

**PowerMill Setup Sheet**

Project	Diplomová práce - vrtací cykly 1. upnutí
PowerMill Version	PowerMILL 2022.000 CodeBase 2022005
Page Generated:	12:03 odp. on 2023-05-19

**NC Program NC program obrábění**

Customer	Diplomová práce
Part Name	1. upnutí vrtací cykly
Order Number	1
CAD Model	C:/Users/Antonin/Desktop/TOM/Databaze/Databaze_upinek_a_upinacu/SCHUNK Kontec KSX.stl C:/Users/Antonin/Desktop/TOM/Díly na praktickou/forma.CATPart
Programmer	Tomáš Jelínek
Option File	C:/Users/Antonin/Desktop/TOM/Databaze/opt/AP_TAJMAC-MCV_1210_Sinumerik_840D_v20_VECTOR.pmoptz
Tool Datum Setting	Špička
Cutting Time For NC Program	0:013:21
Total Time For NC Program	0:23:52



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**NC Program Notes**

Materiál obrobku: Hliník - slévárenská litina - ≤ 12% Si, kalitelná - zakalená - 300N/mm<sup>2</sup> / 90 HB

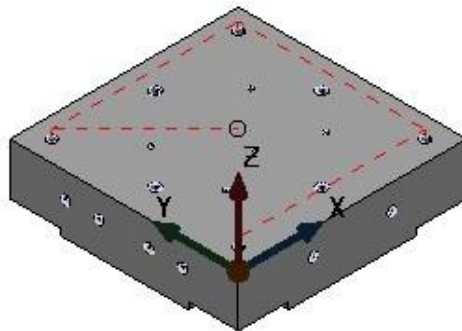
Všechny využitě nástroje v projektu jsou z rodiny HSS s volenými řeznými podmínkami dle materiálu obrobku.

**PowerMill Setup Sheet**

<b>Project</b>	Diplomová práce - vrtací cykly 1. upnutí
<b>NC Program</b>	NC program obrabeni
<b>PowerMill Version</b>	PowerMILL 2022.000 CodeBase 2022005
<b>Page Generated:</b>	12:03 odp. on 2023-05-19
<b>Order Number</b>	1
<b>CAD Model</b>	C:/Users/Antonin/Desktop/TOM/Databaze/Databaze_upinek_a_upinacu/SCHUNK Kontec KSX.stl C:/Users/Antonin/Desktop/TOM/Dily na praktickou/forma.CATPart

**Toolpath**

<b>Name</b>	D12_Navrtani		
<b>Description</b>			
<b>Strategy</b>	Vrtání		
<b>Tolerance</b>	0,1	<b>Cutting Feed Rate</b>	405
<b>Global Thickness</b>	0	<b>Plunge Feed Rate</b>	40
<b>Radial Thickness</b>	0	<b>Rapid Feed Rate</b>	3000
<b>Axial Thickness</b>		<b>Spindle</b>	4775
<b>Stepover</b>		<b>Cutting Time</b>	0:00:04
<b>Stepdown</b>		<b>Total Time</b>	0:00:24
<b>Block</b>	274 × 274 × 72		

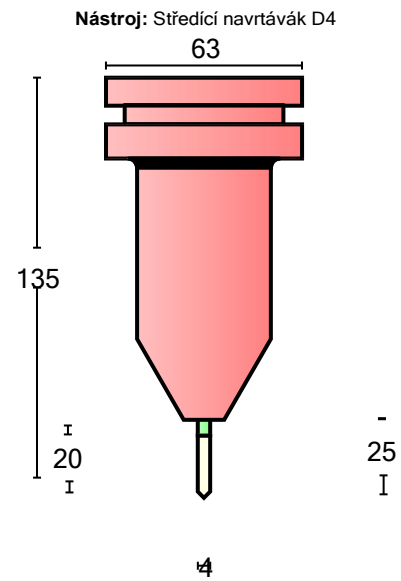


## Toolpath Limits

	X	Y	Z
Start Point	274	297	-258
Minimum	25	25	-2
Maximum	249	249	10

## Tool

Name	Středící navrtávák D4
Number	1
Type	Vrták
Diameter	4
Tip radius	
Length	20



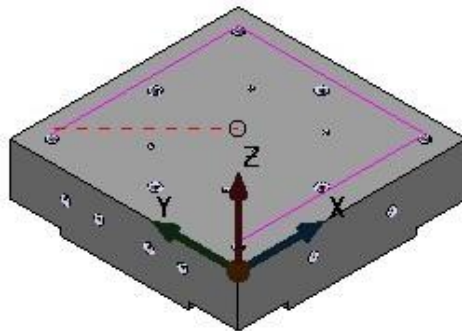
## Toolpath Notes

**PowerMill Setup Sheet**

<b>Project</b>	Diplomová práce - vrtací cykly 1. upnutí
<b>NC Program</b>	NC program obrabeni
<b>PowerMill Version</b>	PowerMILL 2022.000 CodeBase 2022005
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<b>CAD Model</b>	C:/Users/Antonin/Desktop/TOM/Databaze/Databaze_upinek_a_upinacu/SCHUNK Kontec KSX.stl C:/Users/Antonin/Desktop/TOM/Dily na praktickou/forma.CATPart

**Toolpath**

<b>Name</b>	D12_Vrtani		
<b>Description</b>			
<b>Strategy</b>	Vrtání		
<b>Tolerance</b>	0,1	<b>Cutting Feed Rate</b>	405
<b>Global Thickness</b>	0	<b>Plunge Feed Rate</b>	40
<b>Radial Thickness</b>	0	<b>Rapid Feed Rate</b>	3000
<b>Axial Thickness</b>		<b>Spindle</b>	1619
<b>Stepover</b>		<b>Cutting Time</b>	0:01:20
<b>Stepdown</b>		<b>Total Time</b>	0:01:43
<b>Block</b>	274 × 274 × 72		

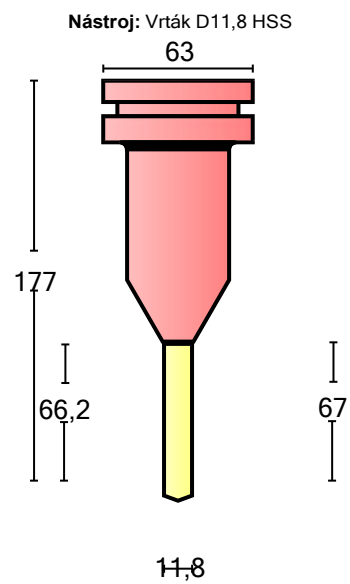


## Toolpath Limits

	X	Y	Z
Start Point	274	297	-258
Minimum	25	25	-66
Maximum	249	249	10

## Tool

Name	Vrták D 11,8 HSS
Number	2
Type	Vrták
Diameter	11,8
Tip radius	
Length	66,2



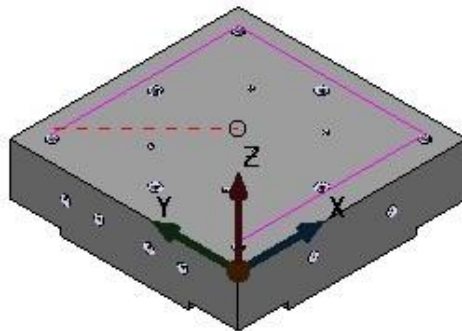
## Toolpath Notes

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<b>NC Program</b>	NC program obrabeni
<b>PowerMill Version</b>	PowerMILL 2022.000 CodeBase 2022005
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**Toolpath**

<b>Name</b>	D12_Vystružení		
<b>Description</b>			
<b>Strategy</b>	Stružení		
<b>Tolerance</b>	0,005	<b>Cutting Feed Rate</b>	160
<b>Global Thickness</b>	0	<b>Plunge Feed Rate</b>	16
<b>Radial Thickness</b>	0	<b>Rapid Feed Rate</b>	3000
<b>Axial Thickness</b>		<b>Spindle</b>	477
<b>Stepover</b>		<b>Cutting Time</b>	0:02:00
<b>Stepdown</b>		<b>Total Time</b>	0:02:18
<b>Block</b>	274 × 274 × 72		



## Toolpath Limits

	X	Y	Z
Start Point	274	297	-258
Minimum	25	25	-18
Maximum	249	249	10

## Tool

Name	Výstružník D12 H7
Number	3
Type	Vrták
Diameter	12
Tip radius	
Length	44

**Nástroj: Výstružník D12 H7**

63

245.997

44

106

12

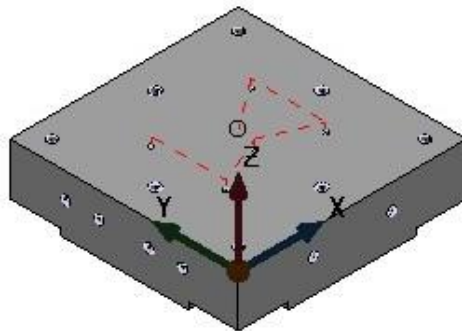
## Toolpath Notes

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<b>NC Program</b>	NC program obrabeni
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**Toolpath**

<b>Name</b>	D6_navrtání		
<b>Description</b>			
<b>Strategy</b>	Vrtání		
<b>Tolerance</b>	0,1	<b>Cutting Feed Rate</b>	405
<b>Global Thickness</b>	0	<b>Plunge Feed Rate</b>	40
<b>Radial Thickness</b>	0	<b>Rapid Feed Rate</b>	3000
<b>Axial Thickness</b>		<b>Spindle</b>	3183
<b>Stepover</b>		<b>Cutting Time</b>	0:00:05
<b>Stepdown</b>		<b>Total Time</b>	0:00:15
<b>Block</b>	274 × 274 × 72		



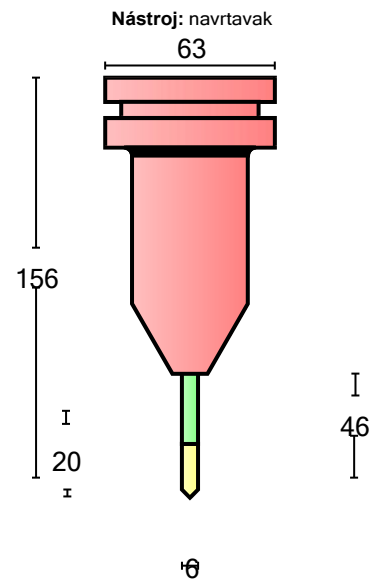


## Toolpath Limits

	X	Y	Z
Start Point	274	297	-258
Minimum	77	92	-2
Maximum	197	182	10

## Tool

Name	navrtavak
Number	4
Type	Vrták
Diameter	6
Tip radius	
Length	20



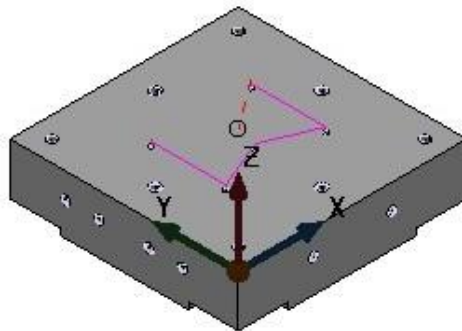
## Toolpath Notes

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**Toolpath**

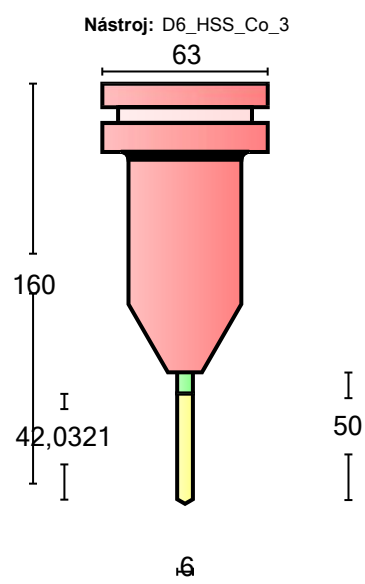
<b>Name</b>	D6_vrtání		
<b>Description</b>			
<b>Strategy</b>	Vrtání		
<b>Tolerance</b>	0,1	<b>Cutting Feed Rate</b>	405
<b>Global Thickness</b>	0	<b>Plunge Feed Rate</b>	40
<b>Radial Thickness</b>	0	<b>Rapid Feed Rate</b>	3000
<b>Axial Thickness</b>		<b>Spindle</b>	3183
<b>Stepover</b>		<b>Cutting Time</b>	0:03:05
<b>Stepdown</b>	12	<b>Total Time</b>	0:03:15
<b>Block</b>	274 × 274 × 72		



## Toolpath Limits

	X	Y	Z
Start Point	274	297	-258
Minimum	77	92	-41,732
Maximum	197	182	10

## Tool

Name	D6_HSS_Co_3	 <p>Nástroj: D6_HSS_Co_3</p> <p>63</p> <p>160</p> <p>42,0321</p> <p>50</p> <p>6</p>
Number	5	
Type	Vrták	
Diameter	6	
Tip radius		
Length	42,032	

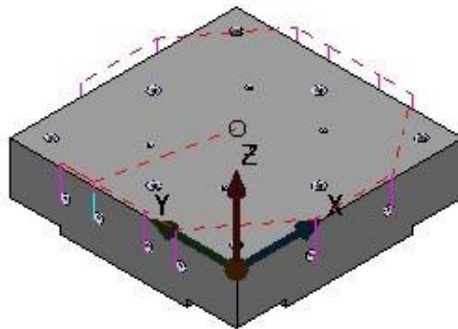
## Toolpath Notes

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**Toolpath**

<b>Name</b>	M10_Navrtání		
<b>Description</b>			
<b>Strategy</b>	Vrtání		
<b>Tolerance</b>	0,1	<b>Cutting Feed Rate</b>	405
<b>Global Thickness</b>	0	<b>Plunge Feed Rate</b>	40
<b>Radial Thickness</b>	0	<b>Rapid Feed Rate</b>	3000
<b>Axial Thickness</b>		<b>Spindle</b>	3183
<b>Stepover</b>		<b>Cutting Time</b>	0:00:12
<b>Stepdown</b>		<b>Total Time</b>	0:01:43
<b>Block</b>	274 × 274 × 72		

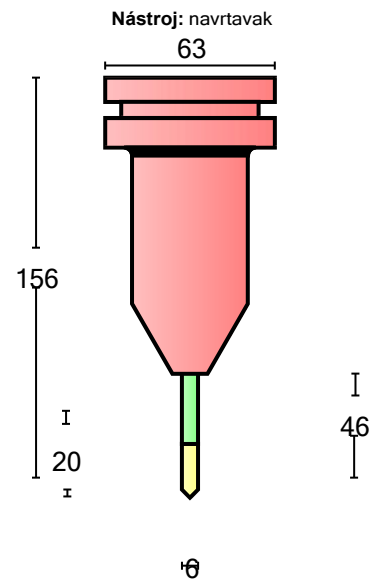


## Toolpath Limits

	X	Y	Z
Start Point	274	297	-258
Minimum	-5,25	-5,25	-30,03
Maximum	279,25	279,25	10

## Tool

Name	navrtavak
Number	4
Type	Vrták
Diameter	6
Tip radius	
Length	20



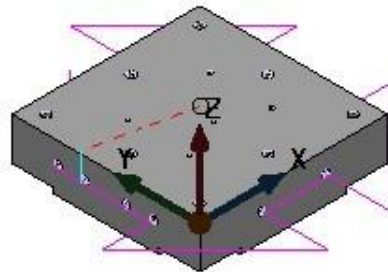
## Toolpath Notes

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<b>NC Program</b>	NC program obrabeni
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**Toolpath**

<b>Name</b>	M10_Vrtání		
<b>Description</b>			
<b>Strategy</b>	Vrtání		
<b>Tolerance</b>	0,1	<b>Cutting Feed Rate</b>	405
<b>Global Thickness</b>	0	<b>Plunge Feed Rate</b>	40
<b>Radial Thickness</b>	0	<b>Rapid Feed Rate</b>	3000
<b>Axial Thickness</b>		<b>Spindle</b>	2247
<b>Stepover</b>		<b>Cutting Time</b>	0:03:45
<b>Stepdown</b>	20	<b>Total Time</b>	0:05:58
<b>Block</b>	274 × 274 × 72		

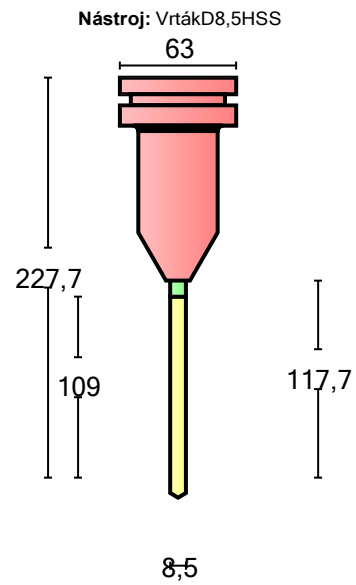


## Toolpath Limits

	X	Y	Z
Start Point	274	297	-258
Minimum	-73,957	-96,957	-30,03
Maximum	347,957	370,957	10

## Tool

Name	Vrták D8,5 HSS
Number	6
Type	Vrták
Diameter	8,5
Tip radius	
Length	109



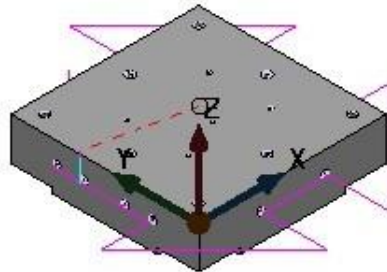
## Toolpath Notes

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<b>Project</b>	Diplomová práce - vrtací cykly 1. upnutí
<b>NC Program</b>	NC program obrabeni
<b>PowerMill Version</b>	PowerMILL 2022.000 CodeBase 2022005
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**Toolpath**

<b>Name</b>	M10_Zahloubeni		
<b>Description</b>			
<b>Strategy</b>	Zahloubeni		
<b>Tolerance</b>	0,1	<b>Cutting Feed Rate</b>	121
<b>Global Thickness</b>	0	<b>Plunge Feed Rate</b>	12
<b>Radial Thickness</b>	0	<b>Rapid Feed Rate</b>	3000
<b>Axial Thickness</b>		<b>Spindle</b>	670
<b>Stepover</b>		<b>Cutting Time</b>	0:00:14
<b>Stepdown</b>		<b>Total Time</b>	0:03:40
<b>Block</b>	274 × 274 × 72		





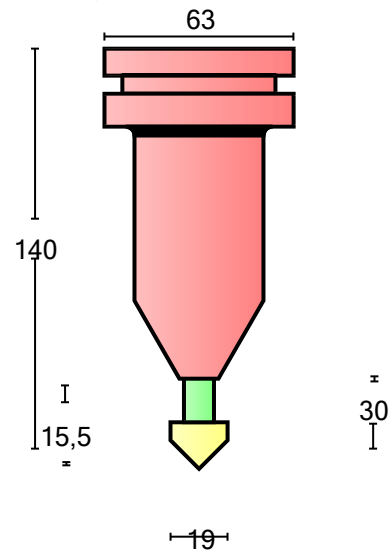
## Toolpath Limits

	X	Y	Z
Start Point	274	297	-258
Minimum	-73,992	-96,992	-30,03
Maximum	347,992	370,992	10

## Tool

Name	Kuželový záhlubník 90° pro M10
Number	7
Type	Vrták
Diameter	19
Tip radius	
Length	15,5

Nástroj: Kuželový záhlubník 90° pro M10



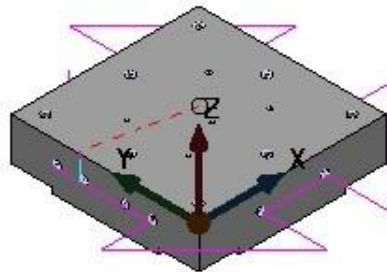
## Toolpath Notes

**PowerMill Setup Sheet**

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**Toolpath**

<b>Name</b>	M10_Závit		
<b>Description</b>			
<b>Strategy</b>	Závitování		
<b>Tolerance</b>	0,1	<b>Cutting Feed Rate</b>	570
<b>Global Thickness</b>	0	<b>Plunge Feed Rate</b>	57
<b>Radial Thickness</b>	0	<b>Rapid Feed Rate</b>	3000
<b>Axial Thickness</b>		<b>Spindle</b>	380
<b>Stepover</b>		<b>Cutting Time</b>	0:01:36
<b>Stepdown</b>		<b>Total Time</b>	0:02:50
<b>Block</b>	274 × 274 × 72		



## Toolpath Limits

	X	Y	Z
Start Point	274	297	-258
Minimum	-74,562	-97,562	-30,03
Maximum	348,562	371,562	10

## Tool

Name	ZT50100T M10 6GX	<p>Nástroj: ZT50100TM106GX</p> <p>63</p> <p>143,097</p> <p>22</p> <p>40</p> <p>10</p>
Number	8	
Type	Závitník	
Diameter	10	
Tip radius		
Length	22	

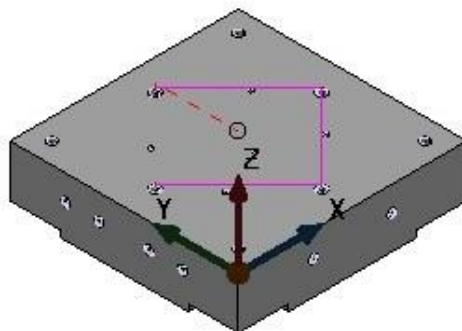
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**Toolpath**

<b>Name</b>	M12_Navrtání		
<b>Description</b>			
<b>Strategy</b>	Vrtání		
<b>Tolerance</b>	0,1	<b>Cutting Feed Rate</b>	405
<b>Global Thickness</b>	0	<b>Plunge Feed Rate</b>	40
<b>Radial Thickness</b>	0	<b>Rapid Feed Rate</b>	3000
<b>Axial Thickness</b>		<b>Spindle</b>	3183
<b>Stepover</b>		<b>Cutting Time</b>	0:00:04
<b>Stepdown</b>		<b>Total Time</b>	0:00:15
<b>Block</b>	274 × 274 × 72		

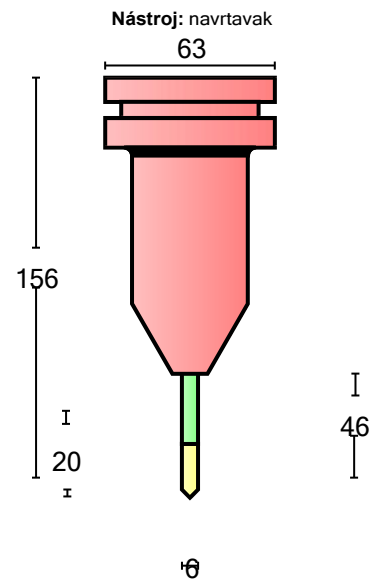


## Toolpath Limits

	X	Y	Z
Start Point	274	297	-258
Minimum	37	37	-2
Maximum	237	237	10

## Tool

Name	navrtavak
Number	4
Type	Vrták
Diameter	6
Tip radius	
Length	20



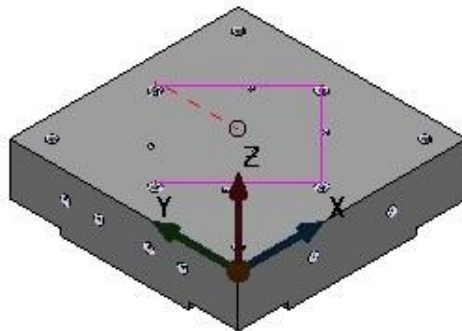
## Toolpath Notes

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**Toolpath**

<b>Name</b>	M12_Vrtání		
<b>Description</b>			
<b>Strategy</b>	Vrtání		
<b>Tolerance</b>	0,1	<b>Cutting Feed Rate</b>	405
<b>Global Thickness</b>	0	<b>Plunge Feed Rate</b>	40
<b>Radial Thickness</b>	0	<b>Rapid Feed Rate</b>	3000
<b>Axial Thickness</b>		<b>Spindle</b>	1872
<b>Stepover</b>		<b>Cutting Time</b>	0:00:20
<b>Stepdown</b>		<b>Total Time</b>	0:00:32
<b>Block</b>	274 × 274 × 72		

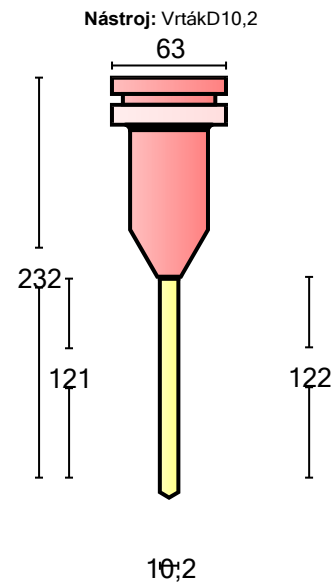


## Toolpath Limits

	X	Y	Z
Start Point	274	297	-258
Minimum	37	37	-20
Maximum	237	237	10

## Tool

Name	Vrták D10,2
Number	9
Type	Vrták
Diameter	10,2
Tip radius	
Length	121



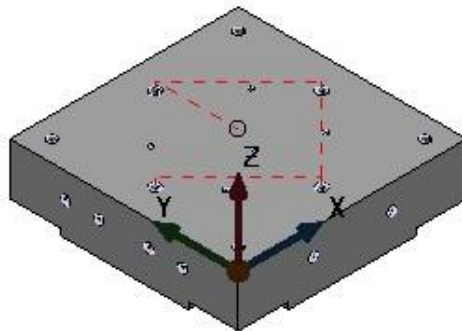
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**Toolpath**

<b>Name</b>	M12_Zahloubeni		
<b>Description</b>			
<b>Strategy</b>	Zahloubeni		
<b>Tolerance</b>	0,1	<b>Cutting Feed Rate</b>	121
<b>Global Thickness</b>	0	<b>Plunge Feed Rate</b>	12
<b>Radial Thickness</b>	0	<b>Rapid Feed Rate</b>	3000
<b>Axial Thickness</b>		<b>Spindle</b>	554
<b>Stepover</b>		<b>Cutting Time</b>	0:00:04
<b>Stepdown</b>		<b>Total Time</b>	0:00:16
<b>Block</b>	274 × 274 × 72		



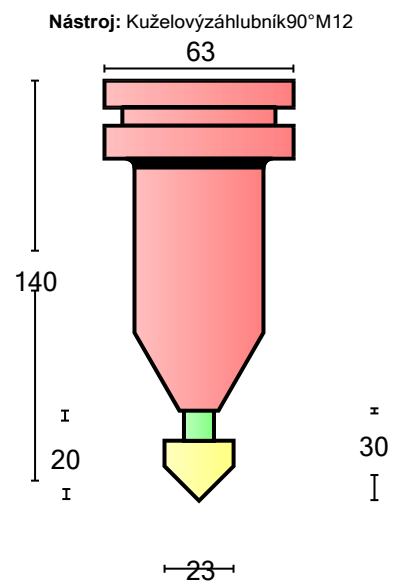


## Toolpath Limits

	X	Y	Z
Start Point	274	297	-258
Minimum	37	37	-0,5
Maximum	237	237	10

## Tool

Name	Kuželový záhlubník 90° M12
Number	10
Type	Vrták
Diameter	23
Tip radius	
Length	20



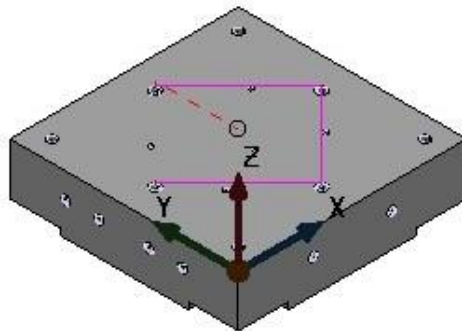
## Toolpath Notes

**PowerMill Setup Sheet**

<b>Project</b>	Diplomová práce - vrtací cykly 1. upnutí
<b>NC Program</b>	NC program obrabeni
<b>PowerMill Version</b>	PowerMILL 2022.000 CodeBase 2022005
<b>Page Generated:</b>	12:03 odp. on 2023-05-19
<b>Order Number</b>	1
<b>CAD Model</b>	C:/Users/Antonin/Desktop/TOM/Databaze/Databaze_upinek_a_upinacu/SCHUNK Kontec KSX.stl C:/Users/Antonin/Desktop/TOM/Dily na praktickou/forma.CATPart

**Toolpath**

<b>Name</b>	M12_Závit		
<b>Description</b>			
<b>Strategy</b>	Závitování		
<b>Tolerance</b>	0,1	<b>Cutting Feed Rate</b>	556,5
<b>Global Thickness</b>	0	<b>Plunge Feed Rate</b>	55,65
<b>Radial Thickness</b>	0	<b>Rapid Feed Rate</b>	3000
<b>Axial Thickness</b>		<b>Spindle</b>	318
<b>Stepover</b>		<b>Cutting Time</b>	0:00:32
<b>Stepdown</b>		<b>Total Time</b>	0:00:43
<b>Block</b>	274 × 274 × 72		



## Toolpath Limits

	X	Y	Z
Start Point	274	297	-258
Minimum	37	37	-14
Maximum	237	237	10

## Tool

Name	M12 6H HSSE 3500_1	<p>Nástroj: M126HHSSE3500_1</p>
Number	11	
Type	Závitník	
Diameter	12	
Tip radius		
Length	23	

## Toolpath Notes

**PowerMill Setup Sheet**

<b>Project</b>	Diplomová práce - vrtací cykly 1. upnutí
<b>NC Program</b>	NC program obrabeni
<b>PowerMill Version</b>	PowerMILL 2022.000 CodeBase 2022005
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**Summary sheet 1 of 4**

Toolpath / TAP File	Strategy	Tool	
D12_Navrtani C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Vrtání	Type	Vrták
		Diameter	4
		Tip radius	
		Length	20
		Number	1
D12_Vrtani C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Vrtání	Type	Vrták
		Diameter	11,8
		Tip radius	
		Length	66,2
		Number	2
D12_Vystružení C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Stružení	Type	Vrták
		Diameter	12
		Tip radius	
		Length	44
		Number	3
D6_navrtání C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Vrtání	Type	Vrták
		Diameter	6
		Tip radius	
		Length	20
		Number	4

**PowerMill Setup Sheet**

<b>Project</b>	Diplomová práce - vrtací cykly 1. upnutí
<b>NC Program</b>	NC program obrabeni
<b>PowerMill Version</b>	PowerMILL 2022.000 CodeBase 2022005
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**Summary sheet 2 of 4**

Toolpath / TAP File	Strategy	Tool	
D6_vrtání C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Vrtání	Type	Vrták
		Diameter	6
		Tip radius	
		Length	42,1
		Number	5
M10_Navrtání C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Vrtání	Type	Vrták
		Diameter	6
		Tip radius	
		Length	20
M10_Vrtání C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Vrtání	Type	Vrták
		Diameter	8,5
		Tip radius	
		Length	109
M10_Zahloubení C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Zahloubení	Number	6
		Type	Vrták
		Diameter	19
		Tip radius	
		Length	15,5
		Number	7

**PowerMill Setup Sheet**

<b>Project</b>	Diplomová práce - vrtací cykly 1. upnutí
<b>NC Program</b>	NC program obrabeni
<b>PowerMill Version</b>	PowerMILL 2022.000 CodeBase 2022005
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**Summary sheet 3 of 4**

Toolpath / TAP File	Strategy	Tool	
M10_Závit C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Závitování	Type	Závitník
		Diameter	10
		Tip radius	
		Length	22
		Number	8
M12_Navrtání C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Vrtání	Type	Vrták
		Diameter	6
		Tip radius	
		Length	20
		Number	4

**PowerMill Setup Sheet**

<b>Project</b>	Diplomová práce - vrtací cykly 1. upnutí
<b>NC Program</b>	NC program obrabeni
<b>PowerMill Version</b>	PowerMILL 2022.000 CodeBase 2022005
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**Summary sheet 4 of 4**

Toolpath / TAP File	Strategy	Tool	
M12_Vrtání C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Vrtání	Type	Vrták
		Diameter	10,2
		Tip radius	
		Length	121
		Number	9
M12_Zahloubení C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Zahloubení	Type	Vrták
		Diameter	23
		Tip radius	
		Length	20
		Number	10
M12_Závit C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Závitování	Type	Závitník
		Diameter	12
		Tip radius	
		Length	23
		Number	11