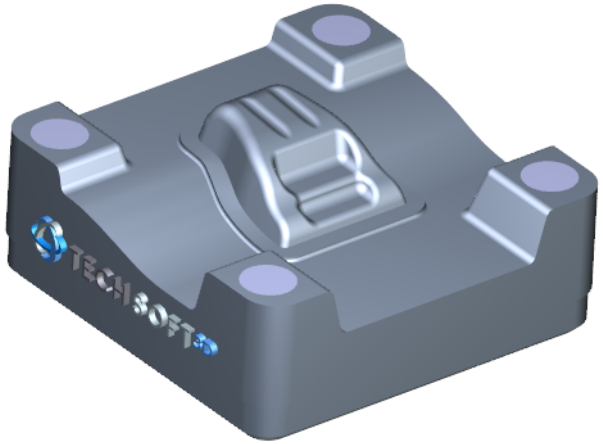
TECH SOFT 3D
Dependable. Dynamic. Durable.

Part	Machine	Material	Units	Programmer	Date
PRJ 150 - Core	TTC HERMLE	Z40CDV5.1	mm	LVI	2018/05/01

Num. of operations	9	
Num. of Tools	6	
Post name	Post HER 3x	
Material size	240 x 240 x 110	
Work range	Min	Max
X	-23.02	262.989
Y	-27.006	263.02
Z	-50	23
Max feed rate	9000 mm/mn	
Max spindle rate	5000 tr/mn	
Cutting distance	243 m	
Rapid distance	60 m	
Total time	02:14:10	



T - 1 - EM20

Op	Tool	Method	Min Z	Feed (mm/mn)	Spindle (rpm)	Time
1	T - 1 - EM20	Roughing constant Z	-50.000	2000	1000	00:11:32
2	T - 2 - BM12	Rest roughing constant Z	-47.758	3000	1500	00:25:40
3	T - 2 - BM12	Combined machining constant Z and surface	-46.547	3000	1500	00:19:50
4	T - 3 - BM10	Combined machining constant Z and surface - Core	-42.824	4000	2000	00:08:45
5	T - 3 - BM10	Surface machining linear - Parting faces	-45.874	4000	2000	00:15:46
6	T - 4 - BM06	Radius machining	-45.826	7000	3500	00:04:56

Type	Flat end mill
Diam.	20
Corner R.	0
Length	24
Flutes	2
Holder	BT40 ER 32x60