
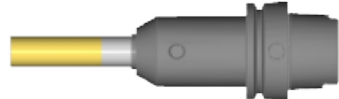

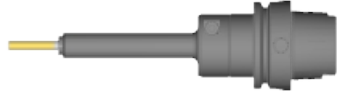

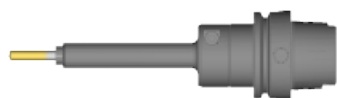



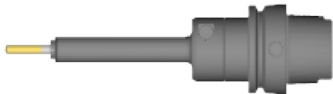
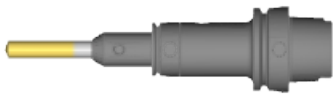

TOOL SETUP SHEET



File Name **Lesson_6_Completed.esprit**
 Machine Name **Horizontal_Mill_4-axis**
 File Unit **Inch**

T- 1 - FM 2.5 in		Milling Head		Station 1	L-Comp: 1	(Inch)
Tool Diameter	2.5	Bottom Clearance	0.05	Tool Material	CARBIDE	
Tool/Overall Length	1.5 / 1.5	# Inserts	6	Process	1	
Cutting Length	1.5	Corner Radius	0.02	Coolant	On	
Orientation Angle	0	Insert Type	Square			
Adaptive Items HSK63ASMC22100M						
Comments						
T- 2 - EM 0.75 in		Milling Head		Station 1	L-Comp: 2	(Inch)
Tool Diameter	0.75	Coolant	On	Tool Material	CARBIDE	
Tool/Overall Length	3 / 3.125	Flutes	2			
Cutting Length	2.25	Process	2			
Adaptive Items HSK63AEM075375						
Comment						

T- 2 - EM 0.5 in				Milling Head		Station 1		L-Comp: 2		(Inch)
Tool Diameter	0.5	Coolant	On		Tool Material	CARBIDE				
Tool/Overall Length	1.5 / 1.55	Flutes	2							
Cutting Length	1.25	Process	3							
Adaptive Items	HSK63AKM40080M HSK40AEM038250									
Comment										
T- 3 - EM 0.25 in				Milling Head		Station 1		L-Comp: 2		(Inch)
Tool Diameter	0.25	Coolant	On		Tool Material	CARBIDE				
Tool/Overall Length	1.375 / 1.5	Flutes	2							
Cutting Length	1.25	Process	4							
Adaptive Items	HSK63HCSLT10160M									
Comment										
T- 4 - SDR 0.5 in				Milling Head		Station 1		L-Comp: 8		(Inch)
Tool Diameter	0.5	Tip Angle	90		Tool Material	CARBIDE				
Tool/Overall Length	2.5 / 2.5	Flutes	2		Process	5				
Cutting Length	2	Coolant	On							
Adaptive Items	HSK63AKM40080M HSK40AEM038250									
Comments										
T- 5 - DR 0.257 in (F)				Milling Head		Station 1		L-Comp: 8		(Inch)
Tool Diameter	0.257	Tip Angle	135		Tool Material	CARBIDE				
Tool/Overall Length	1.3 / 1.5	Flutes	2		Process	6				
Cutting Length	1.04	Coolant	On							
Adaptive Items	HSK63HCSLT10160M									
Comments										

T- 6 - CM 0.5 in				Milling Head		Station 1		L-Comp: 6		(Inch)
Tool Diameter	0.25	Chamfer Angle	45	Tool Material	CARBIDE					
Tool/Overall Length	2 / 2.125	Flutes	2	Process	7					
Cutting Length	0.25	Coolant	On							
Adaptive Items	HSK63AKM40080M HSK40AEM038250									
Comments										
T- 6 - DR 0.25 in				Milling Head		Station 1		L-Comp: 8		(Inch)
Tool Diameter	0.25	Tip Angle	135	Tool Material	CARBIDE					
Tool/Overall Length	1.25 / 1.375	Flutes	2	Process	8					
Cutting Length	1	Coolant	On							
Adaptive Items	HSK63HCSLT10160M									
Comments										
T- 8 - DR 0.5 in				Milling Head		Station 1		L-Comp: 8		(Inch)
Tool Diameter	0.5	Tip Angle	135	Tool Material	CARBIDE					
Tool/Overall Length	2.5 / 2.55	Flutes	2	Process	9					
Cutting Length	2	Coolant	On							
Adaptive Items	HSK63AKM40080M HSK40AEM038250									
Comments										
T- 10 - TM 1/2 - 13				Milling Head		Station 1		L-Comp: 10		(Inch)
Tool Diameter	0.42	Coolant	On	Tool Material	CARBIDE					
Tool/Overall Length	1.5 / 1.625	Flutes	2							
Cutting Length	0.375	Process	10							
Adaptive Items	HSK63HCSLT10160M									
Comment										