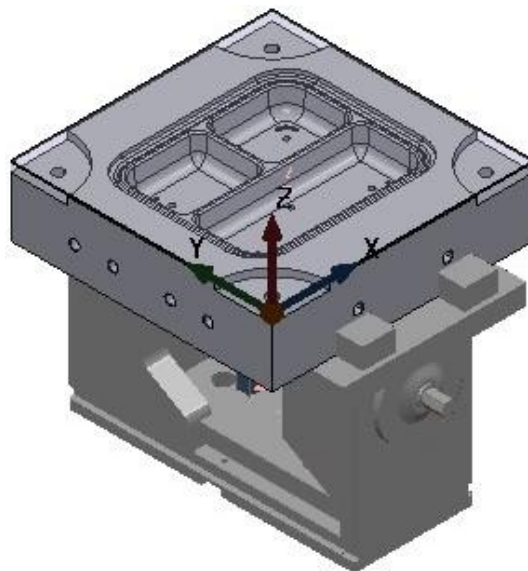


PowerMill Setup Sheet

Project	Diplomová práce - 2.upnutí
PowerMill Version	PowerMILL 2022.000 CodeBase 2022005
Page Generated:	10:08 dop. on 2023-05-22

NC Program NC program obrábění

Customer	Diplomová práce
Part Name	Forma 2. upnutí
Order Number	2
CAD Model	C:/Users/Antonin/Desktop/TOM/Díly na praktickou/forma.CATPart C:/Users/Antonin/Desktop/TOM/Databaze/Databaze_upinek_a_upinacu/SCHUNK Kontec K SX.stl
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	6:16:57
Total Time For NC Program	10:47:41


NC Program Notes

Materiál obrobku: Hliník - slévárenská litina - ≤ 12% Si, kalitelná - zakalená - 300N/mm² / 90 HB

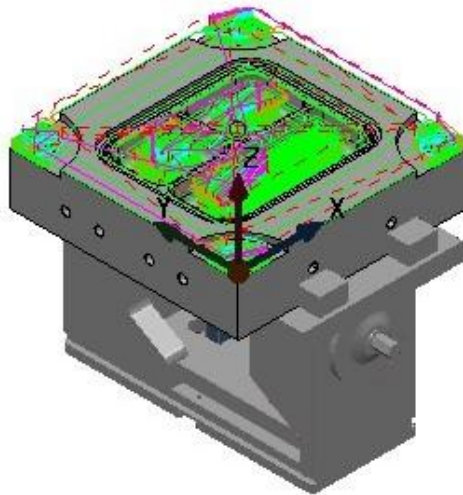
Všechny využitě nástroje v projektu mají navoleny řezné podmínky dle materiálu obrobku.

PowerMill Setup Sheet

Project	Diplomová práce-2.upnutí finall
NC Program	NC program obrabeni
PowerMill Version	PowerMILL 2022.000 CodeBase 2022005
Page Generated:	10:08 dop. on 2023-05-22
Order Number	2
CAD Model	C:/Users/Antonin/Desktop/TOM/Díly na praktickou/forma.CATPart C:/Users/Antonin/Desktop/TOM/Databaze/Databaze_upinek_a_upinacu/SCHUNK Kontec KSX.stl

Toolpath

Name	Hrubovani		
Description	Nástroj: Fréza s VBD z materiálu F40M		
Strategy	Hrubování konturováním		
Tolerance	0,1	Cutting Feed Rate	10914
Global Thickness	1	Plunge Feed Rate	1091
Radial Thickness	1	Rapid Feed Rate	3000
Axial Thickness		Spindle	5457
Stepover	26,25	Cutting Time	0:02:37
Stepdown	2	Total Time	0:09:20
Block	274 × 274 × 72		

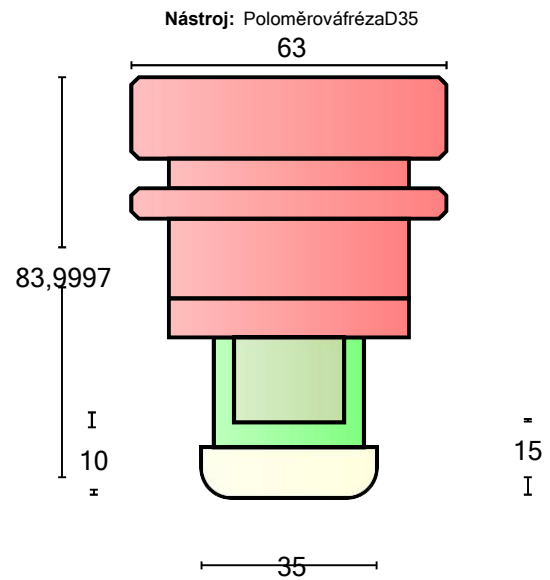


Toolpath Limits

	X	Y	Z
Start Point	274	297	-258
Minimum	0	0	-31
Maximum	274	274	10

Tool

Name	Poloměrová fréza D 35
Number	1
Type	Poloměrová fréza
Diameter	35
Tip radius	6
Length	10



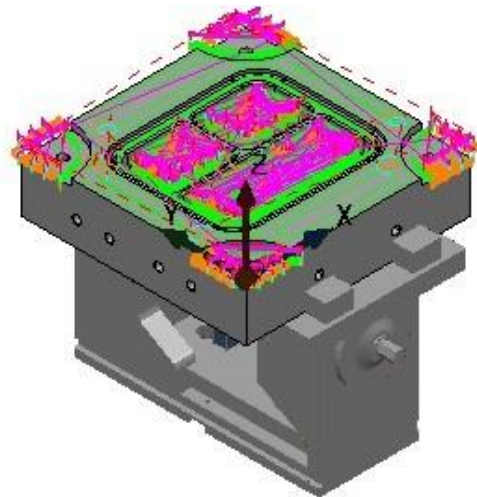
Toolpath Notes

PowerMill Setup Sheet

Project	Diplomová práce-2.upnutí finall
NC Program	NC program obrabeni
PowerMill Version	PowerMILL 2022.000 CodeBase 2022005
Page Generated:	10:08 dop. on 2023-05-22
Order Number	2
CAD Model	C:/Users/Antonin/Desktop/TOM/Díly na praktickou/forma.CATPart C:/Users/Antonin/Desktop/TOM/Databaze/Databaze_upinek_a_upinacu/SCHUNK Kontec KSX.stl

Toolpath

Name	Zbytkove hrubovani		
Description	Nástroj: HSS		
Strategy	Hrubování konturováním		
Tolerance	0,1	Cutting Feed Rate	382
Global Thickness	0,3	Plunge Feed Rate	38
Radial Thickness	0,3	Rapid Feed Rate	4000
Axial Thickness		Spindle	1592
Stepover	15	Cutting Time	1:50:38
Stepdown	2	Total Time	4:32:11
Block	274 × 274 × 72		

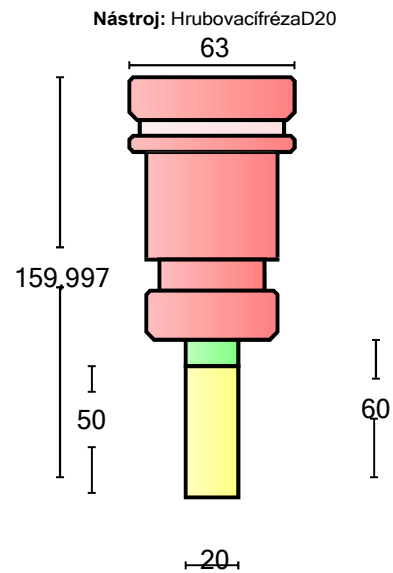


Toolpath Limits

	X	Y	Z
Start Point	143,195	153,27	-258
Minimum	-10,794	-10,794	-31,7
Maximum	284,794	284,794	10

Tool

Name	Hrubovací fréza D20
Number	2
Type	Válcová fréza
Diameter	20
Tip radius	0
Length	50



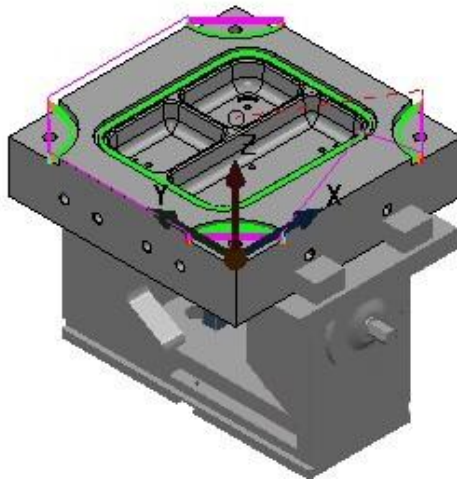
Toolpath Notes

PowerMill Setup Sheet

Project	Diplomová práce-2.upnutí finall
NC Program	NC program obrabeni
PowerMill Version	PowerMILL 2022.000 CodeBase 2022005
Page Generated:	10:08 dop. on 2023-05-22
Order Number	2
CAD Model	C:/Users/Antonin/Desktop/TOM/Díly na praktickou/forma.CATPart C:/Users/Antonin/Desktop/TOM/Databaze/Databaze_upinek_a_upinacu/SCHUNK Kontec KSX.stl

Toolpath

Name	Dokonceni v Z		
Description	Nástroj: HSS		
Strategy	Hladina Z		
Tolerance	0,005	Cutting Feed Rate	1019
Global Thickness	0	Plunge Feed Rate	102
Radial Thickness	0	Rapid Feed Rate	3000
Axial Thickness		Spindle	5305
Stepover		Cutting Time	0:08:13
Stepdown	0,8	Total Time	0:12:19
Block	274 × 274 × 72		

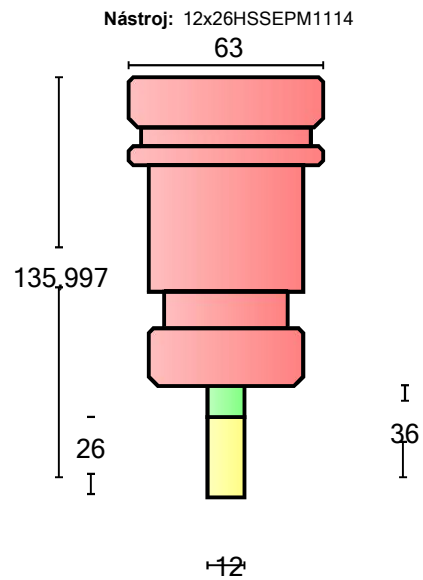


Toolpath Limits

	X	Y	Z
Start Point	274	297	-258
Minimum	-4,995	-4,995	-10
Maximum	278,995	278,995	10

Tool

Name	12x26 HSSE PM 1114
Number	3
Type	Válcová fréza
Diameter	12
Tip radius	0
Length	26



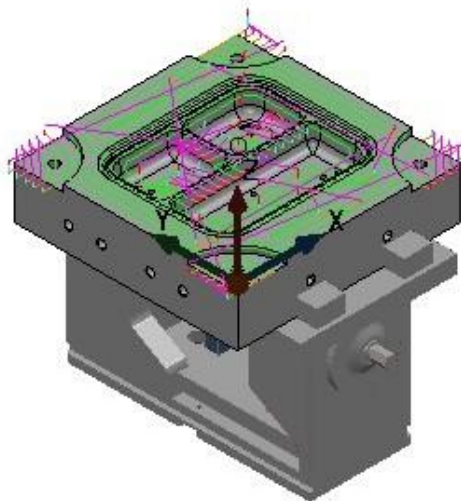
Toolpath Notes

PowerMill Setup Sheet

Project	Diplomová práce-2.upnutí finall
NC Program	NC program obrabeni
PowerMill Version	PowerMILL 2022.000 CodeBase 2022005
Page Generated:	10:08 dop. on 2023-05-22
Order Number	2
CAD Model	C:/Users/Antonin/Desktop/TOM/Díly na praktickou/forma.CATPart C:/Users/Antonin/Desktop/TOM/Databaze/Databaze_upinek_a_upinacu/SCHUNK Kontec K SX.stl

Toolpath

Name	Dokonceni rovin		
Description	Nástroj: HSS		
Strategy	Plošný offset		
Tolerance	0,005	Cutting Feed Rate	509
Global Thickness	0	Plunge Feed Rate	51
Radial Thickness	0	Rapid Feed Rate	3000
Axial Thickness		Spindle	2546
Stepover	10	Cutting Time	0:14:14
Stepdown		Total Time	0:22:30
Block	274 × 274 × 72		

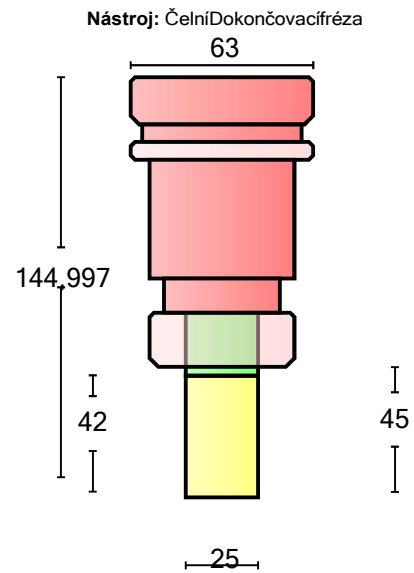


Toolpath Limits

	X	Y	Z
Start Point	274	297	-258
Minimum	-13,188	-9,992	-32
Maximum	287,188	283,992	10

Tool

Name	Čelní Dokončovací fréza
Number	4
Type	Válcová fréza
Diameter	25
Tip radius	0
Length	42



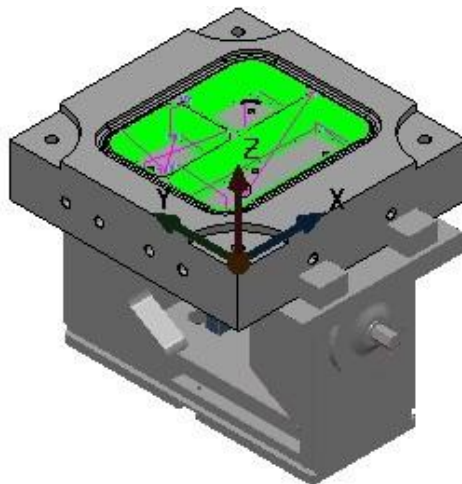
Toolpath Notes

PowerMill Setup Sheet

Project	Diplomová práce-2.upnutí finall
NC Program	NC program obrabeni
PowerMill Version	PowerMILL 2022.000 CodeBase 2022005
Page Generated:	10:08 dop. on 2023-05-22
Order Number	2
CAD Model	C:/Users/Antonin/Desktop/TOM/Díly na praktickou/forma.CATPart C:/Users/Antonin/Desktop/TOM/Databaze/Databaze_upinek_a_upinacu/SCHUNK Kontec K SX.stl

Toolpath

Name	Dokonceni strme a plosne		
Description	Nástroj: HSS		
Strategy	Strmé a plošné		
Tolerance	0,005	Cutting Feed Rate	1019
Global Thickness	0	Plunge Feed Rate	102
Radial Thickness	0	Rapid Feed Rate	3000
Axial Thickness		Spindle	6366
Stepover	0,2	Cutting Time	2:20:01
Stepdown		Total Time	2:22:27
Block	274 × 274 × 72		

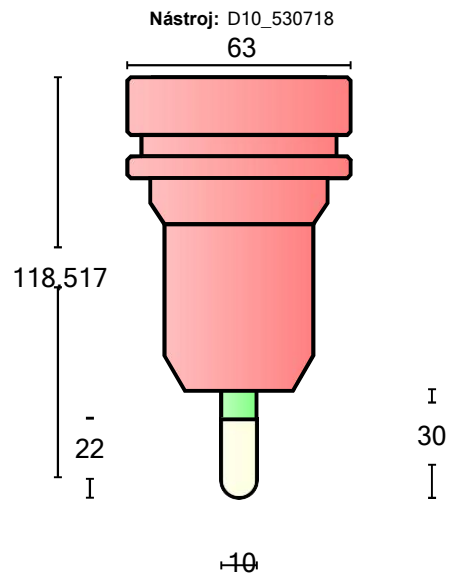


Toolpath Limits

	X	Y	Z
Start Point	205,421	222,036	-258
Minimum	45,52	60,538	-32
Maximum	228,48	213,479	10

Tool

Name	D10_530718
Number	5
Type	Kulová fréza
Diameter	10
Tip radius	5
Length	22



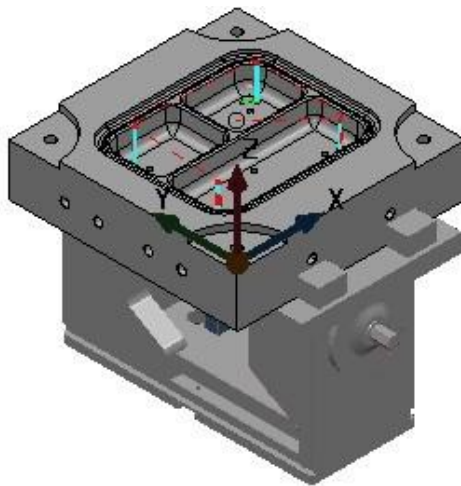
Toolpath Notes

PowerMill Setup Sheet

Project	Diplomová práce-2.upnutí finall
NC Program	NC program obrabeni
PowerMill Version	PowerMILL 2022.000 CodeBase 2022005
Page Generated:	10:08 dop. on 2023-05-22
Order Number	2
CAD Model	C:/Users/Antonin/Desktop/TOM/Díly na praktickou/forma.CATPart C:/Users/Antonin/Desktop/TOM/Databaze/Databaze_upinek_a_upinacu/SCHUNK Kontec KSX.stl

Toolpath

Name	Dokončení prvku		
Description	Nástroj: HSS		
Strategy	Dokončení prvku		
Tolerance	0,005	Cutting Feed Rate	509
Global Thickness	0	Plunge Feed Rate	51
Radial Thickness	0	Rapid Feed Rate	3000
Axial Thickness		Spindle	31831
Stepover	0,1	Cutting Time	0:23:41
Stepdown	0,04	Total Time	1:42:07
Block	274 × 274 × 72		

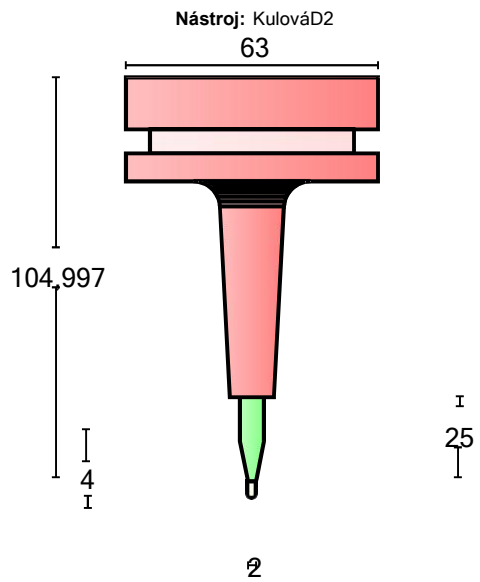


Toolpath Limits

	X	Y	Z
Start Point	274	297	-258
Minimum	62,068	77,068	-33
Maximum	211,932	196,932	10

Tool

Name	Kulová D2
Number	6
Type	Kulová fréza
Diameter	2
Tip radius	1
Length	4



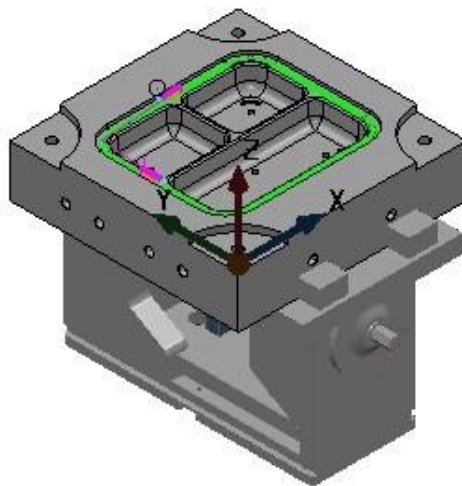
Toolpath Notes

PowerMill Setup Sheet

Project	Diplomová práce-2.upnutí finall
NC Program	NC program obrabeni
PowerMill Version	PowerMILL 2022.000 CodeBase 2022005
Page Generated:	10:08 dop. on 2023-05-22
Order Number	2
CAD Model	C:/Users/Antonin/Desktop/TOM/Díly na praktickou/forma.CATPart C:/Users/Antonin/Desktop/TOM/Databaze/Databaze_upinek_a_upinacu/SCHUNK Kontec K SX.stl

Toolpath

Name	Dokonceni mezi krivky		
Description	Nástroj: HSS		
Strategy	Mezi dvě křivky		
Tolerance	0,005	Cutting Feed Rate	232
Global Thickness	0	Plunge Feed Rate	23
Radial Thickness	0	Rapid Feed Rate	3000
Axial Thickness		Spindle	8594
Stepover	0,3	Cutting Time	1:17:29
Stepdown		Total Time	1:26:44
Block	274 × 274 × 72		

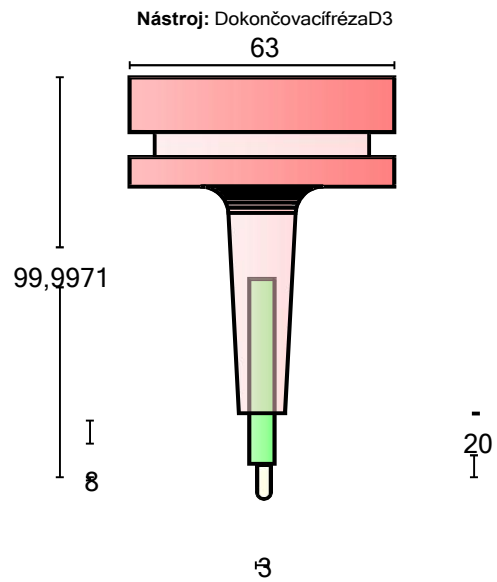


Toolpath Limits

	X	Y	Z
Start Point	261,498	380,932	-258
Minimum	38,002	53	-7,982
Maximum	236	220,996	10

Tool

Name	Dokončovací fréza D3
Number	7
Type	Kulová fréza
Diameter	3
Tip radius	1,5
Length	8



Toolpath Notes

PowerMill Setup Sheet

Project	Diplomová práce-2.upnutí finall
NC Program	NC program obrabeni
PowerMill Version	PowerMILL 2022.000 CodeBase 2022005
Page Generated:	10:08 dop. on 2023-05-22

Summary sheet 1 of 2

Toolpath / TAP File	Strategy	Tool	
Hrubovani C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Hrubování konturováním	Type	Poloměrová fréza
		Diameter	35
		Tip radius	6
		Length	10
		Number	1
Zbytkove hrubovani C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Hrubování konturováním	Type	Válcová fréza
		Diameter	20
		Tip radius	0
		Length	50
		Number	2
Dokonceni v Z C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Hladina Z	Type	Válcová fréza
		Diameter	12
		Tip radius	0
		Length	26
		Number	3
Dokonceni rovin C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Plošný offset	Type	Válcová fréza
		Diameter	25
		Tip radius	0
		Length	42
		Number	4

PowerMill Setup Sheet

Project	Diplomová práce-2.upnutí finall
NC Program	NC program obrabeni
PowerMill Version	PowerMILL 2022.000 CodeBase 2022005
Page Generated:	10:08 dop. on 2023-05-22

Summary sheet 2 of 2

Toolpath / TAP File	Strategy	Tool	
Dokonceni strme a plosne C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Strmé a plošné	Type	Kulová fréza
		Diameter	10
		Tip radius	5
		Length	22
		Number	5
Dokonceni prvku C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Dokončení prvku	Type	Kulová fréza
		Diameter	2
		Tip radius	1
		Length	4
		Number	6
Dokonceni mezi krivky C:/Users/Antonin/Desktop/TOM/NCprogramy/NC program obrabeni.tap	Mezi dvě křivky	Type	Kulová fréza
		Diameter	3
		Tip radius	1,5
		Length	8
		Number	7