

# Setup

SETUP : SETUP4

SetupStockPost Process

Setup

Operation TypeMilling

Work Coordinate System (WCS)

OrientationSelect Z axis/plane && X axis

Z AxisFace

Flip Z Axis

X Axis

Flip X Axis

OriginSelected point

WCS OriginEdge

Model

ModelBody

Fixture

OKCancel

SETUP : SETUP4

SetupStockPost Process

Stock

ModeFixed size box

Width (X)300 mm

Model PositionCenter

Depth (Y)800 mm

Model PositionCenter

Height (Z)20 mm

Model PositionOffset from top (+Z)

Offset4 mm

Round Up to Nearest10 mm

Dimensions

Width (X)300 mm

Depth (Y)800 mm

Height (Z)20 mm

OKCancel

SETUP : SETUP4

SetupStockPost Process

Program

Program Name/Number1001

Program Comment

Machine WCS

WCS Offset0

Probe WCS override0

Multiple WCS Offsets

OK

# 2d Contour

2D CONTOUR : 2D CONTOUR2

ToolGeometryHeightsPassesLinking

Tool

ToolSelect...

#1 - Ø1/4" flat (1/4" Flat Endmill)

CoolantFlood

Feed & Speed

Spindle Speed10000 rpm

Surface Speed199.491 m/min

Ramp Spindle Speed10000 rpm

Cutting Feedrate1524 mm/min

Feed per Tooth0.0508 mm

Lead-In Feedrate1524 mm/min

Lead-Out Feedrate1524 mm/min

Ramp Feedrate1524 mm/min

Plunge Feedrate762 mm/min

Feed per Revolution0.0762 mm

OKCancel

2D CONTOUR : 2D CONTOUR2

ToolGeometryHeightsPassesLinking

Geometry

Contour Selection3 Chains

Tangential Extension Distance0 mm

Separate Tangential End Extension

Stock Contours

Tab

Tab ShapeRectangular

Tab Width6.35 mm

Tab Height1.5875 mm

Tab PositioningBy distance

Tab Distance50.8 mm

Rest Machining

Wrap Toolpath

Tool Orientation

OKCancel

2D CONTOUR : 2D CONTOUR2

ToolGeometryHeightsPassesLinking

Clearance Height

FromRetract height

Offset10 mm

Retract Height

FromStock top

Offset5 mm

Feed Height

FromTop height

Offset5 mm

Top Height

FromStock top

Offset0 mm

Bottom Height

FromSelected contour(s)

Offset0 mm

OKCancel

2D CONTOUR : 2D CONTOUR2

ToolGeometryHeightsPassesLinking

Passes

Tolerance0.01 mm

Sideways CompensationLeft (climb milling)

Compensation TypeIn computer

Finishing Smoothing Deviation0 mm

Multiple Finishing Passes

Finish Feedrate1524 mm/min

Repeat Finishing Pass

Finishing Overlap0 mm

Lead End Distance0 mm

Outer Corner ModeRoll around corner

Tangential Fragment Extension Distance0 mm

Preserve Order

Both Ways

Roughing Passes

Multiple Depths

Stock to Leave

Smoothing

Feed Optimization

OKCancel