

Setup Sheet for Program 1001

JOB DESCRIPTION: Setup1

DOCUMENT PATH: C:\Users\De Silva04112018\Documents\Inventor\Trapped Roller Clutch\
Bearing Inner Ring.ipt

Setup

WCS: #0

STOCK:

DX: 0.373in
DY: 0.367in
DZ: 0.15in

PART:

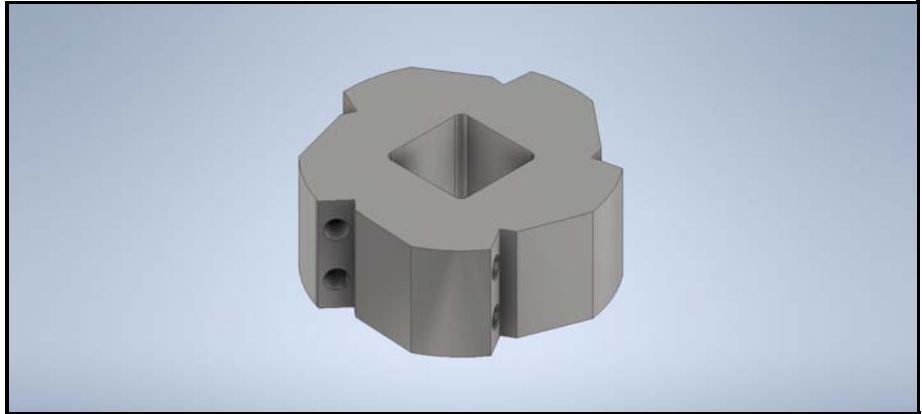
DX: 0.373in
DY: 0.367in
DZ: 0.15in

STOCK LOWER IN WCS #0:

X: 0in
Y: 0in
Z: -0.15in

STOCK UPPER IN WCS #0:

X: 0.373in
Y: 0.367in
Z: 0in



Total

NUMBER OF OPERATIONS: 4

NUMBER OF TOOLS: 1

TOOLS: **T1**

MAXIMUM Z: 0.6in

MINIMUM Z: -0.09in

MAXIMUM FEEDRATE: 14in/min

MAXIMUM SPINDLE SPEED: 16500rpm

CUTTING DISTANCE: 132.236in

RAPID DISTANCE: 23.616in

ESTIMATED CYCLE TIME: 12m:52s

Tools

T1 D1 L1

TYPE: flat end mill

DIAMETER: 0.031in

LENGTH: 1in

FLUTES: 2

DESCRIPTION: 1/32" Flat End Mill

VENDOR: Other Machine Co.

PRODUCT: OMC-TL1004

MINIMUM Z: -0.09in

MAXIMUM FEED: 14in/min

MAXIMUM SPINDLE SPEED: 16500rpm





CUTTING DISTANCE: 132.236in

RAPID DISTANCE: 23.616in

ESTIMATED CYCLE TIME: 12m:37s (98.1%)



Operations

<p>Operation 1/4</p> <p>DESCRIPTION: 2D Pocket4</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.004in</p> <p>STOCK TO LEAVE: 0in</p> <p>MAXIMUM STEPDOWN: 0.016in</p> <p>MAXIMUM STEPOVER: 0.016in</p>	<p>MAXIMUM Z: 0.6in</p> <p>MINIMUM Z: -0.09in</p> <p>MAXIMUM SPINDLE SPEED: 16500rpm</p> <p>MAXIMUM FEEDRATE: 14in/min</p> <p>CUTTING DISTANCE: 61.426in</p> <p>RAPID DISTANCE: 10.097in</p> <p>ESTIMATED CYCLE TIME: 5m:51s (45.5%)</p> <p>COOLANT: Off</p>	<p>T1 D1 L1</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 0.031in</p> <p>LENGTH: 1in</p> <p>FLUTES: 2</p> <p>DESCRIPTION: 1/32" Flat End Mill</p> <p>VENDOR: Other Machine Co.</p> <p>PRODUCT: OMC-TL1004</p>	
<p>Operation 2/4</p> <p>DESCRIPTION: 2D Pocket5</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.004in</p> <p>STOCK TO LEAVE: 0in</p> <p>MAXIMUM STEPDOWN: 0.016in</p> <p>MAXIMUM STEPOVER: 0.016in</p>	<p>MAXIMUM Z: 0.6in</p> <p>MINIMUM Z: -0.09in</p> <p>MAXIMUM SPINDLE SPEED: 16500rpm</p> <p>MAXIMUM FEEDRATE: 14in/min</p> <p>CUTTING DISTANCE: 11.499in</p> <p>RAPID DISTANCE: 1.087in</p> <p>ESTIMATED CYCLE TIME: 49s (6.4%)</p> <p>COOLANT: Off</p>	<p>T1 D1 L1</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 0.031in</p> <p>LENGTH: 1in</p> <p>FLUTES: 2</p> <p>DESCRIPTION: 1/32" Flat End Mill</p> <p>VENDOR: Other Machine Co.</p> <p>PRODUCT: OMC-TL1004</p>	
<p>Operation 3/4</p> <p>DESCRIPTION: 2D Pocket6</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.004in</p> <p>STOCK TO LEAVE: 0in</p> <p>MAXIMUM STEPDOWN: 0.016in</p> <p>MAXIMUM STEPOVER: 0.016in</p>	<p>MAXIMUM Z: 0.6in</p> <p>MINIMUM Z: -0.07in</p> <p>MAXIMUM SPINDLE SPEED: 16500rpm</p> <p>MAXIMUM FEEDRATE: 14in/min</p> <p>CUTTING DISTANCE: 49.363in</p> <p>RAPID DISTANCE: 11.365in</p> <p>ESTIMATED CYCLE TIME: 5m:14s (40.7%)</p> <p>COOLANT: Off</p>	<p>T1 D1 L1</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 0.031in</p> <p>LENGTH: 1in</p> <p>FLUTES: 2</p> <p>DESCRIPTION: 1/32" Flat End Mill</p> <p>VENDOR: Other Machine Co.</p> <p>PRODUCT: OMC-TL1004</p>	
<p>Operation 4/4</p> <p>DESCRIPTION: 2D Pocket7</p> <p>STRATEGY: Pocket 2D</p> <p>WCS: #0</p> <p>TOLERANCE: 0.004in</p> <p>STOCK TO LEAVE: 0in</p> <p>MAXIMUM STEPDOWN: 0.016in</p> <p>MAXIMUM STEPOVER: 0.016in</p>	<p>MAXIMUM Z: 0.6in</p> <p>MINIMUM Z: -0.07in</p> <p>MAXIMUM SPINDLE SPEED: 16500rpm</p> <p>MAXIMUM FEEDRATE: 14in/min</p> <p>CUTTING DISTANCE: 9.949in</p> <p>RAPID DISTANCE: 1.067in</p> <p>ESTIMATED CYCLE TIME: 43s (5.5%)</p> <p>COOLANT: Off</p>	<p>T1 D1 L1</p> <p>TYPE: flat end mill</p> <p>DIAMETER: 0.031in</p> <p>LENGTH: 1in</p> <p>FLUTES: 2</p> <p>DESCRIPTION: 1/32" Flat End Mill</p> <p>VENDOR: Other Machine Co.</p> <p>PRODUCT: OMC-TL1004</p>	

Generated by [Inventor CAM Ultimate 7.3.1.20023](#) Sunday, December 06, 2020 19:19:11