

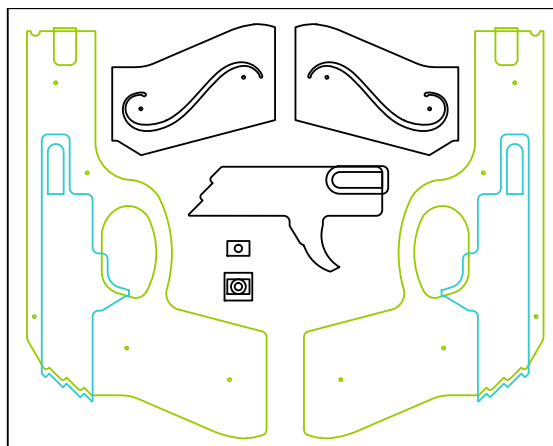
Job Setup Sheet

STEP-UP-ACTION 3D

Vectric
PASSIONATE ABOUT CNC

Job Layout

Material Border

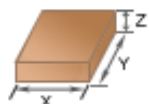


Material Setup

Material Block:

(X):300mm (Y):240mm

(Z):8mm



Datum Position:

Z-Zero:Bottom of Material



XY: Center

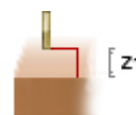


Home / Start Position:

X:0mm Y:0mm Z:11.185mm



Clearance Z1: 3.175mm



Toolpaths Summary

Toolpaths : 6

Pocket Thru 16thEM

Pocket Half 16thEM

Chamfer V90

Quick Engrave V90

Pocket Half 8thEM

Profile Cut 8thEM

Tool Name:

[1] End Mill (1.588 mm 2f)

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[1113] V-Bit (90.0° - 6.35 mm)

[1113] V-Bit (90.0° - 6.35 mm)

[1102] End Mill (3.175 mm 2f)

[1102] End Mill (3.175 mm 2f)

Time Estimate : 00:50:32

00:02:01

00:00:25

00:01:34

00:00:28

00:25:48

00:20:16

Toolpath: Pocket Thru 16thEM



Toolpath Info

Time Estimate: 00:02:01

Toolpath Type: Pocket Toolpath

Feed Rate: 360 mm/min

Plunge Rate: 78 mm/min

Spindle Speed: 20000

Tool Info

Tool Name: End Mill (1.588 mm 2f Hardwood)

Tool Type: End Mill

Tool Number: 1

Max Cut Depth: 8mm

Pass Depth: 0.5877mm

Stepover: 0.6352mm

Tool Notes:

Roughing Cuts Carbide 3D: 112 1/16"

Toolpath: Pocket Half 16thEM



Toolpath Info

Time Estimate: 00:00:25

Toolpath Type: Pocket Toolpath

Feed Rate: 360 mm/min

Plunge Rate: 78 mm/min

Spindle Speed: 20000

Tool Info

Tool Name: End Mill (1.588 mm 2f Hardwood)

Tool Type: End Mill

Tool Number: 1

Max Cut Depth: 4mm

Pass Depth: 0.5877mm

Stepover: 0.6352mm

Tool Notes:

Roughing Cuts Carbide 3D: 112 1/16"

Toolpath: Chamfer V90



Toolpath Info

Time Estimate: 00:01:34

Toolpath Type: Chamfer Toolpath

Feed Rate: 1200 mm/min

Plunge Rate: 270 mm/min

Spindle Speed: 18000

Tool Info

Tool Name: V-Bit (90.0° - 6.35 mm)

Tool Type: V-Bit

Tool Number: 1113

Max Cut Depth: 2mm

Pass Depth: 1.058mm

Stepover: 0.445mm

Tool Notes:

Roughing AND Finishing Pass Trend: Diameter at 1/2 depth = 3.175mm

Toolpath: Quick Engrave V90



Toolpath Info

Time Estimate: 00:00:28

Toolpath Type: Quick Engrave

Feed Rate: 1200 mm/min

Plunge Rate: 270 mm/min

Spindle Speed: 18000

Tool Info

Tool Name: V-Bit (90.0° - 6.35 mm)

Tool Type: V-Bit

Tool Number: 1113

Max Cut Depth: 1mm

Pass Depth: 1.058mm

Stepover: 0.445mm

Tool Notes:

Roughing AND Finishing Pass Trend: Diameter at 1/2 depth = 3.175mm

Toolpath: Pocket Half 8thEM



Toolpath Info

Time Estimate: 00:25:48

Toolpath Type: Pocket Toolpath

Feed Rate: 1400 mm/min

Plunge Rate: 200 mm/min

Spindle Speed: 20000

Tool Info

Tool Name: End Mill (3.175 mm 2f Hardwood)

Tool Type: End Mill

Tool Number: 1102

Max Cut Depth: 4.1mm

Pass Depth: 0.794mm

Stepover: 1.746mm

Tool Notes:

Roughing Cuts Rennie Tools: Solid Carbide 2 Flute Straight Router Bits Solid Carbide 2 Flute Down Cut Spiral Router Bits

Toolpath: Profile Cut 8thEM



Toolpath Info

Time Estimate: 00:20:16

Toolpath Type: 2D Profile Toolpath

Feed Rate: 1400 mm/min

Plunge Rate: 200 mm/min

Spindle Speed: 20000

Tool Info

Tool Name: End Mill (3.175 mm 2f Hardwood)

Tool Type: End Mill

Tool Number: 1102

Max Cut Depth: 8mm

Pass Depth: 0.794mm

Stepover: 1.746mm

Tool Notes:

Finishing Cuts Rennie Tools: Solid Carbide 2 Flute Straight Router Bits Solid Carbide 2 Flute Down Cut Spiral Router Bits