Setup Sheet for Program 13707

JOB DESCRIPTION: OP1

DOCUMENT PATH: Coaster 7th v13

NOTES:

```
X0 Y0 Center of Part
Z0 Top of Part
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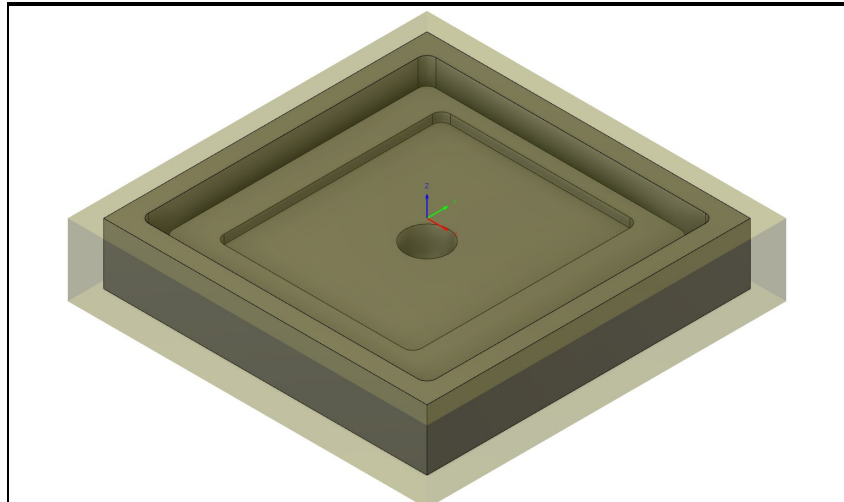| Setup	
WCS: #0 STOCK: DX: 5in DY: 5in DZ: 1in PART: DX: 4.5in DY: 4.5in DZ: 0.85in STOCK LOWER IN WCS #0: X: -2.5in Y: -2.5in Z: -1in STOCK UPPER IN WCS #0: X: 2.5in Y: 2.5in Z: 0in	

Total

NUMBER OF OPERATIONS: 5
NUMBER OF TOOLS: 2
TOOLS: **T2 T3**
MAXIMUM Z: 0.6in
MINIMUM Z: -0.95in
MAXIMUM FEEDRATE: 126.06in/min
MAXIMUM SPINDLE SPEED: 7000rpm
CUTTING DISTANCE: 1434.553in
RAPID DISTANCE: 122.003in
ESTIMATED CYCLE TIME: 25m:29s

Tools

T2 D2 L2

TYPE: flat end mill	MINIMUM Z: -0.95in	HOLDER: Maritool CAT40-ER32-2.35
DIAMETER: 0.5in	MAXIMUM FEED: 126.06in/min	VENDOR: Maritool
LENGTH: 1.1in	MAXIMUM SPINDLE SPEED: 6500rpm	PRODUCT: CAT40-ER32-2.35
FLUTES: 3	CUTTING DISTANCE: 836.596in	
DESCRIPTION: 1/2" Flat Endmill	RAPID DISTANCE: 31.589in	
	ESTIMATED CYCLE TIME: 9m:46s (38.3%)	

T3 D3 L3

TYPE: flat end mill
DIAMETER: 0.125in
LENGTH: 0.6in
FLUTES: 3
DESCRIPTION: 1/8" Flat Endmill

MINIMUM Z: -0.5in
MAXIMUM FEED: 40in/min
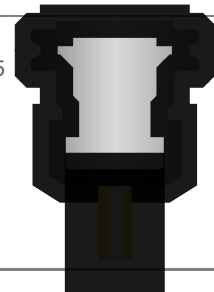MAXIMUM SPINDLE SPEED: 7000rpm
CUTTING DISTANCE: 597.957in
RAPID DISTANCE: 90.414in
ESTIMATED CYCLE TIME: 14m:58s (58.7%)
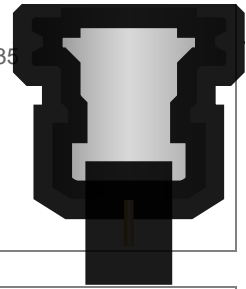
HOLDER: Maritool CAT40-ER32-2.35
VENDOR: Maritool
PRODUCT: CAT40-ER32-2.35

Operations

Operation 1/5		T2 D2 L2

Operation 1/5

DESCRIPTION: Adaptive1
STRATEGY: Adaptive
WCS: #0
TOLERANCE: 0.004in
STOCK TO LEAVE: 0.01in
MAXIMUM STEPDOWN: 0.175in
OPTIMAL LOAD: 0.05in
LOAD DEVIATION: 0.005in

MAXIMUM Z: 0.6in
MINIMUM Z: -0.315in
MAXIMUM SPINDLE SPEED: 6500rpm
MAXIMUM FEEDRATE: 126.06in/min
CUTTING DISTANCE: 816.479in
RAPID DISTANCE: 29.144in
ESTIMATED CYCLE TIME: 9m:31s (37.4%)
COOLANT: Flood

T2 D2 L2

TYPE: flat end mill
DIAMETER: 0.5in
LENGTH: 1.1in
FLUTES: 3
DESCRIPTION: 1/2" Flat Endmill

Operation 2/5

DESCRIPTION: 2D Pocket2
STRATEGY: Pocket 2D
WCS: #0
TOLERANCE: 0.004in
STOCK TO LEAVE: 0in
MAXIMUM STEPOVER: 0.05in

MAXIMUM Z: 0.6in
MINIMUM Z: -0.325in
MAXIMUM SPINDLE SPEED: 7000rpm
MAXIMUM FEEDRATE: 40in/min
CUTTING DISTANCE: 178.406in
RAPID DISTANCE: 1.313in
ESTIMATED CYCLE TIME: 4m:28s (17.5%)
COOLANT: Flood

T3 D3 L3

TYPE: flat end mill
DIAMETER: 0.125in
LENGTH: 0.6in
FLUTES: 3
DESCRIPTION: 1/8" Flat Endmill

Operation 3/5

DESCRIPTION: 2D Pocket2 (3)
STRATEGY: Pocket 2D
WCS: #0
TOLERANCE: 0.004in
STOCK TO LEAVE: 0in
MAXIMUM STEPOVER: 0.05in

MAXIMUM Z: 0.6in
MINIMUM Z: -0.2in
MAXIMUM SPINDLE SPEED: 7000rpm
MAXIMUM FEEDRATE: 40in/min
CUTTING DISTANCE: 150.272in
RAPID DISTANCE: 24.415in
ESTIMATED CYCLE TIME: 3m:46s (14.8%)
COOLANT: Flood

T3 D3 L3

TYPE: flat end mill
DIAMETER: 0.125in
LENGTH: 0.6in
FLUTES: 3
DESCRIPTION: 1/8" Flat Endmill
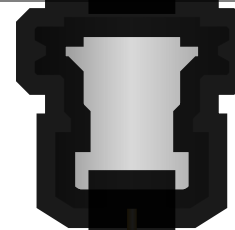
Operation 4/5

DESCRIPTION: 2D Pocket2 (2)
STRATEGY: Pocket 2D
WCS: #0
TOLERANCE: 0.004in
STOCK TO LEAVE: 0in
MAXIMUM STEPDOWN: 0.1in
MAXIMUM STEPOVER: 0.05in

MAXIMUM Z: 0.6in
MINIMUM Z: -0.5in
MAXIMUM SPINDLE SPEED: 7000rpm
MAXIMUM FEEDRATE: 40in/min
CUTTING DISTANCE: 269.279in
RAPID DISTANCE: 64.687in
ESTIMATED CYCLE TIME: 6m:45s (26.5%)
COOLANT: Flood

T3 D3 L3

TYPE: flat end mill
DIAMETER: 0.125in
LENGTH: 0.6in
FLUTES: 3
DESCRIPTION: 1/8" Flat Endmill

Operation 5/5

DESCRIPTION: Bore1
STRATEGY: Bore
WCS: #0
TOLERANCE: 0in
STOCK TO LEAVE: 0in

MAXIMUM Z: 0.6in
MINIMUM Z: -0.95in
MAXIMUM SPINDLE SPEED: 6500rpm
MAXIMUM FEEDRATE: 126.06in/min
CUTTING DISTANCE: 20.118in
RAPID DISTANCE: 2.445in
ESTIMATED CYCLE TIME: 15s (1%)
COOLANT: Flood

T2 D2 L2

TYPE: flat end mill
DIAMETER: 0.5in
LENGTH: 1.1in
FLUTES: 3
DESCRIPTION: 1/2" Flat Endmill
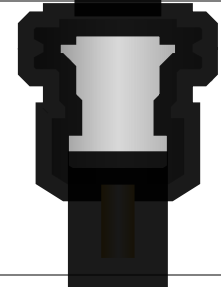
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