

João Vitor



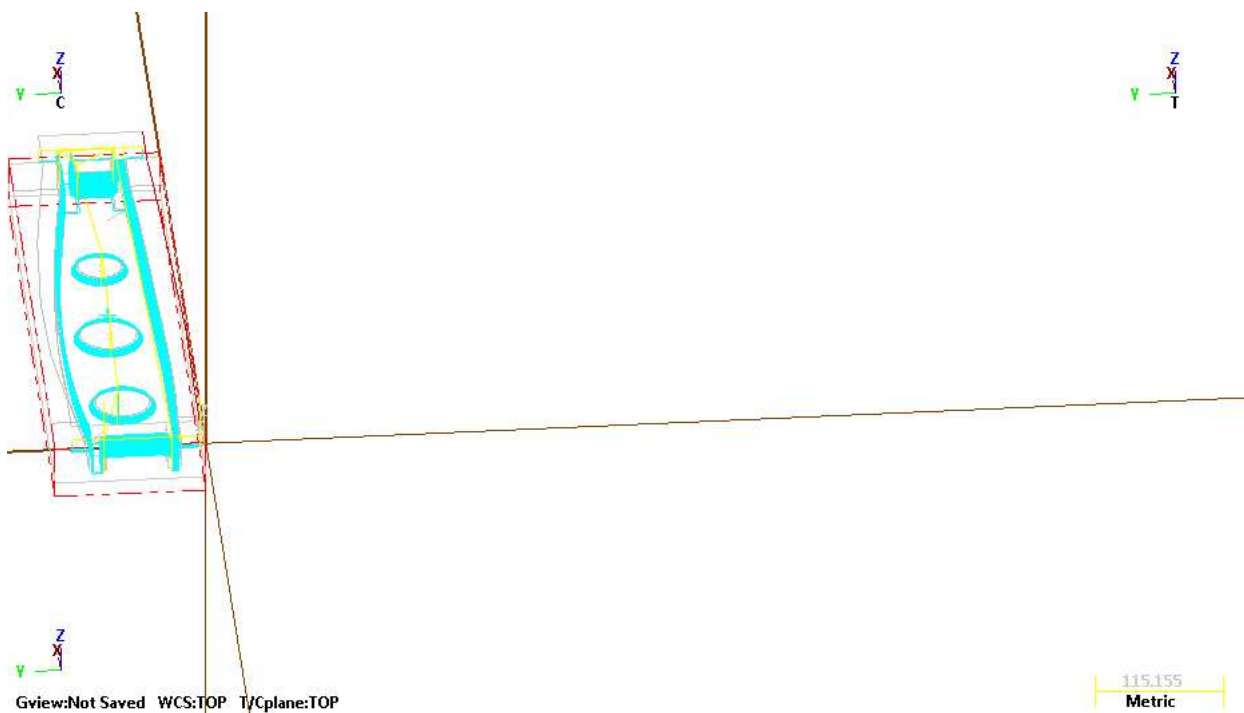
Setup Sheet Report

Haas VF - TR Series 5 Axis Trunnion Mill MM

GENERAL INFORMATION

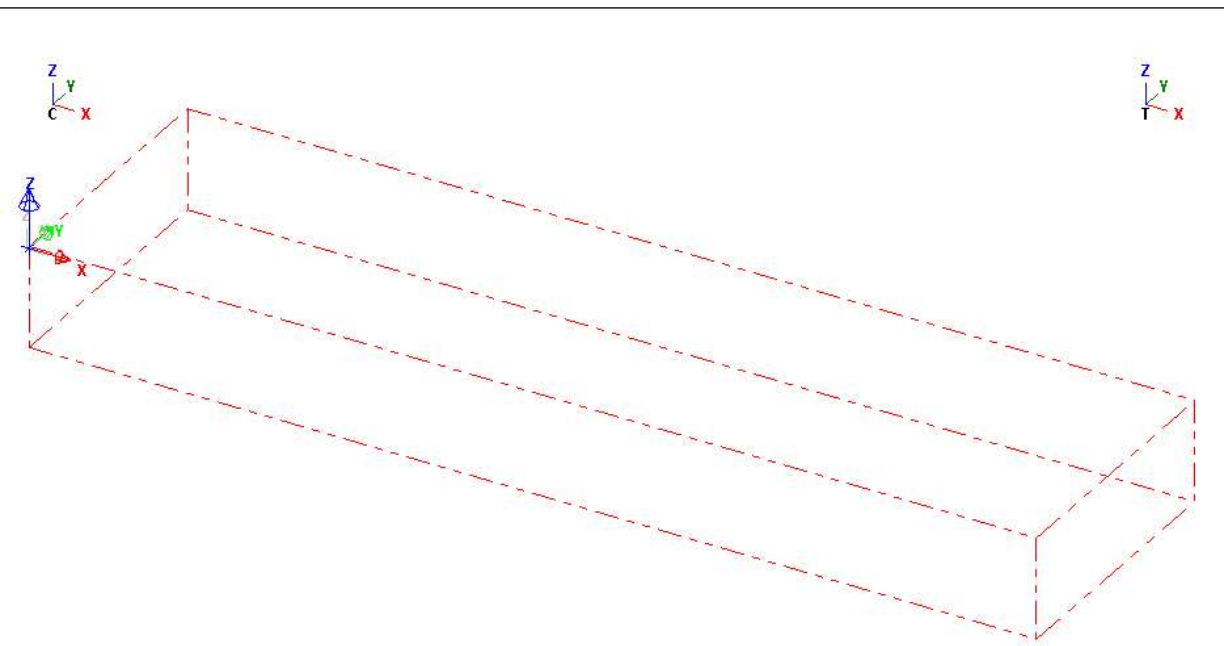
PROJECT NAME:	Molde Nervura W1	
CUSTOMER NAME:	—	
PROGRAMMER:	Eladio Fabio Rafael	
DRAWING:	Eladio Fabio Rafael	REVISION: Grupo 8/ Formador
DATE:	quinta-feira, 23 de Abril de 2015	João Raimundo
TIME:	09:18	

C:\USERS\USER\DESKTOP\NERVURA W1_1\TESTE MOLDE W1.EMCX-5



COMMENTS

STOCK / SAFEZONE INFO



STOCK:	YES	SAFEZONE:	NO
SHAPE:	Box	SHAPE:	NA
SIZE:	499.6475, 136.03959, 50.0	SIZE:	NA
RADIUS:	NA	RADIUS:	NA
LENGTH:	NA	LENGTH:	NA
AXIS:	NA	AXIS:	NA
FILE:	NA		
IDN:	NA		

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

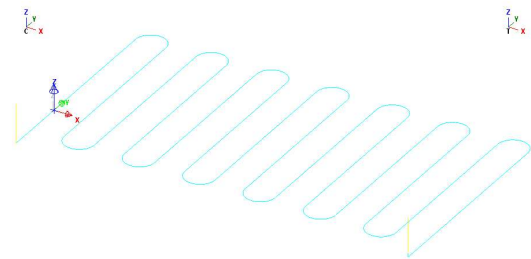
CYCLE TIME: 7 HOURS, 8 MINUTES, 32 SECONDS

OPERATION LIST

OPERATION INFO Facing

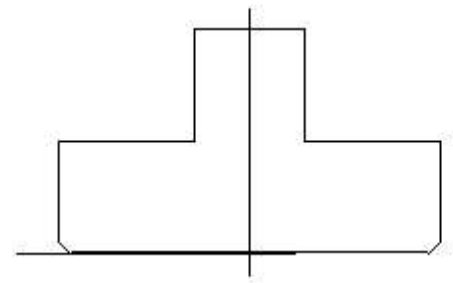
CYCLE TIME: 0 HOURS, 19 MINUTES, 42 SECONDS
COMMENT: -

PROGRAM NUMBER: 0
SPINDLE SPEED: 1000 RPM
FEEDRATE: 203.6 mm/min
CLEARANCE PLANE: 50.0
RETRACT PLANE: 10.0
FEED PLANE: 5.0
DEPTH: 0.0
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET: 0



TOOL INFO #1 - M80.00 FACE MILL - ROCA D80

TYPE: Face mill
NUMBER: 1
DIAMETER: 80.0
CORNER RADIUS: 0.0
LENGTH OFFSET: 1
DIAMETER OFFSET: 1
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.051
SFM: 251.335
MFG CODE: -
HOLDER:
TIME: 00:19:42

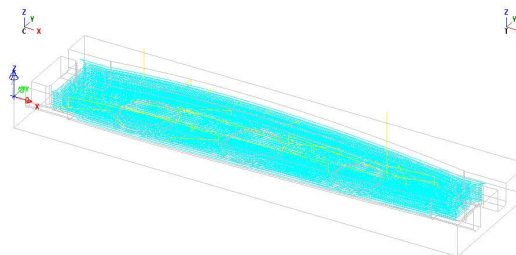


OPERATION INFO

Surface High Speed (Area clearance)

CYCLE TIME: 2 HOURS, 55 MINUTES, 30 SECONDS
COMMENT: -

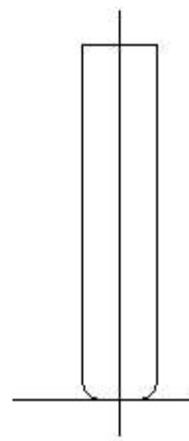
PROGRAM NUMBER: 0
SPINDLE SPEED: 1790 RPM
FEEDRATE: 537.0 mm/min
CLEARANCE PLANE: 50.0
RETRACT PLANE: 4.0
FEED PLANE: 2.0
DEPTH: NA
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET: 0



TOOL INFO

#2 - M16.00 ENDMILL3 BULL - 16. BULL ENDMILL 4. RAD

TYPE: Endmill3 Bull
NUMBER: 2
DIAMETER: 16.0
CORNER RADIUS: 4.0
LENGTH OFFSET: 2
DIAMETER OFFSET: 2
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.075
SFM: 89.978
MFG CODE: -
HOLDER:
TIME: 02:55:30

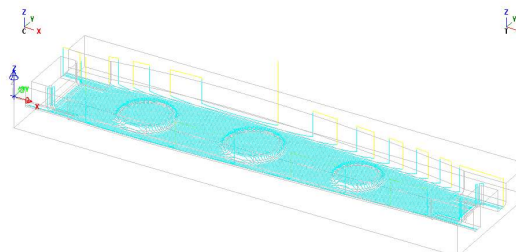


OPERATION INFO

Surface Finish Parallel

CYCLE TIME: 0 HOURS, 50 MINUTES, 43 SECONDS
COMMENT: -

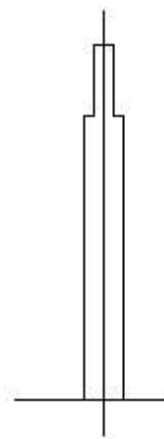
PROGRAM NUMBER: 0
SPINDLE SPEED: 2387 RPM
FEEDRATE: 381.92 mm/min
CLEARANCE PLANE: 50.0
RETRACT PLANE: 7.0
FEED PLANE: 5.0
DEPTH: NA
STOCK TO LEAVE: 0.0
COMP TO TIP: NO
WORK OFFSET: 0



TOOL INFO

#4 - M8.00 ENDMILL1 FLAT - 4. FLAT ENDMILL

TYPE: Endmill1 Flat
NUMBER: 4
DIAMETER: 8.0
CORNER RADIUS: 0.0
LENGTH OFFSET: 4
DIAMETER OFFSET: 4
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.04
SFM: 59.994
MFG CODE: -
HOLDER:
TIME: 00:50:43

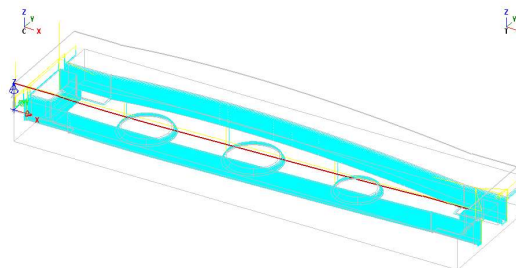


OPERATION INFO

Surface Finish Contour

CYCLE TIME: 3 HOURS, 0 MINUTES, 58 SECONDS
COMMENT: -

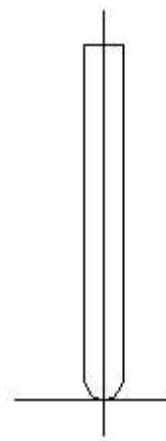
PROGRAM NUMBER: 0
SPINDLE SPEED: 2387 RPM
FEEDRATE: 381.92 mm/min
CLEARANCE PLANE: 50.0
RETRACT PLANE: 10.0
FEED PLANE: 5.0
DEPTH: NA
STOCK TO LEAVE: 0.0
COMP TO TIP: NO
WORK OFFSET: 0



TOOL INFO

#3 - M8.00 ENDMILL2 SPHERE - 8. BALL ENDMILL

TYPE: Endmill2 Sphere
NUMBER: 3
DIAMETER: 8.0
CORNER RADIUS: 4.0
LENGTH OFFSET: 3
DIAMETER OFFSET: 3
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.04
SFM: 59.994
MFG CODE: -
HOLDER:
TIME: 03:00:58

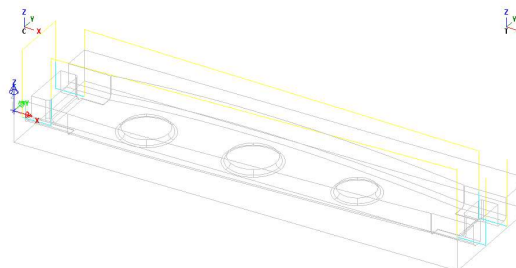


OPERATION INFO

Contour (2D)

CYCLE TIME: 0 HOURS, 1 MINUTES, 34 SECONDS
COMMENT: -

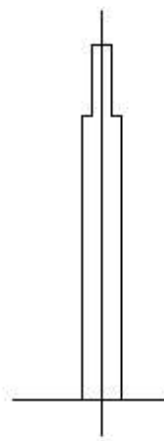
PROGRAM NUMBER: 0
SPINDLE SPEED: 2387 RPM
FEEDRATE: 238.7 mm/min
CLEARANCE PLANE: 50.0
RETRACT PLANE: 10.0
FEED PLANE: 5.0
DEPTH: -24.4
STOCK TO LEAVE: 0.0
COMP TO TIP: YES
WORK OFFSET: 0



TOOL INFO

#4 - M8.00 ENDMILL1 FLAT - 4. FLAT ENDMILL

TYPE: Endmill1 Flat
NUMBER: 4
DIAMETER: 8.0
CORNER RADIUS: 0.0
LENGTH OFFSET: 4
DIAMETER OFFSET: 4
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.025
SFM: 59.994
MFG CODE: -
HOLDER:
TIME: 00:01:34

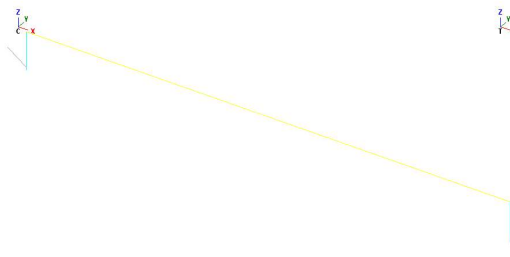


OPERATION INFO

Drill/Counterbore

CYCLE TIME: 0 HOURS, 0 MINUTES, 3 SECONDS
COMMENT: -

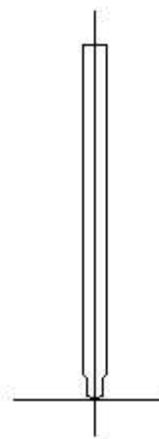
PROGRAM NUMBER: 0
SPINDLE SPEED: 7276 RPM
FEEDRATE: 1455.2 mm/min
CLEARANCE PLANE: 50.0
RETRACT PLANE: 25.0
FEED PLANE: 25.0
DEPTH: -26.5
STOCK TO LEAVE: 0.0
COMP TO TIP: NO
WORK OFFSET: 0



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: 00:00:03

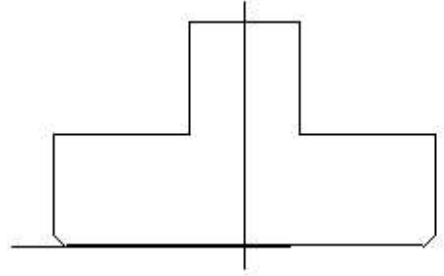


TOOL LIST

Sorted: NO

TOOL INFO **#1 - M80.00 FACE MILL - ROCA D80**

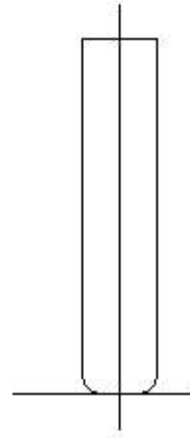
TYPE:	Face mill
NUMBER:	1
DIAMETER:	80.0
CORNER RADIUS:	0.0
LENGTH OFFSET:	1
DIAMETER OFFSET:	1
MATERIAL:	HSS
NUMBER OF FLUTES:	4
FPT:	0.051
SFM:	251.335
MFG CODE:	-
HOLDER:	
TIME:	00:19:42



USED BY OPERATION: # 1 Facing

TOOL INFO **#2 - M16.00 ENDMILL3 BULL - 16. BULL ENDMILL 4. RAD**

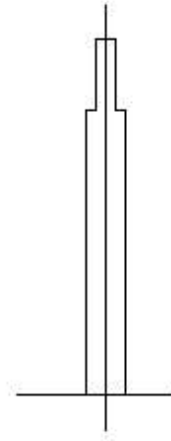
TYPE:	Endmill3 Bull
NUMBER:	2
DIAMETER:	16.0
CORNER RADIUS:	4.0
LENGTH OFFSET:	2
DIAMETER OFFSET:	2
MATERIAL:	HSS
NUMBER OF FLUTES:	4
FPT:	0.075
SFM:	89.978
MFG CODE:	-
HOLDER:	
TIME:	02:55:30



USED BY OPERATION: # 2 Surface High Speed (Area clearance)

TOOL INFO**#4 - M8.00 ENDMILL1 FLAT - 4. FLAT ENDMILL**

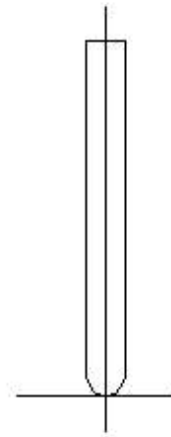
TYPE: Endmill1 Flat
NUMBER: 4
DIAMETER: 8.0
CORNER RADIUS: 0.0
LENGTH OFFSET: 4
DIAMETER OFFSET: 4
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.04
SFM: 59.994
MFG CODE: -
HOLDER:
TIME: 00:52:18



USED BY OPERATION: # 3 Surface Finish Parallel
USED BY OPERATION: # 5 Contour (2D)

TOOL INFO**#3 - M8.00 ENDMILL2 SPHERE - 8. BALL ENDMILL**

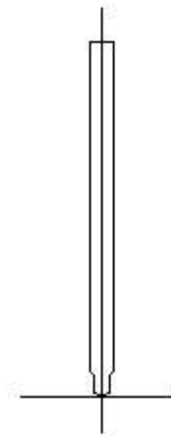
TYPE: Endmill2 Sphere
NUMBER: 3
DIAMETER: 8.0
CORNER RADIUS: 4.0
LENGTH OFFSET: 3
DIAMETER OFFSET: 3
MATERIAL: HSS
NUMBER OF FLUTES: 4
FPT: 0.04
SFM: 59.994
MFG CODE: -
HOLDER:
TIME: 03:00:58



USED BY OPERATION: # 4 Surface Finish Contour

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: 00:00:03



USED BY OPERATION: # 6 Drill/Counterbore

WORK OFFSETS

OFFSET INFO

NUMBER:	0	VNUM: 1	ORIGIN: 0.0, 0.0, 0.0
USED BY OPERATION:	#	All operations	