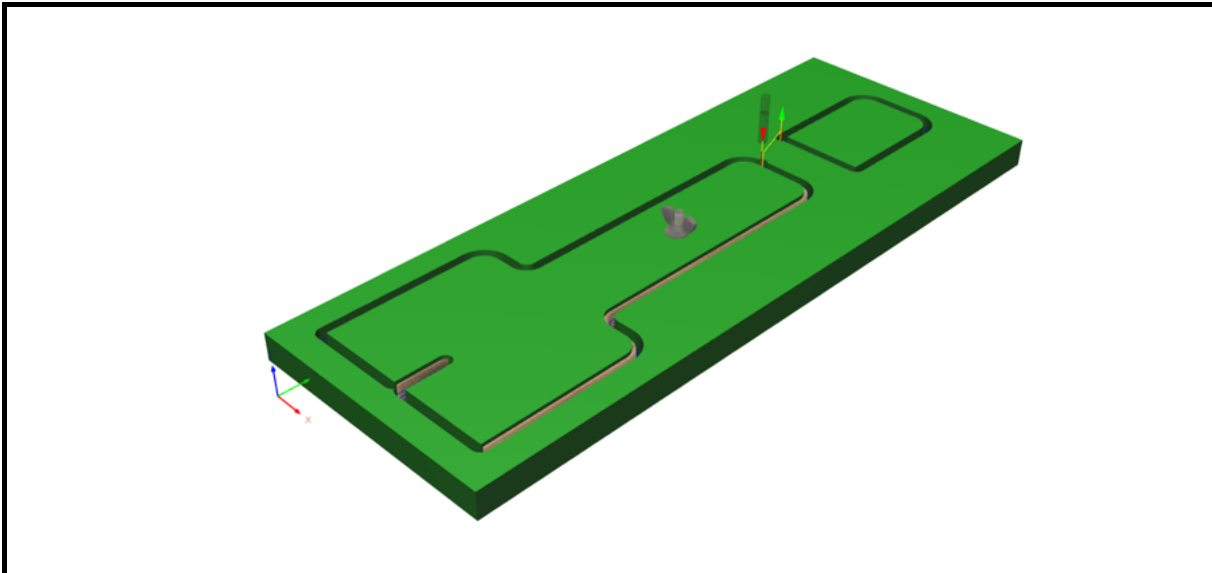



Setup Sheet for Program Dowel Jig

JOB DESCRIPTION: Setup2

DOCUMENT PATH: Dowel Jig v7

Setup	
<p>WCS: #0</p> <p>STOCK:</p> <p>DX: 7.375in</p> <p>DY: 14.75in</p> <p>DZ: 2.44in</p> <p>PART:</p> <p>DX: 5.375in</p> <p>DY: 12.75in</p> <p>DZ: 2.4in</p> <p>STOCK LOWER IN WCS #0:</p> <p>X: 0in</p> <p>Y: 0in</p> <p>Z: 0in</p> <p>STOCK UPPER IN WCS #0:</p> <p>X: 7.375in</p> <p>Y: 14.75in</p> <p>Z: 2.44in</p>	

Total
<p>NUMBER OF OPERATIONS: 1</p> <p>NUMBER OF TOOLS: 1</p> <p>TOOLS: T1</p> <p>MAXIMUM Z: 2.39in</p> <p>MINIMUM Z: 1in</p> <p>MAXIMUM FEEDRATE: 40in/min</p> <p>MAXIMUM SPINDLE SPEED: 18000rpm</p> <p>CUTTING DISTANCE: 220.156in</p> <p>RAPID DISTANCE: 0in</p> <p>ESTIMATED CYCLE TIME: 5m:56s</p>

Tools	
<p>T1 D1 L1</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 0.25in</p> <p>LENGTH: 1.376in</p> <p>FLUTES: 2</p> <p>DESCRIPTION: 46170-K CNC Solid Carbide Spektra™ Extreme Tool Life Coated Compression Spiral 1/4 Dia x 7/8 x 1/4 Inch Shank</p> <p>VENDOR: Amana Tool</p> <p>PRODUCT: 46170-K</p>	<p>MINIMUM Z: 1in</p> <p>MAXIMUM FEED: 40in/min</p> <p>MAXIMUM SPINDLE SPEED: 18000rpm</p> <p>CUTTING DISTANCE: 220.156in</p> <p>RAPID DISTANCE: 0in</p> <p>ESTIMATED CYCLE TIME: 5m:41s</p> 

Operations		
<p>Operation 1/1</p> <p>DESCRIPTION: 2D Contour4</p> <p>STRATEGY: Contour 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0in</p> <p>STOCK TO LEAVE: 0in</p> <p>MAXIMUM STEPDOWN: 0.25in</p> <p>MAXIMUM STEPOVER: 0.238in</p>	<p>MAXIMUM Z: 2.39in</p> <p>MINIMUM Z: 1in</p> <p>MAXIMUM SPINDLE SPEED: 18000rpm</p> <p>MAXIMUM FEEDRATE: 40in/min</p> <p>CUTTING DISTANCE: 220.156in</p> <p>RAPID DISTANCE: 0in</p> <p>ESTIMATED CYCLE TIME: 5m:41s</p> <p>COOLANT: Off</p>	<p>T1 D1 L1</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 0.25in</p> <p>LENGTH: 1.376in</p> <p>FLUTES: 2</p> <p>DESCRIPTION: 46170-K CNC Solid Carbide Spektra™ Extreme Tool Life Coated Compression Spiral 1/4 Dia x 7/8 x 1/4 Inch Shank</p> <p>VENDOR: Amana Tool</p> <p>PRODUCT: 46170-K</p> 