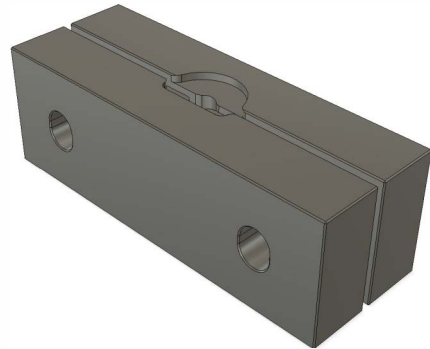


Setup sheet for program crank soft jaw

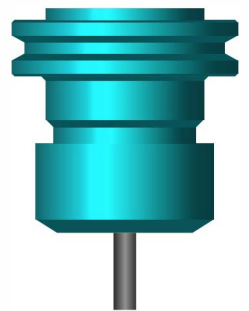
▼ Summary

Program comment: Number of operations: 4
Design document: 4
Crank Soft Jaw v8
Product version: Number of tools: 1
Fusion 360 CAM Tools: T1
2.0.13377 **Maximum Z:** 0.6 in
Created: **Minimum Z:** -0.6192 in
06/27/2022 09:42:52
Number of setups: 1
Maximum feedrate: 99.46 in/min
Maximum spindle speed: 11999 rpm
Cutting distance: 43.0124 in
Rapid distance: 6.4541 in
Estimated cycle time: 27s



▼ Tools

| | | |
|---------------------------------|-------------------------------|----------------------------------|
| Number: 1 | Number of flutes: 3 | Cutting distance: |
| Diameter offset: 1 | Tool description: | 43.0124 in |
| Length offset: 1 | 1/4" Flat Endmill | Rapid distance: 6.4541 in |
| Tool type: flat end mill | Tool product: | Estimated cycle time: 27s |
| Diameter: 0.25 in | Minimum Z: -0.6192 in | Holder description: |
| Length: 0.85 in | Maximum feedrate: | CAT40-ER32-2.35 |
| | 99.46 in/min | Holder product: |
| | Maximum spindle speed: | |
| | 11999 rpm | |

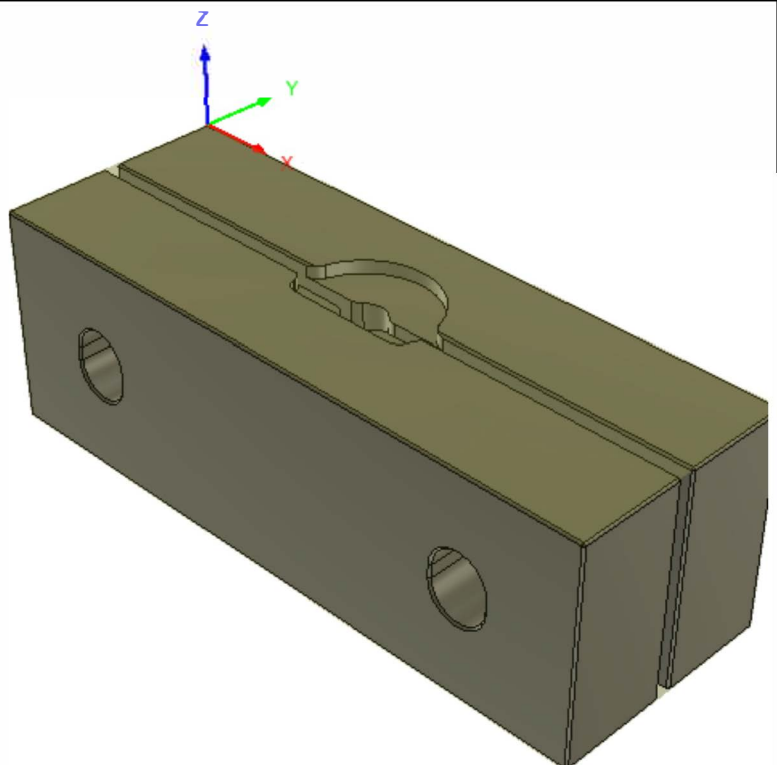


▼ Setup

| | | |
|---------------------|---------------|---------------------|
| Description: | Stock: | Stock lower: |
| Op1 | x: 6 in | x: 0 in |
| WCS: 1 | y: 2.125 in | y: -2.125 in |
| | z: 2 in | z: -2 in |
| | Part: | Stock upper: |
| | x: 6 in | x: 6 in |
| | y: 2.125 in | y: 0 in |
| | z: 2 in | z: 0 in |

Notes:

WCS located at top left corner of sotj jaw. Use 1/8" spacer between jaws.



▼ Operations

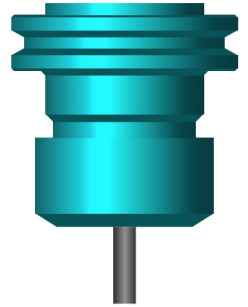
WCS #1

Operation 1/4

Description: 2D Adaptive1
Strategy: Adaptive 2D
WCS: 1
Tolerance: 0.004 in
Radial stock to leave: 0.01 in
Axial stock to leave: 0 in
Optimal load: 0.047 in
Load deviation: 0.0047 in
Maximum Z: 0.6 in

Minimum Z: -0.6192 in
Maximum spindle speed: 11999 rpm
Maximum feedrate: 99.46 in/min
Cutting distance: 19.7262 in
Rapid distance: 1.6922 in
Estimated cycle time: 12s
Coolant: Flood
Number: 1
Diameter offset: 1

Length offset: 1
Diameter: 0.25 in
Length: 0.85 in
Number of flutes: 3
Tool type: flat end mill
Tool description: 1/4" Flat Endmill
Tool product:
Holder description: CAT40-ER32-2.35
Holder product:



Notes:

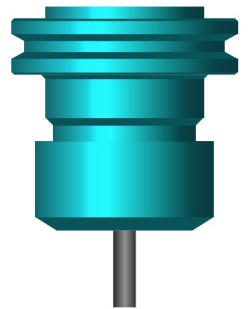
Set radial stock to leave to .010" and axial stock to leave to 0". Set helical ramp diameter to .07" on linking tab.

Operation 2/4

Description: 2D Contour1
Strategy: Contour 2D
WCS: 1
Tolerance: 0.0004 in
Stock to leave: 0 in
Maximum stepover: 0.2375 in
Maximum Z: 0.6 in
Minimum Z: -0.6192 in
Maximum spindle speed: 11999 rpm

Maximum feedrate: 99.46 in/min
Cutting distance: 1.4388 in
Rapid distance: 1.5942 in
Estimated cycle time: 2s
Coolant: Flood
Number: 1
Diameter offset: 1
Length offset: 1
Diameter: 0.25 in

Length: 0.85 in
Number of flutes: 3
Tool type: flat end mill
Tool description: 1/4" Flat Endmill
Tool product:
Holder description: CAT40-ER32-2.35
Holder product:

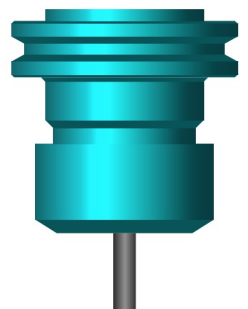


Operation 3/4

Description: 2D Adaptive2
Strategy: Adaptive 2D
WCS: 1
Tolerance: 0.004 in
Radial stock to leave: 0.01 in
Axial stock to leave: 0 in
Optimal load: 0.1 in
Load deviation: 0.01 in
Maximum Z: 0.6 in

Minimum Z: -0.1192 in
Maximum spindle speed: 11999 rpm
Maximum feedrate: 99.46 in/min
Cutting distance: 18.4642 in
Rapid distance: 2.0735 in
Estimated cycle time: 11s
Coolant: Flood
Number: 1
Diameter offset: 1

Length offset: 1
Diameter: 0.25 in
Length: 0.85 in
Number of flutes: 3
Tool type: flat end mill
Tool description: 1/4" Flat Endmill
Tool product:
Holder description: CAT40-ER32-2.35
Holder product:



Notes:

Set radial stock to leave to .010" and axial stock to leave to 0".

Operation 4/4

| | | |
|---------------------------------|------------------------------------|---------------------------------|
| Description: 2D Contour2 | Maximum feedrate: | Length: 0.85 in |
| Strategy: Contour 2D | 99.46 in/min | Number of flutes: 3 |
| WCS: 1 | Cutting distance: 3.3833 in | Tool type: flat end mill |
| Tolerance: 0.0004 in | Rapid distance: 1.0942 in | Tool description: |
| Stock to leave: 0 in | Estimated cycle time: 2s | 1/4" Flat Endmill |
| Maximum stepover: | Coolant: Flood | Tool product: |
| 0.2375 in | Number: 1 | Holder description: |
| Maximum Z: 0.6 in | Diameter offset: 1 | CAT40-ER32-2.35 |
| Minimum Z: -0.1192 in | Length offset: 1 | Holder product: |
| Maximum spindle speed: | Diameter: 0.25 in | |
| 11999 rpm | | |

