

Summary

SETUP SHEET
Project

Project
Intro to 2.5 Axis

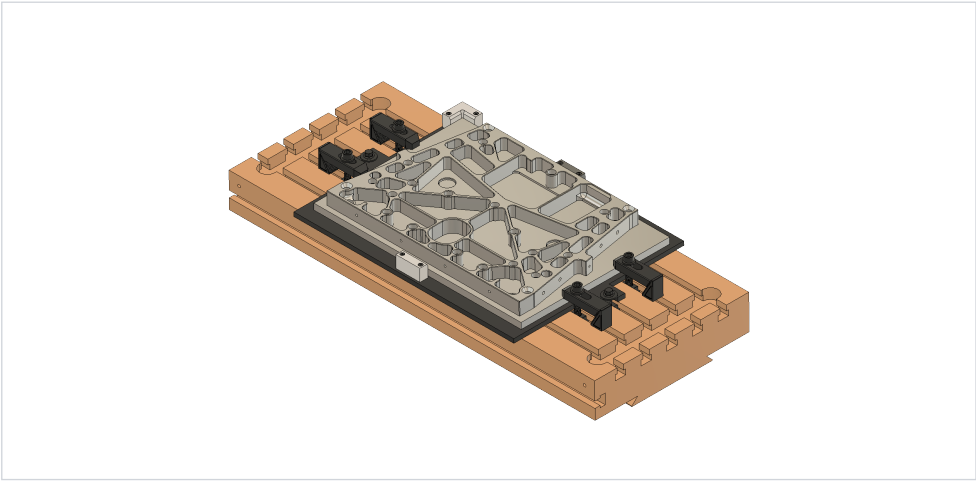
Description

Status
Draft

Created by
Long Han

Number of Tools
8

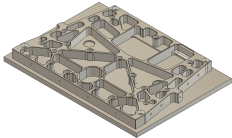
Cycle time
01:18:57



Jobs

#	Name	Part	Machine	Number of Operations	Number of Tools	Cycle time
1	Setup1	 Mono Chassis PRT/25/0011	 Haas VF-1 M0010	11	8	01:18:57

Summary

Job	Project	
Setup1	Intro to 2.5 Axis	
Part	Part Number	Status
Mono Chassis	PRT/25/0011	Draft
Customer Number	Material	Created by
	UNI/C45/220.0 HB	Long Han
Machine	Designation	
Haas VF-1	M0010	
Model	Builder	
VF-1	Haas	
Order	Number of Operations	
0	11	
Number of Tools	Cycle time	
8	01:18:57	

Operations

#	Name	Tool Assembly		Tool No.	Est. Cycle Time
01	Face		BT40_FM80 TA0006	T2	00:11:57
02	Rought big pockets		TA0059	T3	00:04:29
03	Wall finish big pockets		TA0003	T4	00:12:08
04	Rough small pockets		TA0003	T4	00:29:32
05	2D Wall finish small pockets		TA0003	T4	00:08:22
06	Counter sink		TA0062	T5	00:00:04
07	Drill		TA0064	T6	00:00:05
08	Reaming		TA0063	T7	00:00:04
09	Drill6		TA0066	T14	00:00:02
10	Rest finishing		TA0003	T4	00:04:06

#	Name	Tool Assembly	Tool No.	Est. Cycle Time
11	Chamfering	 TA0065	T8	00:08:08

Tools

#	Tool Assembly	Operation no	Est. Cycle Time
T2	 BT40_FM80 TA0006 LTA: 100.8 mm WTA: 40.0 mm	#01	00:11:57
Tools List	Tool ID T000011	Location Haas VF-1/#2	Condition Used Rem. Life 02:00:00
Bill of Materials	AA2B05-40 25 051 I/24/0028	Quantity 1	Forecasted/On Hand 9/9
	R245-18 T6 M-PM 4340 I/25/0043	Quantity 4	Forecasted/On Hand 46/46
	RA245-080J25-18M I/25/0042	Quantity 1	Forecasted/On Hand 4/4
T3	 TA0059 LTA: 194.0 mm WTA: 12.516 mm	#02	00:04:29
Bill of Materials	930-BB40-HD-25-094 I/25/0048	Quantity 1	Forecasted/On Hand 0/0
	R216.38-25045ICK45K 1640 I/25/0050	Quantity 1	Forecasted/On Hand 0/0
T4	 TA0003 LTA: 119.0 mm WTA: 4.0 mm	#03, #04, #05, #10	00:54:08
Bill of Materials	930-BB40-S-08-075 I/24/0031	Quantity 1	Forecasted/On Hand 0/0
	2P160-0800-NA H10F I/25/0054	Quantity 1	Forecasted/On Hand 0/0
T5	 TA0062 HTA: 0.44 mm LTA: 130.665 mm WTA: 7.988 mm	#06	00:00:04
Bill of Materials	392.55523-4020065 I/25/0055	Quantity 1	Forecasted/On Hand 0/0
	880-02 02 04H-C-LM 1044 I/25/0047	Quantity 1	Forecasted/On Hand 0/0
	880-02 02 W05H-P-LM 4044 I/25/0045	Quantity 1	Forecasted/On Hand 0/0
	880-D1600L20-03 I/25/0051	Quantity 1	Forecasted/On Hand 0/0
T6	 TA0064 LTA: 128.52 mm WTA: 3.9 mm	#07	00:00:05
Bill of Materials	930-BB40-S-08-075 I/24/0031	Quantity 1	Forecasted/On Hand 0/0
	860.1-0780-040A0-PM 4234 I/25/0046	Quantity 1	Forecasted/On Hand 0/0

#	Tool Assembly		Operation no	Est. Cycle Time
T7		TA0063 LTA: 137.8 mm WTA: 4.0 mm	#08	00:00:04
Bill of Materials	930-BB40-S-08-075 I/24/0031		Quantity 1	Forecasted/On Hand 0/0
	835.T-0800-A1-MF 1024 I/25/0052		Quantity 1	Forecasted/On Hand 0/0
T14		TA0066 LTA: 129.725 mm WTA: 6.25 mm	#09	00:00:02
Bill of Materials	A2B14-40 32 070 I/24/0024		Quantity 1	Forecasted/On Hand 0/0
	393.15-32 14 I/25/0056		Quantity 1	Forecasted/On Hand 0/0
	860.1-1250-039A0-GM X1BM I/25/0057		Quantity 1	Forecasted/On Hand 0/0
T8		TA0065 LTA: 111.5 mm WTA: 1.5 mm	#11	00:08:08
Bill of Materials	393.14-32 120 I/25/0053		Quantity 1	Forecasted/On Hand 0/0
	A2B14-40 32 070 I/24/0024		Quantity 1	Forecasted/On Hand 0/0
	1C050-0300-045-XA 1620 I/25/0049		Quantity 1	Forecasted/On Hand 0/0