

# Setup Sheet for Program 6295581101\_OP3

JOB DESCRIPTION: OP3

DOCUMENT PATH: 6295581101-001-0 v8

NOTES:

X0 Y0 Center of Bore  
Z0 Top of Part

## Setup

WCS: #30

STOCK:

DX: 159mm

DY: 159mm

DZ: 70mm

PART:

DX: 159mm

DY: 159mm

DZ: 70mm

STOCK LOWER IN WCS #30:

X: -79.5mm

Y: -79.5mm

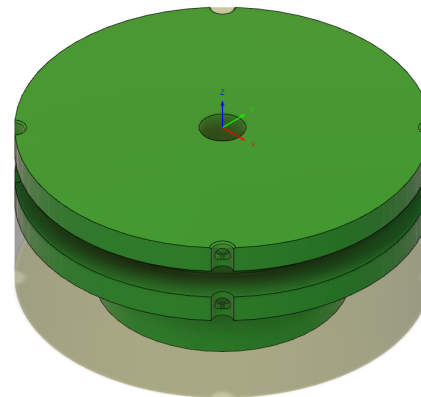
Z: -70mm

STOCK UPPER IN WCS #30:

X: 79.5mm

Y: 79.5mm

Z: 0mm



## Total

NUMBER OF OPERATIONS: 21

NUMBER OF TOOLS: 6

TOOLS: T2 T5 T10 T102 T230 T1030

MAXIMUM FEEDRATE: 2160mm/min

MAXIMUM SPINDLE SPEED: 10610rpm

CUTTING DISTANCE: 18869.64mm

RAPID DISTANCE: 26108.06mm

ESTIMATED CYCLE TIME: 35m:58s

## Tools

### T2 D2 L2

TYPE: drill

DIAMETER: 3.5mm

TIP ANGLE: 130°

LENGTH: 100mm

FLUTES: 1

MAXIMUM FEED: 100mm/min

MAXIMUM SPINDLE SPEED: 1000rpm

CUTTING DISTANCE: 424.21mm

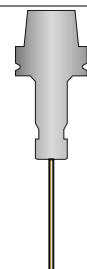
RAPID DISTANCE: 20783.86mm

ESTIMATED CYCLE TIME: 8m:48s (24.5%)

HOLDER: HSK A63-ER16

VENDOR: Hoffmann Group

PRODUCT: 305390 16



### T5 D5 L5

TYPE: spot drill

DIAMETER: 6mm

TIP ANGLE: 90°

LENGTH: 46mm

FLUTES: 2

DESCRIPTION: ZENBO-D6\_90GRAD

VENDOR: Hoffmann Group

PRODUCT: [112020 6](#)

MAXIMUM FEED: 39.789mm/min

MAXIMUM SPINDLE SPEED: 1000rpm

CUTTING DISTANCE: 52mm

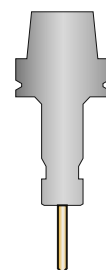
RAPID DISTANCE: 284.66mm

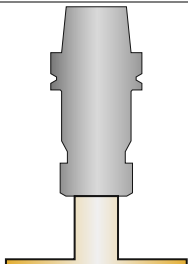
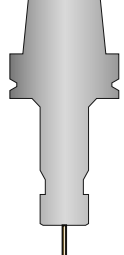
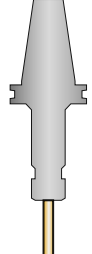
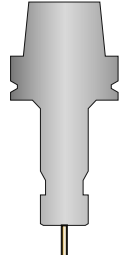
ESTIMATED CYCLE TIME: 1m:22s (3.8%)

HOLDER: HSK A63-ER16

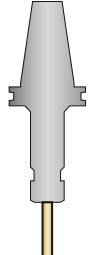
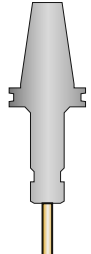
VENDOR: Hoffmann Group

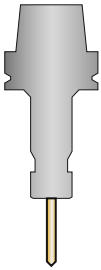
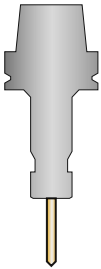
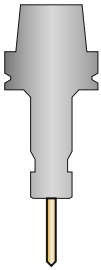
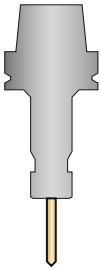
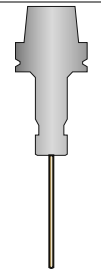
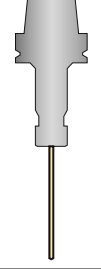
PRODUCT: 305390 16

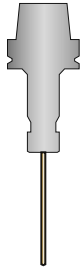
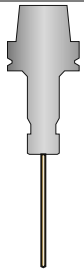
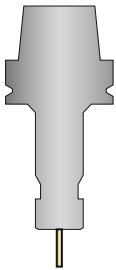
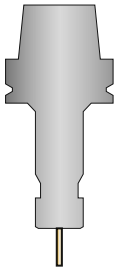
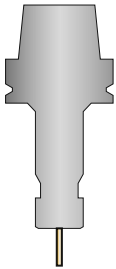
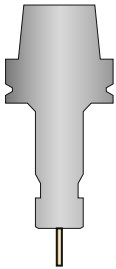


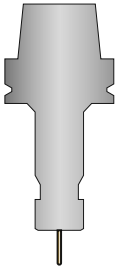
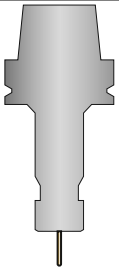
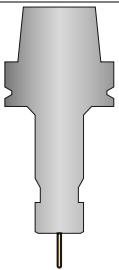
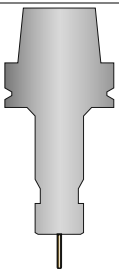
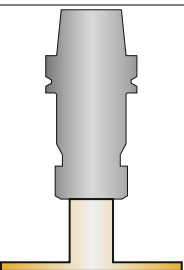
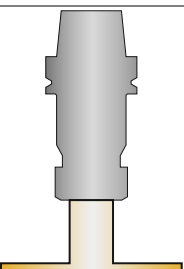
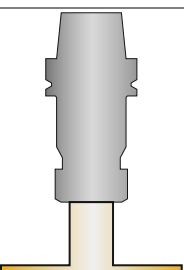
<b>T10 D10 L10</b> TYPE: slot mill DIAMETER: 125mm LENGTH: 50mm FLUTES: 64	MAXIMUM FEED: 782.278mm/min MAXIMUM SPINDLE SPEED: 2037rpm CUTTING DISTANCE: 10531.62mm RAPID DISTANCE: 97.5mm ESTIMATED CYCLE TIME: 13m:30s (37.5%)	HOLDER: HSK A63-ER32 VENDOR: Hoffmann Group PRODUCT: 305390 32	
<b>T102 D102 L102</b> TYPE: ball end mill DIAMETER: 2mm CORNER RADIUS: 1mm LENGTH: 20mm FLUTES: 4	MAXIMUM FEED: 1600mm/min MAXIMUM SPINDLE SPEED: 8000rpm CUTTING DISTANCE: 943.48mm RAPID DISTANCE: 118.43mm ESTIMATED CYCLE TIME: 37s (1.7%)	HOLDER: HSK A63-ER16 VENDOR: Hoffmann Group PRODUCT: <a href="#">305390 16</a>	
<b>T230 D230 L230</b> TYPE: flat end mill DIAMETER: 8mm LENGTH: 51mm FLUTES: 3 DESCRIPTION: 8mm Roughing Endmill Long VENDOR: Hoffmann Group PRODUCT: <a href="#">202282 8</a>	MAXIMUM FEED: 2160mm/min MAXIMUM SPINDLE SPEED: 8000rpm CUTTING DISTANCE: 5031.51mm RAPID DISTANCE: 4560.16mm ESTIMATED CYCLE TIME: 7m:15s (20.2%)	HOLDER: SK40-ER16 VENDOR: Hoffmann Group PRODUCT: 300510-16	
<b>T1030 D1030 L1030</b> TYPE: flat end mill DIAMETER: 3mm LENGTH: 22mm FLUTES: 1 DESCRIPTION: HM-KU-1SCHN-D3 VENDOR: Schmid Werkzeug Muenchen PRODUCT: <a href="#">016-3</a>	MAXIMUM FEED: 1061.033mm/min MAXIMUM SPINDLE SPEED: 10610rpm CUTTING DISTANCE: 1886.82mm RAPID DISTANCE: 263.46mm ESTIMATED CYCLE TIME: 2m:57s (8.2%)	HOLDER: HSK A63-ER16 VENDOR: Hoffmann Group PRODUCT: <a href="#">305390 16</a>	

## Operations

Operation 1/21 DESCRIPTION: 2D Contour4 STRATEGY: Contour 2D WCS: #30 TOLERANCE: 0.01mm STOCK TO LEAVE: 0.1mm/0mm MAXIMUM STEPDOWN: 2mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 8000rpm MAXIMUM FEEDRATE: 2160mm/min CUTTING DISTANCE: 2513.98mm RAPID DISTANCE: 2283.87mm ESTIMATED CYCLE TIME: 3m:38s (10.1%) COOLANT: Flood	<b>T230 D230 L230</b> TYPE: flat end mill DIAMETER: 8mm LENGTH: 51mm FLUTES: 3 DESCRIPTION: 8mm Roughing Endmill Long VENDOR: Hoffmann Group PRODUCT: <a href="#">202282 8</a>	
Operation 2/21 DESCRIPTION: 2D Contour4 (2) STRATEGY: Contour 2D WCS: #30 TOLERANCE: 0.01mm STOCK TO LEAVE: 0mm MAXIMUM STEPDOWN: 2mm MAXIMUM STEPOVER: 7.6mm	MAXIMUM SPINDLE SPEED: 8000rpm MAXIMUM FEEDRATE: 2160mm/min CUTTING DISTANCE: 2517.54mm RAPID DISTANCE: 2276.28mm ESTIMATED CYCLE TIME: 3m:38s (10.1%) COOLANT: Flood	<b>T230 D230 L230</b> TYPE: flat end mill DIAMETER: 8mm LENGTH: 51mm FLUTES: 3 DESCRIPTION: 8mm Roughing Endmill Long VENDOR: Hoffmann Group PRODUCT: <a href="#">202282 8</a>	

<b>Operation 3/21</b> <b>DESCRIPTION:</b> Drill4 <b>STRATEGY:</b> Drilling <b>WCS:</b> #30 <b>PATTERN GROUP:</b> A <b>TOLERANCE:</b> 0.01mm	<b>MAXIMUM SPINDLE SPEED:</b> 1000rpm <b>MAXIMUM FEEDRATE:</b> 39.789mm/min <b>CUTTING DISTANCE:</b> 13mm <b>RAPID DISTANCE:</b> 71.16mm <b>ESTIMATED CYCLE TIME:</b> 20s (0.9%) <b>COOLANT:</b> Flood	<b>T5 D5 L5</b> <b>TYPE:</b> spot drill <b>DIAMETER:</b> 6mm <b>TIP ANGLE:</b> 90° <b>LENGTH:</b> 46mm <b>FLUTES:</b> 2 <b>DESCRIPTION:</b> ZENBO-D6_90GRAD <b>VENDOR:</b> Hoffmann Group <b>PRODUCT:</b> <a href="#">112020 6</a>	
<b>Operation 4/21</b> <b>DESCRIPTION:</b> Drill4 <b>STRATEGY:</b> Drilling <b>WCS:</b> #30 <b>PATTERN GROUP:</b> A <b>TOLERANCE:</b> 0.01mm	<b>MAXIMUM SPINDLE SPEED:</b> 1000rpm <b>MAXIMUM FEEDRATE:</b> 39.789mm/min <b>CUTTING DISTANCE:</b> 13mm <b>RAPID DISTANCE:</b> 71.16mm <b>ESTIMATED CYCLE TIME:</b> 20s (0.9%) <b>COOLANT:</b> Flood	<b>T5 D5 L5</b> <b>TYPE:</b> spot drill <b>DIAMETER:</b> 6mm <b>TIP ANGLE:</b> 90° <b>LENGTH:</b> 46mm <b>FLUTES:</b> 2 <b>DESCRIPTION:</b> ZENBO-D6_90GRAD <b>VENDOR:</b> Hoffmann Group <b>PRODUCT:</b> <a href="#">112020 6</a>	
<b>Operation 5/21</b> <b>DESCRIPTION:</b> Drill4 <b>STRATEGY:</b> Drilling <b>WCS:</b> #30 <b>PATTERN GROUP:</b> A <b>TOLERANCE:</b> 0.01mm	<b>MAXIMUM SPINDLE SPEED:</b> 1000rpm <b>MAXIMUM FEEDRATE:</b> 39.789mm/min <b>CUTTING DISTANCE:</b> 13mm <b>RAPID DISTANCE:</b> 71.16mm <b>ESTIMATED CYCLE TIME:</b> 20s (0.9%) <b>COOLANT:</b> Flood	<b>T5 D5 L5</b> <b>TYPE:</b> spot drill <b>DIAMETER:</b> 6mm <b>TIP ANGLE:</b> 90° <b>LENGTH:</b> 46mm <b>FLUTES:</b> 2 <b>DESCRIPTION:</b> ZENBO-D6_90GRAD <b>VENDOR:</b> Hoffmann Group <b>PRODUCT:</b> <a href="#">112020 6</a>	
<b>Operation 6/21</b> <b>DESCRIPTION:</b> Drill4 <b>STRATEGY:</b> Drilling <b>WCS:</b> #30 <b>PATTERN GROUP:</b> A <b>TOLERANCE:</b> 0.01mm	<b>MAXIMUM SPINDLE SPEED:</b> 1000rpm <b>MAXIMUM FEEDRATE:</b> 39.789mm/min <b>CUTTING DISTANCE:</b> 13mm <b>RAPID DISTANCE:</b> 71.16mm <b>ESTIMATED CYCLE TIME:</b> 20s (0.9%) <b>COOLANT:</b> Flood	<b>T5 D5 L5</b> <b>TYPE:</b> spot drill <b>DIAMETER:</b> 6mm <b>TIP ANGLE:</b> 90° <b>LENGTH:</b> 46mm <b>FLUTES:</b> 2 <b>DESCRIPTION:</b> ZENBO-D6_90GRAD <b>VENDOR:</b> Hoffmann Group <b>PRODUCT:</b> <a href="#">112020 6</a>	
<b>Operation 7/21</b> <b>DESCRIPTION:</b> Drill4 (2) <b>STRATEGY:</b> Drilling <b>WCS:</b> #30 <b>PATTERN GROUP:</b> B <b>TOLERANCE:</b> 0.01mm	<b>MAXIMUM SPINDLE SPEED:</b> 1000rpm <b>MAXIMUM FEEDRATE:</b> 100mm/min <b>CUTTING DISTANCE:</b> 92.43mm <b>RAPID DISTANCE:</b> 3963.59mm <b>ESTIMATED CYCLE TIME:</b> 1m:49s (5.1%) <b>COOLANT:</b> Flood	<b>T2 D2 L2</b> <b>TYPE:</b> drill <b>DIAMETER:</b> 3.5mm <b>TIP ANGLE:</b> 130° <b>LENGTH:</b> 100mm <b>FLUTES:</b> 1	
<b>Operation 8/21</b> <b>DESCRIPTION:</b> Drill4 (2) <b>STRATEGY:</b> Drilling <b>WCS:</b> #30 <b>PATTERN GROUP:</b> B <b>TOLERANCE:</b> 0.01mm	<b>MAXIMUM SPINDLE SPEED:</b> 1000rpm <b>MAXIMUM FEEDRATE:</b> 100mm/min <b>CUTTING DISTANCE:</b> 92.43mm <b>RAPID DISTANCE:</b> 3963.59mm <b>ESTIMATED CYCLE TIME:</b> 1m:49s (5.1%) <b>COOLANT:</b> Flood	<b>T2 D2 L2</b> <b>TYPE:</b> drill <b>DIAMETER:</b> 3.5mm <b>TIP ANGLE:</b> 130° <b>LENGTH:</b> 100mm <b>FLUTES:</b> 1	

<p>Operation 9/21</p> <p>DESCRIPTION: Drill5</p> <p>STRATEGY: Drilling</p> <p>WCS: #30</p> <p>PATTERN GROUP: C</p> <p>TOLERANCE: 0.01mm</p>	<p>MAXIMUM SPINDLE SPEED: 1000rpm</p> <p>MAXIMUM FEEDRATE: 100mm/min</p> <p>CUTTING DISTANCE: 119.68mm</p> <p>RAPID DISTANCE: 6428.34mm</p> <p>ESTIMATED CYCLE TIME: 2m:35s (7.2%)</p> <p>COOLANT: Flood</p>	<p><b>T2 D2 L2</b></p> <p>TYPE: drill</p> <p>DIAMETER: 3.5mm</p> <p>TIP ANGLE: 130°</p> <p>LENGTH: 100mm</p> <p>FLUTES: 1</p>	
<p>Operation 10/21</p> <p>DESCRIPTION: Drill5</p> <p>STRATEGY: Drilling</p> <p>WCS: #30</p> <p>PATTERN GROUP: C</p> <p>TOLERANCE: 0.01mm</p>	<p>MAXIMUM SPINDLE SPEED: 1000rpm</p> <p>MAXIMUM FEEDRATE: 100mm/min</p> <p>CUTTING DISTANCE: 119.68mm</p> <p>RAPID DISTANCE: 6428.34mm</p> <p>ESTIMATED CYCLE TIME: 2m:35s (7.2%)</p> <p>COOLANT: Flood</p>	<p><b>T2 D2 L2</b></p> <p>TYPE: drill</p> <p>DIAMETER: 3.5mm</p> <p>TIP ANGLE: 130°</p> <p>LENGTH: 100mm</p> <p>FLUTES: 1</p>	
<p>Operation 11/21</p> <p>DESCRIPTION: 2D Pocket3</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #30</p> <p>PATTERN GROUP: D</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 1mm</p> <p>MAXIMUM STEPOVER: 1.8mm</p>	<p>MAXIMUM SPINDLE SPEED: 10610rpm</p> <p>MAXIMUM FEEDRATE: 1061.033mm/min</p> <p>CUTTING DISTANCE: 471.7mm</p> <p>RAPID DISTANCE: 65.86mm</p> <p>ESTIMATED CYCLE TIME: 44s (2%)</p> <p>COOLANT: Air</p>	<p><b>T1030 D1030 L1030</b></p> <p>TYPE: flat end mill</p> <p>DIAMETER: 3mm</p> <p>LENGTH: 22mm</p> <p>FLUTES: 1</p> <p>DESCRIPTION: HM-KU-1SCHN-D3</p> <p>VENDOR: Schmid Werkzeug Muenchen</p> <p>PRODUCT: <a href="#">016-3</a></p>	
<p>Operation 12/21</p> <p>DESCRIPTION: 2D Pocket3</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #30</p> <p>PATTERN GROUP: D</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 1mm</p> <p>MAXIMUM STEPOVER: 1.8mm</p>	<p>MAXIMUM SPINDLE SPEED: 10610rpm</p> <p>MAXIMUM FEEDRATE: 1061.033mm/min</p> <p>CUTTING DISTANCE: 471.7mm</p> <p>RAPID DISTANCE: 65.86mm</p> <p>ESTIMATED CYCLE TIME: 44s (2%)</p> <p>COOLANT: Air</p>	<p><b>T1030 D1030 L1030</b></p> <p>TYPE: flat end mill</p> <p>DIAMETER: 3mm</p> <p>LENGTH: 22mm</p> <p>FLUTES: 1</p> <p>DESCRIPTION: HM-KU-1SCHN-D3</p> <p>VENDOR: Schmid Werkzeug Muenchen</p> <p>PRODUCT: <a href="#">016-3</a></p>	
<p>Operation 13/21</p> <p>DESCRIPTION: 2D Pocket3</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #30</p> <p>PATTERN GROUP: D</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 1mm</p> <p>MAXIMUM STEPOVER: 1.8mm</p>	<p>MAXIMUM SPINDLE SPEED: 10610rpm</p> <p>MAXIMUM FEEDRATE: 1061.033mm/min</p> <p>CUTTING DISTANCE: 471.7mm</p> <p>RAPID DISTANCE: 65.86mm</p> <p>ESTIMATED CYCLE TIME: 44s (2%)</p> <p>COOLANT: Air</p>	<p><b>T1030 D1030 L1030</b></p> <p>TYPE: flat end mill</p> <p>DIAMETER: 3mm</p> <p>LENGTH: 22mm</p> <p>FLUTES: 1</p> <p>DESCRIPTION: HM-KU-1SCHN-D3</p> <p>VENDOR: Schmid Werkzeug Muenchen</p> <p>PRODUCT: <a href="#">016-3</a></p>	
<p>Operation 14/21</p> <p>DESCRIPTION: 2D Pocket3</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #30</p> <p>PATTERN GROUP: D</p> <p>TOLERANCE: 0.1mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPDOWN: 1mm</p> <p>MAXIMUM STEPOVER: 1.8mm</p>	<p>MAXIMUM SPINDLE SPEED: 10610rpm</p> <p>MAXIMUM FEEDRATE: 1061.033mm/min</p> <p>CUTTING DISTANCE: 471.7mm</p> <p>RAPID DISTANCE: 65.86mm</p> <p>ESTIMATED CYCLE TIME: 44s (2%)</p> <p>COOLANT: Air</p>	<p><b>T1030 D1030 L1030</b></p> <p>TYPE: flat end mill</p> <p>DIAMETER: 3mm</p> <p>LENGTH: 22mm</p> <p>FLUTES: 1</p> <p>DESCRIPTION: HM-KU-1SCHN-D3</p> <p>VENDOR: Schmid Werkzeug Muenchen</p> <p>PRODUCT: <a href="#">016-3</a></p>	

<p>Operation 15/21</p> <p>DESCRIPTION: Blend1</p> <p>STRATEGY: Blend</p> <p>WCS: #30</p> <p>PATTERN GROUP: E</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPOVER: 0.08mm</p>	<p>MAXIMUM SPINDLE SPEED: 8000rpm</p> <p>MAXIMUM FEEDRATE: 1600mm/min</p> <p>CUTTING DISTANCE: 235.87mm</p> <p>RAPID DISTANCE: 29.61mm</p> <p>ESTIMATED CYCLE TIME: 9s (0.4%)</p> <p>COOLANT: Flood</p>	<p><b>T102 D102 L102</b></p> <p>TYPE: ball end mill</p> <p>DIAMETER: 2mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 20mm</p> <p>FLUTES: 4</p>	
<p>Operation 16/21</p> <p>DESCRIPTION: Blend1</p> <p>STRATEGY: Blend</p> <p>WCS: #30</p> <p>PATTERN GROUP: E</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPOVER: 0.08mm</p>	<p>MAXIMUM SPINDLE SPEED: 8000rpm</p> <p>MAXIMUM FEEDRATE: 1600mm/min</p> <p>CUTTING DISTANCE: 235.87mm</p> <p>RAPID DISTANCE: 29.61mm</p> <p>ESTIMATED CYCLE TIME: 9s (0.4%)</p> <p>COOLANT: Flood</p>	<p><b>T102 D102 L102</b></p> <p>TYPE: ball end mill</p> <p>DIAMETER: 2mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 20mm</p> <p>FLUTES: 4</p>	
<p>Operation 17/21</p> <p>DESCRIPTION: Blend1</p> <p>STRATEGY: Blend</p> <p>WCS: #30</p> <p>PATTERN GROUP: E</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPOVER: 0.08mm</p>	<p>MAXIMUM SPINDLE SPEED: 8000rpm</p> <p>MAXIMUM FEEDRATE: 1600mm/min</p> <p>CUTTING DISTANCE: 235.87mm</p> <p>RAPID DISTANCE: 29.61mm</p> <p>ESTIMATED CYCLE TIME: 9s (0.4%)</p> <p>COOLANT: Flood</p>	<p><b>T102 D102 L102</b></p> <p>TYPE: ball end mill</p> <p>DIAMETER: 2mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 20mm</p> <p>FLUTES: 4</p>	
<p>Operation 18/21</p> <p>DESCRIPTION: Blend1</p> <p>STRATEGY: Blend</p> <p>WCS: #30</p> <p>PATTERN GROUP: E</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPOVER: 0.08mm</p>	<p>MAXIMUM SPINDLE SPEED: 8000rpm</p> <p>MAXIMUM FEEDRATE: 1600mm/min</p> <p>CUTTING DISTANCE: 235.87mm</p> <p>RAPID DISTANCE: 29.61mm</p> <p>ESTIMATED CYCLE TIME: 9s (0.4%)</p> <p>COOLANT: Flood</p>	<p><b>T102 D102 L102</b></p> <p>TYPE: ball end mill</p> <p>DIAMETER: 2mm</p> <p>CORNER RADIUS: 1mm</p> <p>LENGTH: 20mm</p> <p>FLUTES: 4</p>	
<p>Operation 19/21</p> <p>DESCRIPTION: 2D Contour6</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #30</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPOVER: 5mm</p>	<p>MAXIMUM SPINDLE SPEED: 2037rpm</p> <p>MAXIMUM FEEDRATE: 782.278mm/min</p> <p>CUTTING DISTANCE: 3513.54mm</p> <p>RAPID DISTANCE: 35.5mm</p> <p>ESTIMATED CYCLE TIME: 4m:30s (12.5%)</p> <p>COOLANT: Air</p>	<p><b>T10 D10 L10</b></p> <p>TYPE: slot mill</p> <p>DIAMETER: 125mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 64</p>	
<p>Operation 20/21</p> <p>DESCRIPTION: 2D Contour6 (2)</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #30</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPOVER: 5mm</p>	<p>MAXIMUM SPINDLE SPEED: 2037rpm</p> <p>MAXIMUM FEEDRATE: 782.278mm/min</p> <p>CUTTING DISTANCE: 3510.54mm</p> <p>RAPID DISTANCE: 32.5mm</p> <p>ESTIMATED CYCLE TIME: 4m:30s (12.5%)</p> <p>COOLANT: Air</p>	<p><b>T10 D10 L10</b></p> <p>TYPE: slot mill</p> <p>DIAMETER: 125mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 64</p>	
<p>Operation 21/21</p> <p>DESCRIPTION: 2D Contour6 (3)</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #30</p> <p>TOLERANCE: 0.01mm</p> <p>STOCK TO LEAVE: 0mm</p> <p>MAXIMUM STEPOVER: 5mm</p>	<p>MAXIMUM SPINDLE SPEED: 2037rpm</p> <p>MAXIMUM FEEDRATE: 782.278mm/min</p> <p>CUTTING DISTANCE: 3507.54mm</p> <p>RAPID DISTANCE: 29.5mm</p> <p>ESTIMATED CYCLE TIME: 4m:30s (12.5%)</p> <p>COOLANT: Air</p>	<p><b>T10 D10 L10</b></p> <p>TYPE: slot mill</p> <p>DIAMETER: 125mm</p> <p>LENGTH: 50mm</p> <p>FLUTES: 64</p>	

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