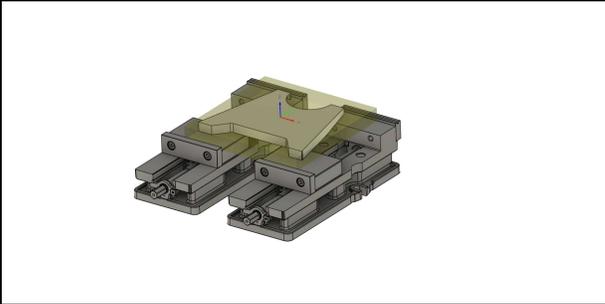


Setup Sheet for Program 00001

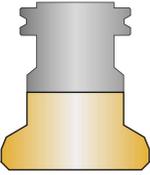
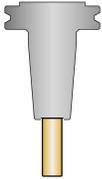
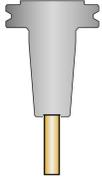
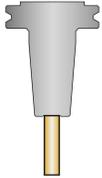
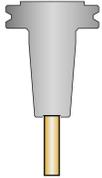
PROGRAM COMMENT: Aerospace panel
 JOB DESCRIPTION: OP10
 DOCUMENT PATH: Aerospace panel machining v15

Setup	
<p>WCS: #1</p> <p>STOCK: DX: 12in DY: 12in DZ: 1.25in</p> <p>PART: DX: 11.055in DY: 9.055in DZ: 0.866in</p> <p>STOCK LOWER IN WCS #1: X: -6in Y: -6in Z: -1.25in</p> <p>STOCK UPPER IN WCS #1: X: 6in Y: 6in Z: 0in</p>	

Total
<p>NUMBER OF OPERATIONS: 6</p> <p>NUMBER OF TOOLS: 4</p> <p>TOOLS: T1 T2 T3 T4</p> <p>MAXIMUM Z: 0.6in</p> <p>MINIMUM Z: -1.375in</p> <p>MAXIMUM FEEDRATE: 240in/min</p> <p>MAXIMUM SPINDLE SPEED: 12000rpm</p> <p>CUTTING DISTANCE: 1067.381in</p> <p>RAPID DISTANCE: 447.5in</p> <p>ESTIMATED CYCLE TIME: 12m:27s</p>

Tools		
<p>T1 D1 L1</p> <p>TYPE: face mill</p> <p>DIAMETER: 3in</p> <p>CORNER RADIUS: 0.005in</p> <p>TAPER ANGLE: 45°</p> <p>LENGTH: 1.75in</p> <p>FLUTES: 6</p> <p>DESCRIPTION: 3" Cut Dia, 1" Arbor Hole, 4.51mm Max Depth of Cut, 45° Indexable Chamfer & Angle Face Mill</p> <p>VENDOR: Kennametal</p> <p>PRODUCT: 60299922</p>	<p>MINIMUM Z: -0.05in</p> <p>MAXIMUM FEED: 72in/min</p> <p>MAXIMUM SPINDLE SPEED: 4000rpm</p> <p>CUTTING DISTANCE: 144.829in</p> <p>RAPID DISTANCE: 127.158in</p> <p>ESTIMATED CYCLE TIME: 2m:2s (16.4%)</p>	<p>HOLDER: Shell Mill Holder: CAT40, Taper Shank, 1" Pilot</p> <p>VENDOR: Kennametal</p> <p>PRODUCT: 30734412</p>
<p>T2 D2 L2</p> <p>TYPE: bullnose end mill</p> <p>DIAMETER: 0.5in</p> <p>CORNER RADIUS: 0.03in</p> <p>LENGTH: 1.5in</p> <p>FLUTES: 4</p> <p>DESCRIPTION: Corner Radius End Mill: 1/2" Dia, 1" LOC, 0.0300" Radius, 4 Flute, Solid Carbide</p> <p>VENDOR: SECO</p> <p>PRODUCT: 82763467</p>	<p>MINIMUM Z: -0.8in</p> <p>MAXIMUM FEED: 240in/min</p> <p>MAXIMUM SPINDLE SPEED: 12000rpm</p> <p>CUTTING DISTANCE: 681.238in</p> <p>RAPID DISTANCE: 311.48in</p> <p>ESTIMATED CYCLE TIME: 2m:54s (23.3%)</p>	<p>HOLDER: Shrink-Fit Tool Holder & Adapter: CAT40 Taper Shar</p> <p>VENDOR: Haimer</p> <p>PRODUCT: 61772216</p>
<p>T3 D3 L3</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 0.375in</p> <p>LENGTH: 1.6in</p> <p>FLUTES: 3</p> <p>DESCRIPTION: Square End Mill: 3/8" Dia, 1-1/4" LOC, 3 Flute, Solid Carbide</p> <p>VENDOR: Accupro</p> <p>PRODUCT: 65250052</p>	<p>MINIMUM Z: -1.375in</p> <p>MAXIMUM FEED: 34.2in/min</p> <p>MAXIMUM SPINDLE SPEED: 5700rpm</p> <p>CUTTING DISTANCE: 200.187in</p> <p>RAPID DISTANCE: 7.802in</p> <p>ESTIMATED CYCLE TIME: 5m:56s (47.6%)</p>	<p>HOLDER: Shrink-Fit Tool Holder & Adapter: CAT40 Taper Shar</p> <p>VENDOR: Haimer</p> <p>PRODUCT: 61772174</p>
<p>T4 D4 L4</p> <p>TYPE: chamfer mill</p> <p>DIAMETER: 0.375in</p> <p>TAPER ANGLE: 45°</p> <p>LENGTH: 1.5in</p> <p>FLUTES: 2</p> <p>DESCRIPTION: Chamfer Mill: 3/8" Dia, 3/8" Shank Dia, 90 deg, 2 Flute, Solid Carbide, Single End</p> <p>VENDOR: Accupro</p> <p>PRODUCT: 09550336</p>	<p>MINIMUM Z: -0.11in</p> <p>MAXIMUM FEED: 72in/min</p> <p>MAXIMUM SPINDLE SPEED: 12000rpm</p> <p>CUTTING DISTANCE: 41.126in</p> <p>RAPID DISTANCE: 1.06in</p> <p>ESTIMATED CYCLE TIME: 35s (4.7%)</p>	<p>HOLDER: Shrink-Fit Tool Holder & Adapter: CAT40 Taper Shar</p> <p>VENDOR: Haimer</p> <p>PRODUCT: 61772174</p>

Operations
Empty area for operations

<p>Operation 1/6 DESCRIPTION: Face bottom STRATEGY: Facing WCS: #1 TOLERANCE: 0in MAXIMUM STEPOVER: 1.4in</p>	<p>MAXIMUM Z: 0.6in MINIMUM Z: -0.05in MAXIMUM SPINDLE SPEED: 4000rpm MAXIMUM FEEDRATE: 72in/min CUTTING DISTANCE: 144.829in RAPID DISTANCE: 127.158in ESTIMATED CYCLE TIME: 2m:2s (16.4%) COOLANT: Flood</p>	<p>T1 D1 L1 TYPE: face mill DIAMETER: 3in CORNER RADIUS: 0.005in TAPER ANGLE: 45° LENGTH: 1.75in FLUTES: 6 DESCRIPTION: 3" Cut Dia, 1" Arbor Hole, 4.51mm Max Depth of Cut, 45° Indexable Chamfer & Angle Face Mill VENDOR: Kennametal PRODUCT: 60299922</p>	
<p>Operation 2/6 DESCRIPTION: Rough contour STRATEGY: Adaptive 2D WCS: #1 TOLERANCE: 0.004in STOCK TO LEAVE: 0.02in/0in OPTIMAL LOAD: 0.125in LOAD DEVIATION: 0.013in</p>	<p>MAXIMUM Z: 0.6in MINIMUM Z: -0.8in MAXIMUM SPINDLE SPEED: 12000rpm MAXIMUM FEEDRATE: 240in/min CUTTING DISTANCE: 681.238in RAPID DISTANCE: 311.48in ESTIMATED CYCLE TIME: 2m:54s (23.3%) COOLANT: Flood</p>	<p>T2 D2 L2 TYPE: bullnose end mill DIAMETER: 0.5in CORNER RADIUS: 0.03in LENGTH: 1.5in FLUTES: 4 DESCRIPTION: Corner Radius End Mill: 1/2" Dia, 1" LOC, 0.0300" Radius, 4 Flute, Solid Carbide VENDOR: SECO PRODUCT: 82763467</p>	
<p>Operation 3/6 DESCRIPTION: Rough slot STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0in STOCK TO LEAVE: 0.02in/0in MAXIMUM STEPDOWN: 0.1in MAXIMUM STEPOVER: 0.356in</p>	<p>MAXIMUM Z: 0.6in MINIMUM Z: -0.966in MAXIMUM SPINDLE SPEED: 5700rpm MAXIMUM FEEDRATE: 34.2in/min CUTTING DISTANCE: 125.466in RAPID DISTANCE: 2.716in ESTIMATED CYCLE TIME: 3m:41s (29.6%) COOLANT: Flood</p>	<p>T3 D3 L3 TYPE: flat end mill DIAMETER: 0.375in LENGTH: 1.6in FLUTES: 3 DESCRIPTION: Square End Mill: 3/8" Dia, 1-1/4" LOC, 3 Flute, Solid Carbide VENDOR: Accupro PRODUCT: 65250052</p>	
<p>Operation 4/6 DESCRIPTION: Finish contour and slot STRATEGY: Contour 2D WCS: #1 TOLERANCE: 0in STOCK TO LEAVE: 0in MAXIMUM STEPOVER: 0.356in</p>	<p>MAXIMUM Z: 0.6in MINIMUM Z: -0.966in MAXIMUM SPINDLE SPEED: 5700rpm MAXIMUM FEEDRATE: 34.2in/min CUTTING DISTANCE: 42.879in RAPID DISTANCE: 1.929in ESTIMATED CYCLE TIME: 1m:18s (10.5%) COOLANT: Flood</p>	<p>T3 D3 L3 TYPE: flat end mill DIAMETER: 0.375in LENGTH: 1.6in FLUTES: 3 DESCRIPTION: Square End Mill: 3/8" Dia, 1-1/4" LOC, 3 Flute, Solid Carbide VENDOR: Accupro PRODUCT: 65250052</p>	
<p>Operation 5/6 DESCRIPTION: Bore hole STRATEGY: Bore WCS: #1 TOLERANCE: 0in STOCK TO LEAVE: 0in</p>	<p>MAXIMUM Z: 0.6in MINIMUM Z: -1.375in MAXIMUM SPINDLE SPEED: 5700rpm MAXIMUM FEEDRATE: 34.2in/min CUTTING DISTANCE: 31.842in RAPID DISTANCE: 3.157in ESTIMATED CYCLE TIME: 56s (7.5%) COOLANT: Flood</p>	<p>T3 D3 L3 TYPE: flat end mill DIAMETER: 0.375in LENGTH: 1.6in FLUTES: 3 DESCRIPTION: Square End Mill: 3/8" Dia, 1-1/4" LOC, 3 Flute, Solid Carbide VENDOR: Accupro PRODUCT: 65250052</p>	
<p>Operation 6/6 DESCRIPTION: Chamfer bottom edges WCS: #1 TOLERANCE: 0in STOCK TO LEAVE: 0in</p>	<p>MAXIMUM Z: 0.6in MINIMUM Z: -0.11in MAXIMUM SPINDLE SPEED: 12000rpm MAXIMUM FEEDRATE: 72in/min CUTTING DISTANCE: 41.126in RAPID DISTANCE: 1.06in ESTIMATED CYCLE TIME: 35s (4.7%) COOLANT: Flood</p>	<p>T4 D4 L4 TYPE: chamfer mill DIAMETER: 0.375in TAPER ANGLE: 45° LENGTH: 1.5in FLUTES: 2 DESCRIPTION: Chamfer Mill: 3/8" Dia, 3/8" Shank Dia, 90 deg, 2 Flute, Solid Carbide, Single End VENDOR: Accupro PRODUCT: 09550336</p>	