

Setup Sheet for Program Z-axis test

JOB DESCRIPTION: Setup1

DOCUMENT PATH: Untitled

Setup

WCS: #0

STOCK:

DX: 2in

DY: 2in

DZ: 0.75in

PART:

DX: 2in

DY: 2in

DZ: 0.75in

STOCK LOWER IN WCS #0:

X: -1in

Y: -1in

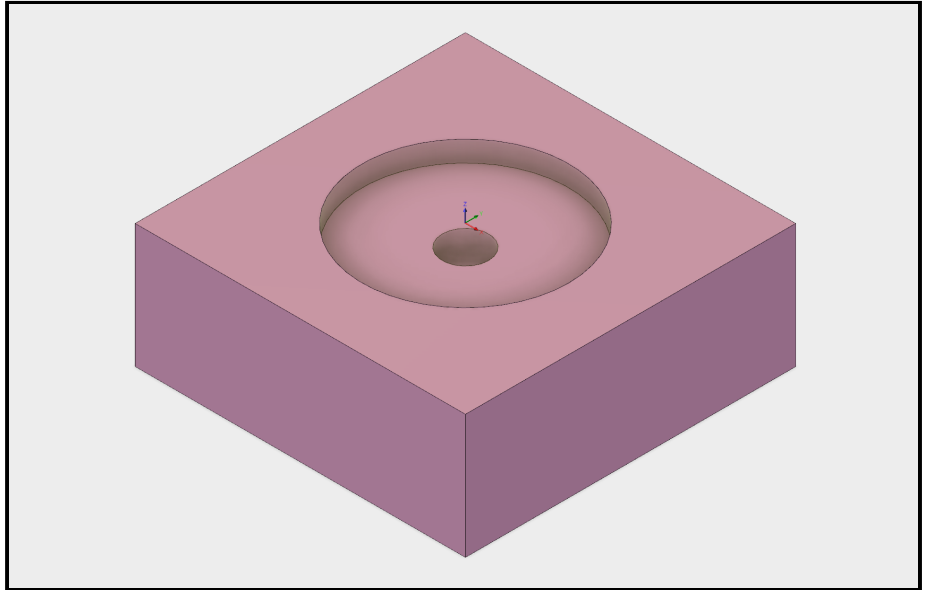
Z: -0.75in

STOCK UPPER IN WCS #0:

X: 1in

Y: 1in

Z: 0in



Total

NUMBER OF OPERATIONS: 2

NUMBER OF TOOLS: 1

TOOLS: T102

MAXIMUM Z: 0.6in

MINIMUM Z: -0.375in

MAXIMUM FEEDRATE: 100in/min

MAXIMUM SPINDLE SPEED: 19700rpm

CUTTING DISTANCE: 39.25in

RAPID DISTANCE: 3.86in

ESTIMATED CYCLE TIME: 43s

Operation 1/2

DESCRIPTION: 2D Pocket1

STRATEGY: Pocket 2D

WCS: #0

TOLERANCE: 0.004in

STOCK TO LEAVE: 0in

MAXIMUM STEPDOWN: 0.1in

MAXIMUM STEPOVER: 0.119in

MAXIMUM Z: 0.6in

MINIMUM Z: -0.125in

MAXIMUM SPINDLE SPEED: 19700rpm

MAXIMUM FEEDRATE: 100in/min

CUTTING DISTANCE: 35.432in

RAPID DISTANCE: 1.112in

ESTIMATED CYCLE TIME: 25s (59%)

COOLANT: Off

T102 D102 L102

TYPE: flat end mill

DIAMETER: 0.125in

LENGTH: 1.45in

FLUTES: 2

DESCRIPTION: #102 .125" Flat Ply

Operation 2/2

DESCRIPTION: Bore1

STRATEGY: Bore

WCS: #0

TOLERANCE: 0in

STOCK TO LEAVE: 0in

MAXIMUM Z: 0.6in

MINIMUM Z: -0.375in

MAXIMUM SPINDLE SPEED: 19700rpm

MAXIMUM FEEDRATE: 100in/min

CUTTING DISTANCE: 3.818in

RAPID DISTANCE: 2.748in

ESTIMATED CYCLE TIME: 3s (5.9%)

COOLANT: Off

T102 D102 L102

TYPE: flat end mill

DIAMETER: 0.125in

LENGTH: 1.45in

FLUTES: 2

DESCRIPTION: #102 .125" Flat Ply