

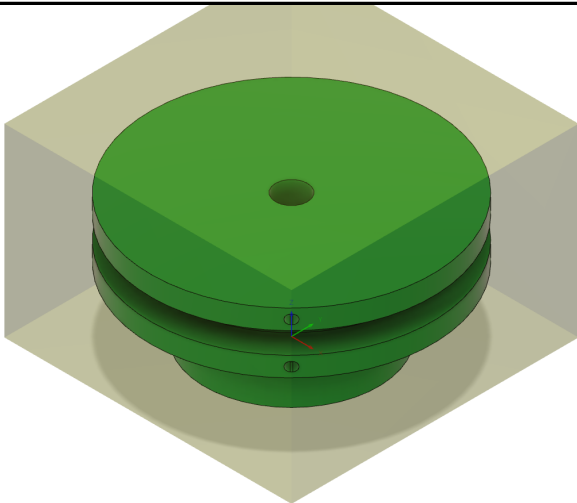
# Setup Sheet for Program 6295581101\_OP2

JOB DESCRIPTION: OP2


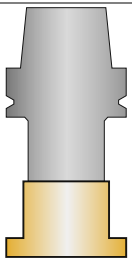
DOCUMENT PATH: 6295581101-001-0 v8

NOTES:

X0 Y0 Center of Part  
Z0 Bottom of Part

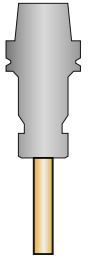
Setup	
<p>WCS: #30</p> <p>STOCK:</p> <p>DX: 162mm</p> <p>DY: 162mm</p> <p>DZ: 104mm</p> <p>PART:</p> <p>DX: 159mm</p> <p>DY: 159mm</p> <p>DZ: 70mm</p> <p>STOCK LOWER IN WCS #30:</p> <p>X: -81mm</p> <p>Y: -81mm</p> <p>Z: -0.5mm</p> <p>STOCK UPPER IN WCS #30:</p> <p>X: 81mm</p> <p>Y: 81mm</p> <p>Z: 103.5mm</p>	

Total
<p>NUMBER OF OPERATIONS: 5</p> <p>NUMBER OF TOOLS: 4</p> <p>TOOLS: <b>T1 T402 T1160 T7610</b></p> <p>MAXIMUM Z: 258.5mm</p> <p>MINIMUM Z: 66mm</p> <p>MAXIMUM FEEDRATE: 4240mm/min</p> <p>MAXIMUM SPINDLE SPEED: 4576rpm</p> <p>CUTTING DISTANCE: 44427.32mm</p> <p>RAPID DISTANCE: 9515.88mm</p> <p>ESTIMATED CYCLE TIME: 17m:38s</p>

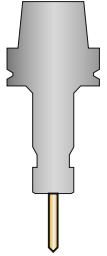
Tools		
<p><b>T1 D1 L1</b></p> <p>TYPE: probe</p> <p>DIAMETER: 4mm</p> <p>CORNER RADIUS: 2mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 1</p> <p>DESCRIPTION: DMU75mB Probe</p>	<p>MINIMUM Z: 66mm</p> <p>MAXIMUM FEED: 0mm/min</p> <p>MAXIMUM SPINDLE SPEED: 0rpm</p> <p>CUTTING DISTANCE: 0mm</p> <p>RAPID DISTANCE: 0mm</p> <p>ESTIMATED CYCLE TIME: 0s (0%)</p>	
<p><b>T402 D402 L402</b></p> <p>TYPE: face mill</p> <p>DIAMETER: 63mm</p> <p>LENGTH: 40mm</p> <p>FLUTES: 6</p> <p>DESCRIPTION: AL-PMK-D63</p> <p>VENDOR: Hoffmann Group</p> <p>PRODUCT: <a href="#">213555 63/6</a></p>	<p>MINIMUM Z: 70mm</p> <p>MAXIMUM FEED: 4240mm/min</p> <p>MAXIMUM SPINDLE SPEED: 3540rpm</p> <p>CUTTING DISTANCE: 40444.61mm</p> <p>RAPID DISTANCE: 4630.15mm</p> <p>ESTIMATED CYCLE TIME: 12m:8s (68.8%)</p>	<p>HOLDER: HSK A63-Face mill adapter 22 mm</p> <p>VENDOR: Hoffmann Group</p> <p>PRODUCT: 306110 22</p> 

**T1160 D1160 L1160**

TYPE: flat end mill	MINIMUM Z: 69mm	HOLDER: HSK A63-ER25
DIAMETER: 16mm	MAXIMUM FEED: 1372.711mm/min	VENDOR: Hoffmann Group
LENGTH: 82mm	MAXIMUM SPINDLE SPEED: 4576rpm	PRODUCT: 305390 25
FLUTES: 1	CUTTING DISTANCE: 3344.85mm	
DESCRIPTION: HM-KU-1SCHN-D16_SR	RAPID DISTANCE: 4712.63mm	
VENDOR: Schmid Werkzeug Muenchen	ESTIMATED CYCLE TIME: 3m:23s (19.2%)	
PRODUCT: <a href="#">016-16</a>		

**T7610 D7610 L7610**

TYPE: chamfer mill	MINIMUM Z: 68.8mm	HOLDER: HSK A63-ER16
DIAMETER: 6mm	MAXIMUM FEED: 509.296mm/min	VENDOR: Hoffmann Group
TAPER ANGLE: 45°	MAXIMUM SPINDLE SPEED: 4244rpm	PRODUCT: 305390 16
LENGTH: 40mm	CUTTING DISTANCE: 637.86mm	
FLUTES: 4	RAPID DISTANCE: 173.1mm	
DESCRIPTION: FASENFR-D6X45GRAD	ESTIMATED CYCLE TIME: 1m:22s (7.8%)	
VENDOR: Hoffmann Group		
PRODUCT: <a href="#">208120 6</a>		



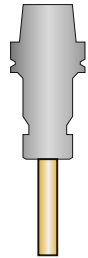
### Operations

**Operation 1/5**

DESCRIPTION: 2D Adaptive3	MAXIMUM Z: 118.5mm
STRATEGY: Adaptive 2D	MINIMUM Z: 69mm
WCS: #30	MAXIMUM SPINDLE SPEED: 4576rpm
TOLERANCE: 0.1mm	MAXIMUM FEEDRATE: 1372.711mm/min
STOCK TO LEAVE: 3mm/0mm	CUTTING DISTANCE: 3344.85mm
OPTIMAL LOAD: 2mm	RAPID DISTANCE: 4712.63mm
LOAD DEVIATION: 0.2mm	ESTIMATED CYCLE TIME: 3m:23s (19.2%)
	COOLANT: Air

**T1160 D1160 L1160**

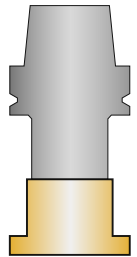
TYPE: flat end mill
DIAMETER: 16mm
LENGTH: 82mm
FLUTES: 1
DESCRIPTION: HM-KU-1SCHN-D16_SR
VENDOR: Schmid Werkzeug Muenchen
PRODUCT: <a href="#">016-16</a>

**Operation 2/5**

DESCRIPTION: Face2	MAXIMUM Z: 118.5mm
STRATEGY: Facing	MINIMUM Z: 70.1mm
WCS: #30	MAXIMUM SPINDLE SPEED: 3540rpm
TOLERANCE: 0.01mm	MAXIMUM FEEDRATE: 4240mm/min
MAXIMUM STEPDOWN: 1mm	CUTTING DISTANCE: 39272.95mm
MAXIMUM STEPOVER: 44.1mm	RAPID DISTANCE: 4577.95mm
	ESTIMATED CYCLE TIME: 10m:11s (57.7%)
	COOLANT: Flood

**T402 D402 L402**

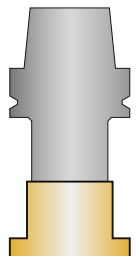
TYPE: face mill
DIAMETER: 63mm
LENGTH: 40mm
FLUTES: 6
DESCRIPTION: AL-PMK-D63
VENDOR: Hoffmann Group
PRODUCT: <a href="#">213555 63/6</a>

**Operation 3/5**

DESCRIPTION: Face2 (2)	MAXIMUM Z: 118.5mm
STRATEGY: Facing	MINIMUM Z: 70mm
WCS: #30	MAXIMUM SPINDLE SPEED: 3540rpm
TOLERANCE: 0.01mm	MAXIMUM FEEDRATE: 600mm/min
MAXIMUM STEPOVER: 44.1mm	CUTTING DISTANCE: 1171.66mm
	RAPID DISTANCE: 52.2mm
	ESTIMATED CYCLE TIME: 1m:58s (11.1%)
	COOLANT: Flood

**T402 D402 L402**

TYPE: face mill
DIAMETER: 63mm
LENGTH: 40mm
FLUTES: 6
DESCRIPTION: AL-PMK-D63
VENDOR: Hoffmann Group
PRODUCT: <a href="#">213555 63/6</a>

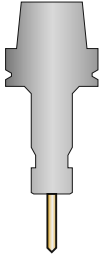
**Operation 4/5**

DESCRIPTION: Probe WCS1	MAXIMUM Z: 258.5mm
STRATEGY: Probe	MINIMUM Z: 66mm
WCS: #30	
TOLERANCE: 0.01mm	

**T1 D1 L1**

TYPE: probe
DIAMETER: 4mm
CORNER RADIUS: 2mm
LENGTH: 50mm
FLUTES: 1
DESCRIPTION: DMU75mB Probe



Operation 5/5		<b>T7610 D7610 L7610</b>	
DESCRIPTION: 2D Chamfer2	MAXIMUM Z: 118.5mm	TYPE: chamfer mill	
WCS: #30	MINIMUM Z: 68.8mm	DIAMETER: 6mm	
TOLERANCE: 0.01mm	MAXIMUM SPINDLE SPEED: 4244rpm	TAPER ANGLE: 45°	
STOCK TO LEAVE: 0mm	MAXIMUM FEEDRATE: 509.296mm/min	LENGTH: 40mm	
	CUTTING DISTANCE: 637.86mm	FLUTES: 4	
	RAPID DISTANCE: 173.1mm	DESCRIPTION: FASENFR-D6X45GRAD	
	ESTIMATED CYCLE TIME: 1m:22s (7.8%)	VENDOR: Hoffmann Group	
	COOLANT: Flood	PRODUCT: <a href="#">208120 6</a>	

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