



Setup Sheet Report

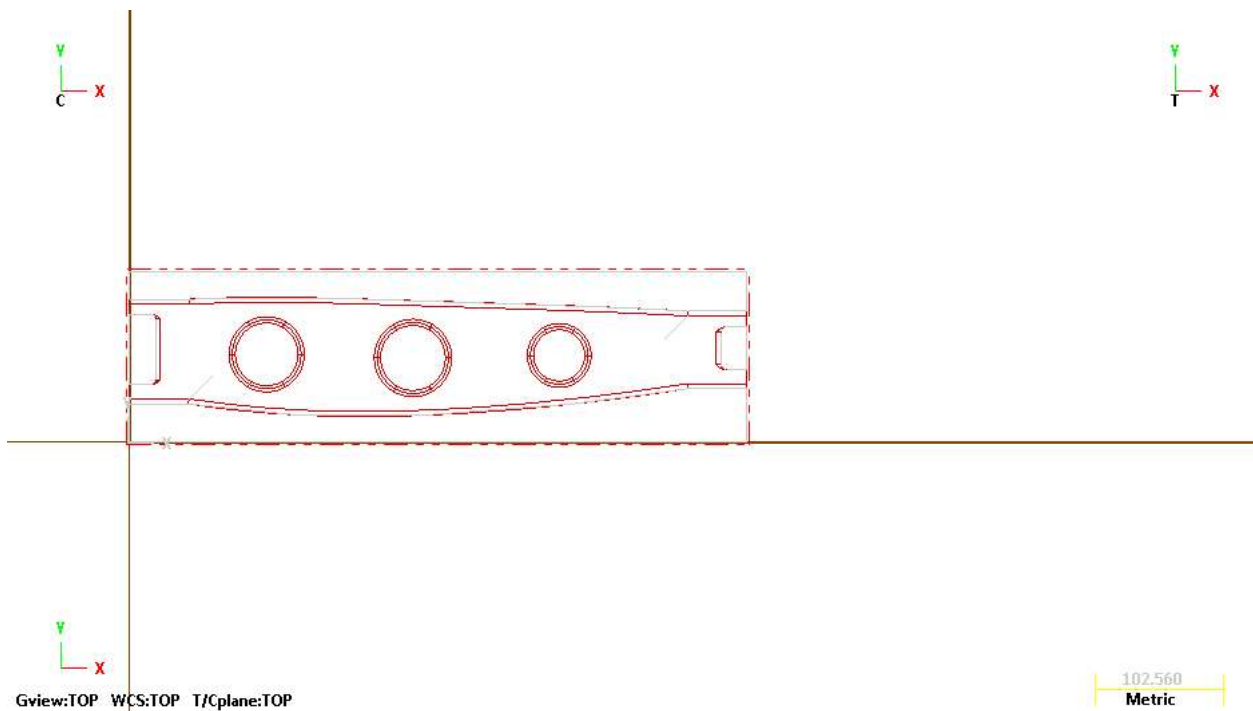
Haas VF - TR Series 5 Axis Trunnion Mill MM

GENERAL INFORMATION

PROJECT NAME: Contra Molde Nervura W1
CUSTOMER NAME: —
PROGRAMMER: Eladio Fabio Rafael
DRAWING: Eladio Fabio Rafael
DATE: quinta-feira, 23 de Abril de 2015
TIME: 09:22

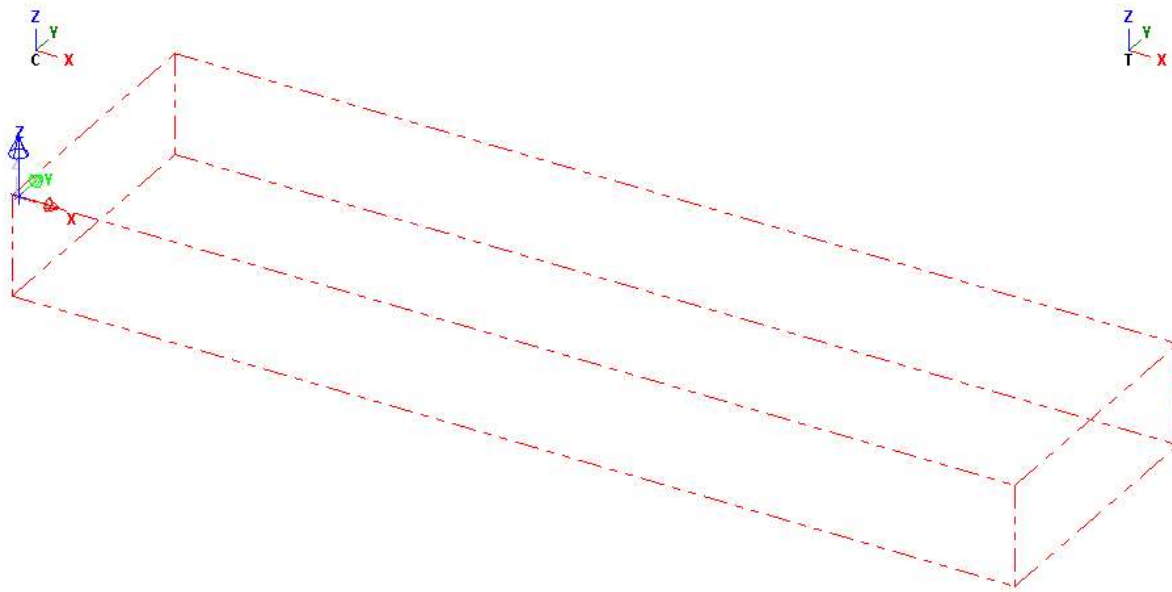
REVISION: Grupo 8/ Formador
João Raimundo

C:\USERS\USER\DESKTOP\NERVURA W1_1\CESSNA W1 FINAL.EMCX-5



COMMENTS

STOCK / SAFEZONE INFO



STOCK:	YES
SHAPE:	Box
SIZE:	497.6475, 140.03959, 50.0
RADIUS:	NA
LENGTH:	NA
AXIS:	NA
FILE:	NA
IDN:	NA

SAFEZONE:	NO
SHAPE:	NA
SIZE:	NA
RADIUS:	NA
LENGTH:	NA
AXIS:	NA

C:\USERS\USER\DOCUMENTS\MY MCAMX5\MILL\NC\CESSNA W

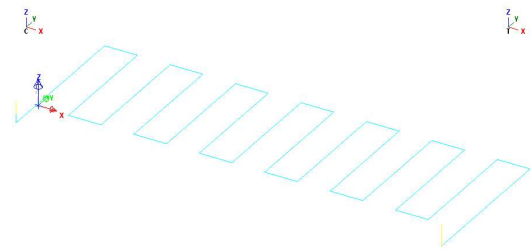
CYCLE TIME: 3 HOURS, 13 MINUTES, 7 SECONDS

OPERATION LIST

OPERATION INFO Facing

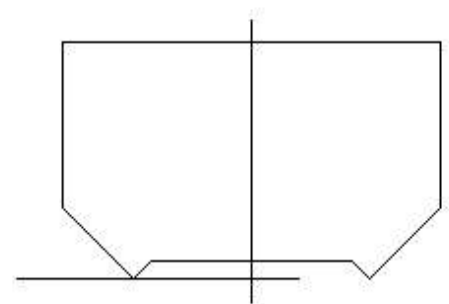
CYCLE TIME: 0 HOURS, 13 MINUTES, 24 SECONDS
COMMENT: -

PROGRAM NUMBER: 0
SPINDLE SPEED: 477 RPM
FEEDRATE: 190.8 mm/min
CLEARANCE PLANE: 50.0
RETRACT PLANE: 25.0
FEED PLANE: 10.0
DEPTH: 0.0
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET: 0



TOOL INFO #1 - M80.00 FACE MILL -

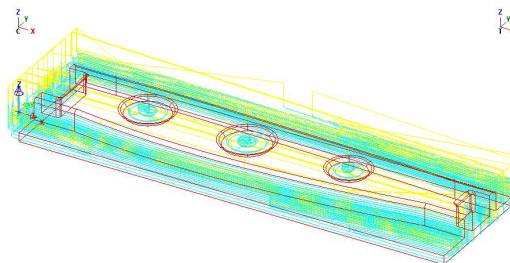
TYPE: Face mill
NUMBER: 1
DIAMETER: 80.0
CORNER RADIUS: 0.0
LENGTH OFFSET: 1
DIAMETER OFFSET: 1
MATERIAL: -
NUMBER OF FLUTES: 4
FPT: 0.1
SFM: 119.887
MFG CODE: -
HOLDER:
TIME: 00:13:24



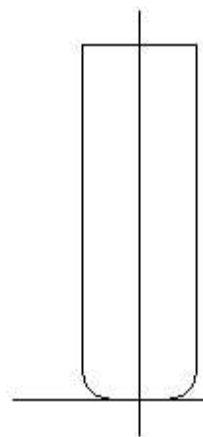
OPERATION INFO**Surface High Speed (Core roughing)**

CYCLE TIME:	0 HOURS, 29 MINUTES, 22 SECONDS
COMMENT:	—

PROGRAM NUMBER:	0
SPINDLE SPEED:	4774 RPM
FEEDRATE:	1909.6 mm/min
CLEARANCE PLANE:	30.0
RETRACT PLANE:	25.0
FEED PLANE:	5.0
DEPTH:	NA
STOCK TO LEAVE:	0.0
COMP TO TIP:	YES
WORK OFFSET:	0

**TOOL INFO****#4 - M16.00 ENDMILL3 BULL -**

TYPE:	Endmill3 Bull
NUMBER:	4
DIAMETER:	16.0
CORNER RADIUS:	4.0
LENGTH OFFSET:	4
DIAMETER OFFSET:	4
MATERIAL:	—
NUMBER OF FLUTES:	4
FPT:	0.1
SFM:	239.975
MFG CODE:	—
HOLDER:	—
TIME:	00:29:22

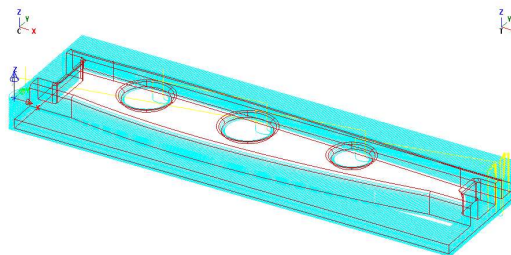


OPERATION INFO

Surface High Speed (Waterline)

CYCLE TIME: 0 HOURS, 49 MINUTES, 42 SECONDS
COMMENT: -

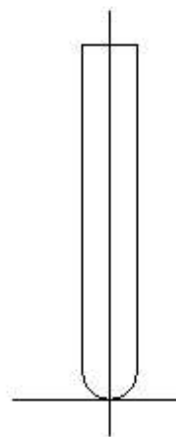
PROGRAM NUMBER: 0
SPINDLE SPEED: 4774 RPM
FEEDRATE: 1909.6 mm/min
CLEARANCE PLANE: 30.0
RETRACT PLANE: 25.0
FEED PLANE: 5.0
DEPTH: NA
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET: 0



TOOL INFO

#2 - M8.00 ENDMILL2 SPHERE -

TYPE: Endmill2 Sphere
NUMBER: 2
DIAMETER: 8.0
CORNER RADIUS: 4.0
LENGTH OFFSET: 2
DIAMETER OFFSET: 2
MATERIAL: -
NUMBER OF FLUTES: 4
FPT: 0.1
SFM: 119.987
MFG CODE: -
HOLDER:
TIME: 00:49:42

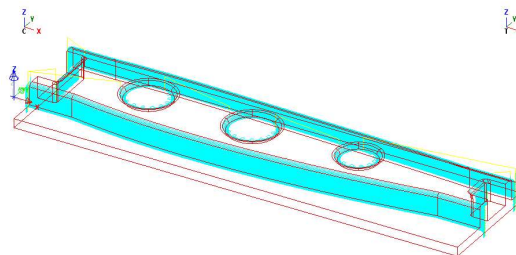


OPERATION INFO

Surface Finish Contour

CYCLE TIME: 0 HOURS, 32 MINUTES, 30 SECONDS
COMMENT: -

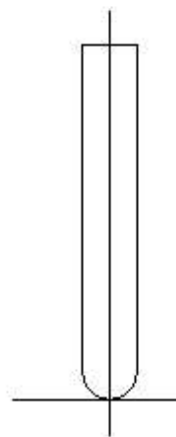
PROGRAM NUMBER: 0
SPINDLE SPEED: 4774 RPM
FEEDRATE: 1909.6 mm/min
CLEARANCE PLANE: 50.0
RETRACT PLANE: 10.0
FEED PLANE: 5.0
DEPTH: NA
STOCK TO LEAVE: 0.0
COMP TO TIP: NO
WORK OFFSET: 0



TOOL INFO

#2 - M8.00 ENDMILL2 SPHERE -

TYPE: Endmill2 Sphere
NUMBER: 2
DIAMETER: 8.0
CORNER RADIUS: 4.0
LENGTH OFFSET: 2
DIAMETER OFFSET: 2
MATERIAL: -
NUMBER OF FLUTES: 4
FPT: 0.1
SFM: 119.987
MFG CODE: -
HOLDER:
TIME: 00:32:30

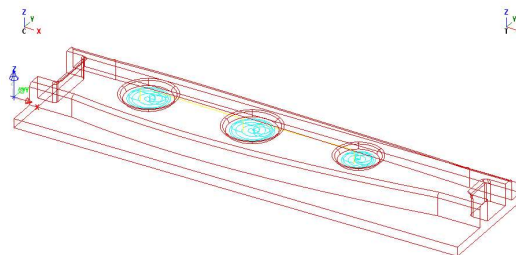


OPERATION INFO

Pocket (Standard)

CYCLE TIME: 0 HOURS, 0 MINUTES, 56 SECONDS
COMMENT: -

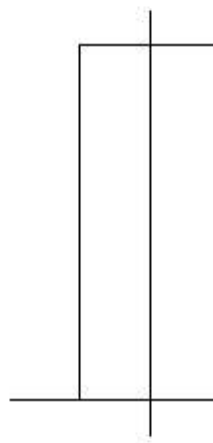
PROGRAM NUMBER: 0
SPINDLE SPEED: 4774 RPM
FEEDRATE: 1909.6 mm/min
CLEARANCE PLANE: 50.0
RETRACT PLANE: 10.0
FEED PLANE: 5.0
DEPTH: -5.0
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET: 0



TOOL INFO

#3 - M8.00 ENDMILL1 FLAT -

TYPE: Endmill1 Flat
NUMBER: 3
DIAMETER: 8.0
CORNER RADIUS: 0.0
LENGTH OFFSET: 3
DIAMETER OFFSET: 3
MATERIAL: -
NUMBER OF FLUTES: 4
FPT: 0.1
SFM: 119.987
MFG CODE: -
HOLDER:
TIME: 00:00:56

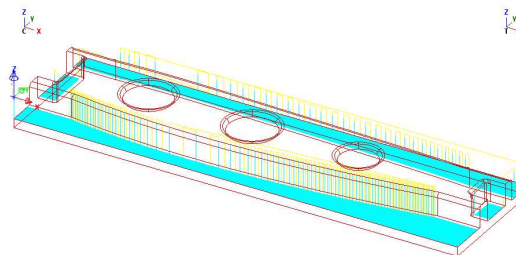


OPERATION INFO

Surface Finish Parallel

CYCLE TIME: 1 HOURS, 5 MINUTES, 47 SECONDS
COMMENT: -

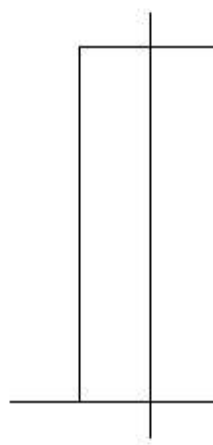
PROGRAM NUMBER: 0
SPINDLE SPEED: 4774 RPM
FEEDRATE: 1909.6 mm/min
CLEARANCE PLANE: 50.0
RETRACT PLANE: 10.0
FEED PLANE: 5.0
DEPTH: NA
STOCK TO LEAVE: 0.0
COMP TO TIP: NO
WORK OFFSET: 0



TOOL INFO

#3 - M8.00 ENDMILL1 FLAT -

TYPE: Endmill1 Flat
NUMBER: 3
DIAMETER: 8.0
CORNER RADIUS: 0.0
LENGTH OFFSET: 3
DIAMETER OFFSET: 3
MATERIAL: -
NUMBER OF FLUTES: 4
FPT: 0.1
SFM: 119.987
MFG CODE: -
HOLDER:
TIME: 01:05:47

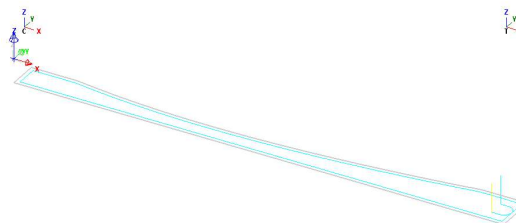


OPERATION INFO

Contour (2D)

CYCLE TIME:	0 HOURS, 0 MINUTES, 35 SECONDS
COMMENT:	—

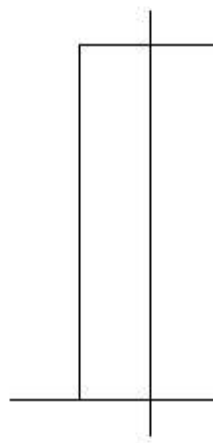
PROGRAM NUMBER:	0
SPINDLE SPEED:	4774 RPM
FEEDRATE:	1909.6 mm/min
CLEARANCE PLANE:	50.0
RETRACT PLANE:	25.0
FEED PLANE:	5.0
DEPTH:	-24.0
STOCK TO LEAVE:	0.0
COMP TO TIP:	YES
WORK OFFSET:	0



TOOL INFO

#3 - M8.00 ENDMILL1 FLAT -

TYPE:	Endmill1 Flat
NUMBER:	3
DIAMETER:	8.0
CORNER RADIUS:	0.0
LENGTH OFFSET:	3
DIAMETER OFFSET:	3
MATERIAL:	—
NUMBER OF FLUTES:	4
FPT:	0.1
SFM:	119.987
MFG CODE:	—
HOLDER:	—
TIME:	00:00:35

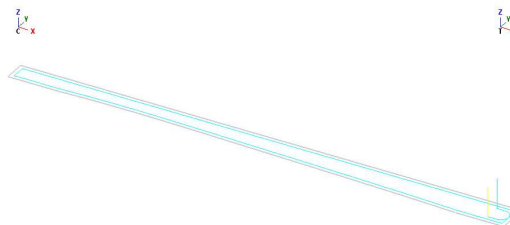


OPERATION INFO

Contour (2D)

CYCLE TIME:	0 HOURS, 0 MINUTES, 34 SECONDS
COMMENT:	—

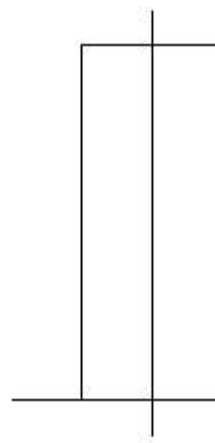
PROGRAM NUMBER:	0
SPINDLE SPEED:	4774 RPM
FEEDRATE:	1909.6 mm/min
CLEARANCE PLANE:	50.0
RETRACT PLANE:	25.0
FEED PLANE:	5.0
DEPTH:	-24.0
STOCK TO LEAVE:	0.0
COMP TO TIP:	YES
WORK OFFSET:	0



TOOL INFO

#3 - M8.00 ENDMILL1 FLAT -

TYPE:	Endmill1 Flat
NUMBER:	3
DIAMETER:	8.0
CORNER RADIUS:	0.0
LENGTH OFFSET:	3
DIAMETER OFFSET:	3
MATERIAL:	—
NUMBER OF FLUTES:	4
FPT:	0.1
SFM:	119.987
MFG CODE:	—
HOLDER:	
TIME:	00:00:34

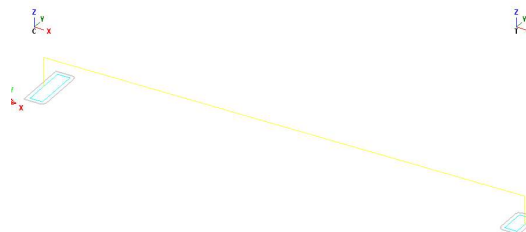


OPERATION INFO

Contour (2D)

CYCLE TIME:	0 HOURS, 0 MINUTES, 11 SECONDS
COMMENT:	—

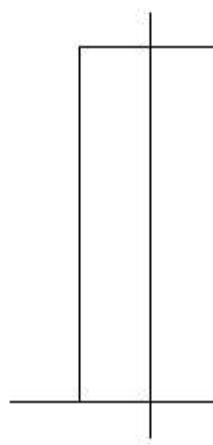
PROGRAM NUMBER:	0
SPINDLE SPEED:	4774 RPM
FEEDRATE:	1909.6 mm/min
CLEARANCE PLANE:	50.0
RETRACT PLANE:	25.0
FEED PLANE:	5.0
DEPTH:	-24.0
STOCK TO LEAVE:	0.0
COMP TO TIP:	YES
WORK OFFSET:	0



TOOL INFO

#3 - M8.00 ENDMILL1 FLAT -

TYPE:	Endmill1 Flat
NUMBER:	3
DIAMETER:	8.0
CORNER RADIUS:	0.0
LENGTH OFFSET:	3
DIAMETER OFFSET:	3
MATERIAL:	—
NUMBER OF FLUTES:	4
FPT:	0.1
SFM:	119.987
MFG CODE:	—
HOLDER:	—
TIME:	00:00:11

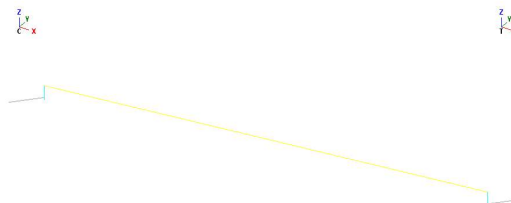


OPERATION INFO

Drill/Counterbore

CYCLE TIME: 0 HOURS, 0 MINUTES, 1 SECONDS
COMMENT: -

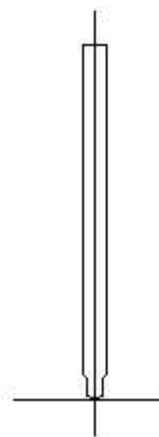
PROGRAM NUMBER: 0
SPINDLE SPEED: 7276 RPM
FEEDRATE: 1455.2 mm/min
CLEARANCE PLANE: 50.0
RETRACT PLANE: 25.0
FEED PLANE: 10.0
DEPTH: -2.0
STOCK TO LEAVE: 0.0
COMP TO TIP: NO
WORK OFFSET: 0



TOOL INFO

#5 - M3.15 CENTER DRILL -

TYPE: Center Drill
NUMBER: 5
DIAMETER: 3.15
CORNER RADIUS: 0.0
LENGTH OFFSET: 5
DIAMETER OFFSET: 5
MATERIAL: -
NUMBER OF FLUTES: 2
FPT: 0.1
SFM: 72.006
MFG CODE: -
HOLDER:
TIME: 00:00:01

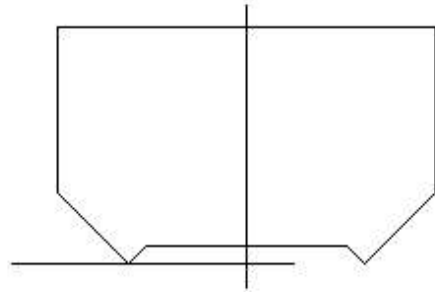


TOOL LIST

Sorted: NO

TOOL INFO**#1 - M80.00 FACE MILL -**

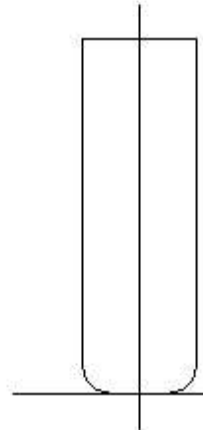
TYPE:	Face mill
NUMBER:	1
DIAMETER:	80.0
CORNER RADIUS:	0.0
LENGTH OFFSET:	1
DIAMETER OFFSET:	1
MATERIAL:	—
NUMBER OF FLUTES:	4
FPT:	0.1
SFM:	119.887
MFG CODE:	—
HOLDER:	
TIME:	00:13:24



USED BY OPERATION: # 1 Facing

TOOL INFO**#4 - M16.00 ENDMILL3 BULL -**

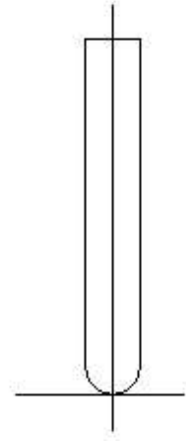
TYPE:	Endmill3 Bull
NUMBER:	4
DIAMETER:	16.0
CORNER RADIUS:	4.0
LENGTH OFFSET:	4
DIAMETER OFFSET:	4
MATERIAL:	—
NUMBER OF FLUTES:	4
FPT:	0.1
SFM:	239.975
MFG CODE:	—
HOLDER:	
TIME:	00:29:22



USED BY OPERATION: # 2 Surface High Speed (Core roughing)

TOOL INFO**#2 - M8.00 ENDMILL2 SPHERE -**

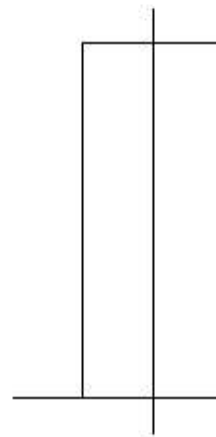
TYPE:	Endmill2 Sphere
NUMBER:	2
DIAMETER:	8.0
CORNER RADIUS:	4.0
LENGTH OFFSET:	2
DIAMETER OFFSET:	2
MATERIAL:	—
NUMBER OF FLUTES:	4
FPT:	0.1
SFM:	119.987
MFG CODE:	—
HOLDER:	
TIME:	01:22:13



USED BY OPERATION:	# 3	Surface High Speed (Waterline)
USED BY OPERATION:	# 4	Surface Finish Contour

TOOL INFO**#3 - M8.00 ENDMILL1 FLAT -**

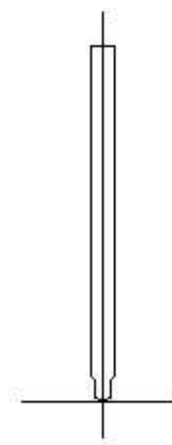
TYPE:	Endmill1 Flat
NUMBER:	3
DIAMETER:	8.0
CORNER RADIUS:	0.0
LENGTH OFFSET:	3
DIAMETER OFFSET:	3
MATERIAL:	—
NUMBER OF FLUTES:	4
FPT:	0.1
SFM:	119.987
MFG CODE:	—
HOLDER:	
TIME:	01:08:05



USED BY OPERATION:	# 5	Pocket (Standard)
USED BY OPERATION:	# 6	Surface Finish Parallel
USED BY OPERATION:	# 7	Contour (2D)
USED BY OPERATION:	# 8	Contour (2D)
USED BY OPERATION:	# 9	Contour (2D)

TOOL INFO**#5 - M3.15 CENTER DRILL -**

TYPE:	Center Drill
NUMBER:	5
DIAMETER:	3.15
CORNER RADIUS:	0.0
LENGTH OFFSET:	5
DIAMETER OFFSET:	5
MATERIAL:	—
NUMBER OF FLUTES:	2
FPT:	0.1
SFM:	72.006
MFG CODE:	—
HOLDER:	
TIME:	00:00:01



USED BY OPERATION:	# 10	Drill/Counterbore
--------------------	------	-------------------

WORK OFFSETS**OFFSET INFO**

NUMBER:	0	VNUM:	1	ORIGIN:	0.0, 0.0, 0.0
---------	---	-------	---	---------	---------------

USED BY OPERATION:	#	All operations
--------------------	---	----------------