Facing Мінімим Z: -1 mm LENGTH: 29.96mm WCS: #0 MAXIMUM SPINDLE SPEED: 12000rpm TOLERANCE: 0.01mm MAXIMUM FEEDRATE: 2540mm/min FLUTES: 3 DESCRIPTION: 1/4" EM Short MAXIMUM STEPOVER: 6.03mm CUTTING DISTANCE: 551.51mm COMMENT: For pocket toolpaths, max depth of cut = 0.075" RAPID DISTANCE: 25.37mm ESTIMATED CYCLE TIME: 14S (1.7%) PRODUCT: 65249823 COOLANT: Flood T108 D108 L108 Operation 10/11 Type: ball end mill Description: Scallop2 MAXIMUM Z: 15mm DIAMETER: 3.17mm Strategy: Scallop Мимим Z: -1.61mm CORNER RADIUS: 1.59mm WCS: #0 MAXIMUM SPINDLE SPEED: 12000rpm Tolerance: 0.01mm MAXIMUM FEEDRATE: 1828.8mm/min LENGTH: 18.15mm STOCK TO LEAVE: 0mm CUTTING DISTANCE: 360.59mm FLUTES: 3 RAPID DISTANCE: 30.3mm DESCRIPTION: 1/8" Ball EM Long MAXIMUM STEPOVER: 1.59mm COMMENT: Max Depth of Cut = 0.005" ESTIMATED CYCLE TIME: 13s (1.5%) VENDOR: MSC COOLANT: Flood PRODUCT: 85183374 **T101** D101 L101 Operation 11/11 Type: spot drill DESCRIPTION: Drill2 MAXIMUM Z: 15mm DIAMETER: 3.17mm STRATEGY: Drilling **М**імімим **Z**: -11mm TIP ANGLE: 60° WCS: #0 MAXIMUM SPINDLE SPEED: 12000rpm MAXIMUM FEEDRATE: 155.245mm/min Length: 26.01mm TOLERANCE: 0.01mm FLUTES: 2 CUTTING DISTANCE: 15mm DESCRIPTION: 1/8" Spot Drill RAPID DISTANCE: 37mm COMMENT: How to make a hole: spot drill, drill, tap or ream ESTIMATED CYCLE TIME: 6S (0.7%) VENDOR: MSC COOLANT: Flood Ркорист: 985085