

Setup Sheet Installation & Customization Guide

Covers file installation, report template configuration, general information setup, and toolpath display options for custom MachiningPartner setup sheets.

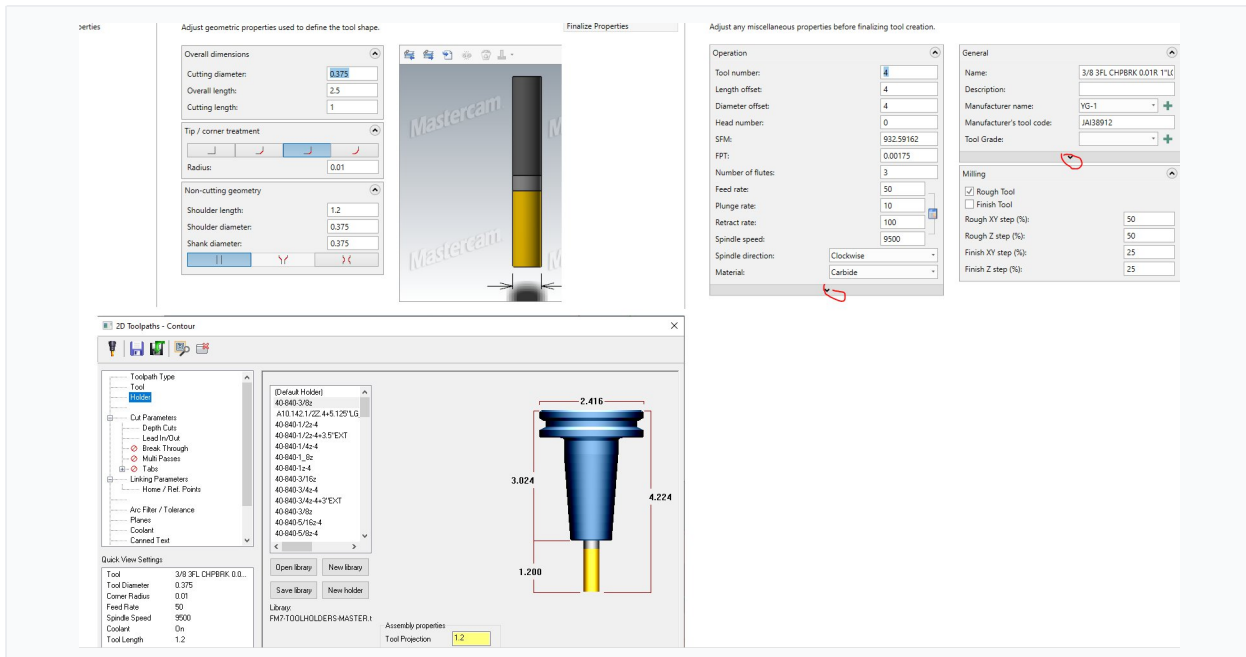
DOCUMENT	Installing & Creating Custom Setup Sheets
INCLUDES	Custom Tool List Files
AUTHOR	MachiningPartner.com
APPLICATION	Mastercam

Overview

These custom setup sheets are auto-generated and serve as a supplemental workbook for first runs. They allow you to quickly generate tool lists and toolpaths for setup sheets. Machinists particularly value the chronological toolpath information, which helps them follow the program and improve communication with programming.

IMPORTANT

Mastercam tool data and cutting parameters must be accurately completed before generating setup sheets. The software pulls tool data directly from Mastercam. See the sample tool and holder below.



▲ Figure 1 — Sample tool and holder in Mastercam

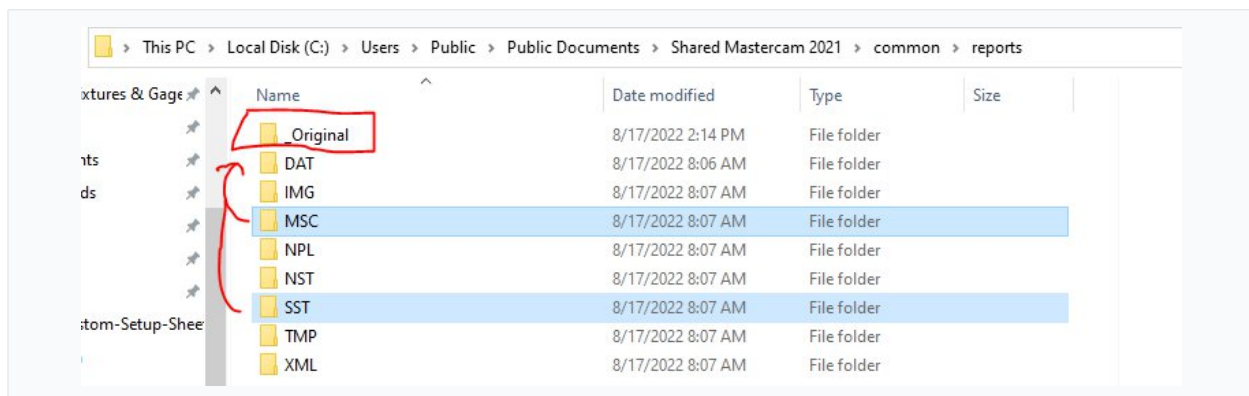
Step 1 — Back Up Original Files

Even though our files will not overwrite any default files its always good idea before making any changes, create a backup of the original report folders. This lets you restore the defaults if needed. (Mastercam 2024 but works in others, simply replace the version with your)

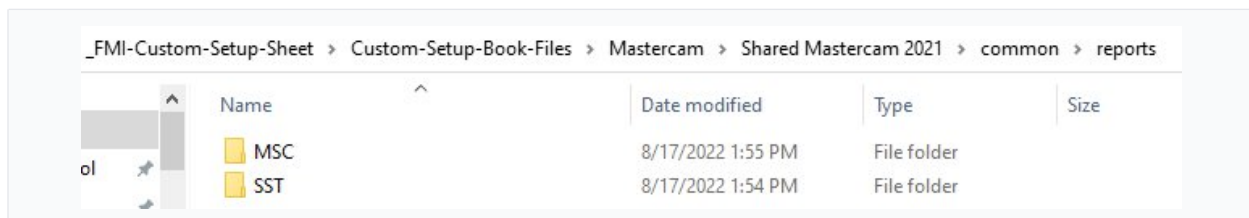
FOLDERS TO BACK UP

C:\Users\Public\Documents\Shared Mastercam 2024\common\reports

Copy both the **SST** and **MSC** folders from the path above into a new folder — for example, name it **Original** — you may choose to keep copy outside the Mastercam folder aswell. Our files are named different than defaults thus will not overwrite anything but its always good idea to have backups.



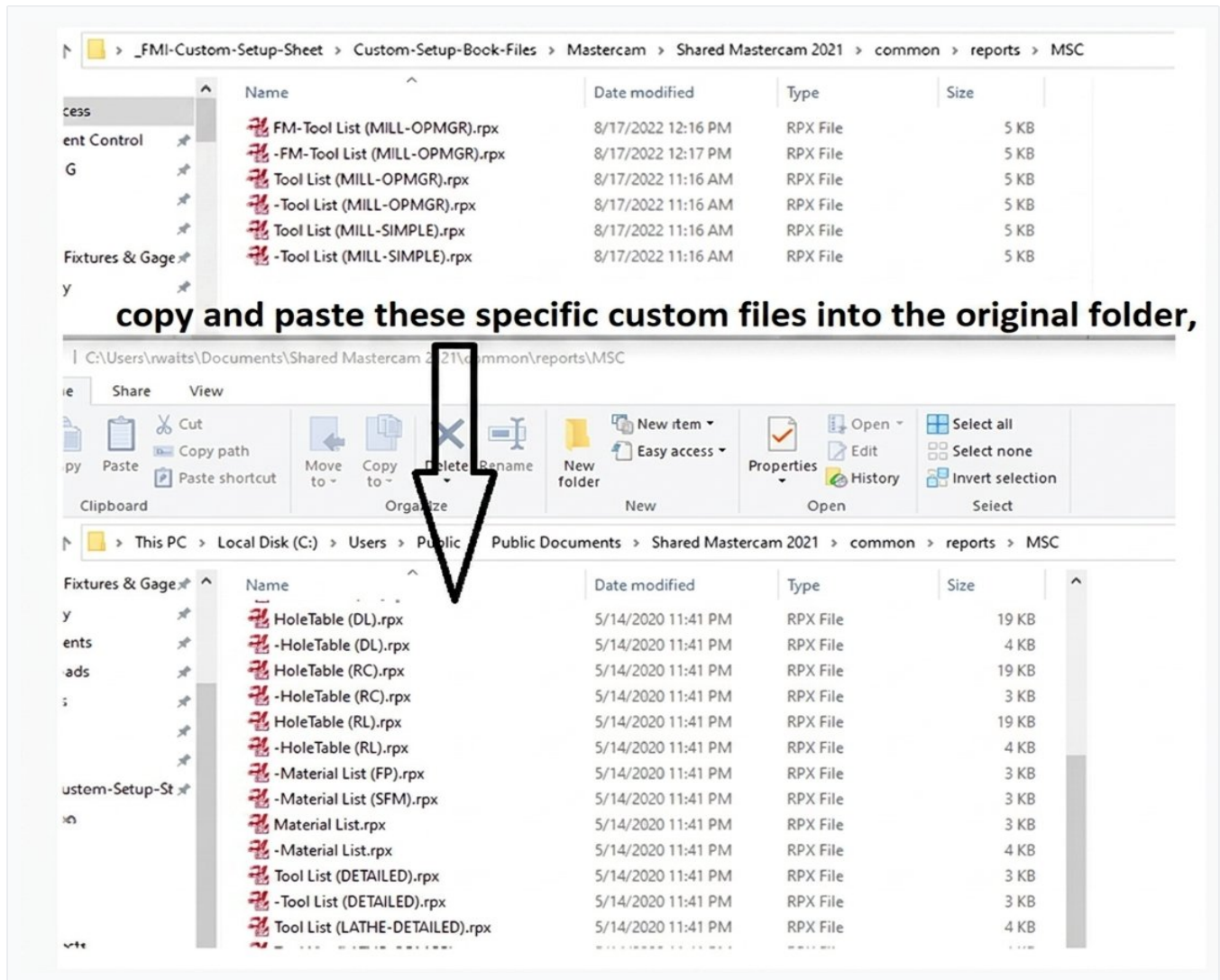
▲ Figure 2 — SST and MSC folders to back up



▲ Figure 3 — Reports folder path in Windows Explorer

Step 2 — Install Custom Files

Save the attached ZIP folder locally and extract it (the desktop works well). The extracted folder contains subfolders that mirror the original Mastercam file path structure.



▲ Figure 4 — Custom folder structure after extraction

COPY MSC FILES TO

C:\Users\Public\Documents\Shared Mastercam 2024\common\reports\MSC

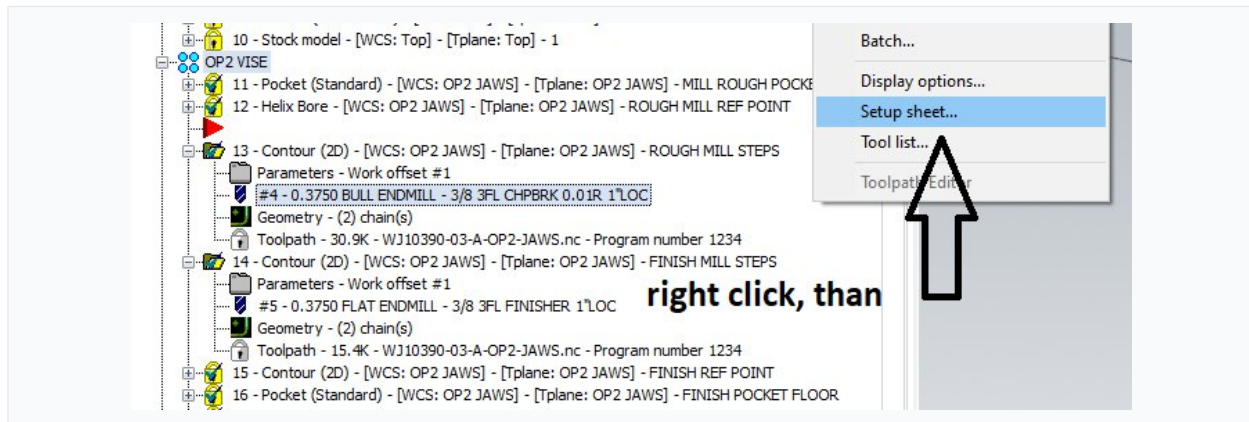
COPY SST FILES TO

C:\Users\Public\Documents\Shared Mastercam 2024\common\reports\SST

(Mastercam 2024 but works in others, simply replace the version with your)

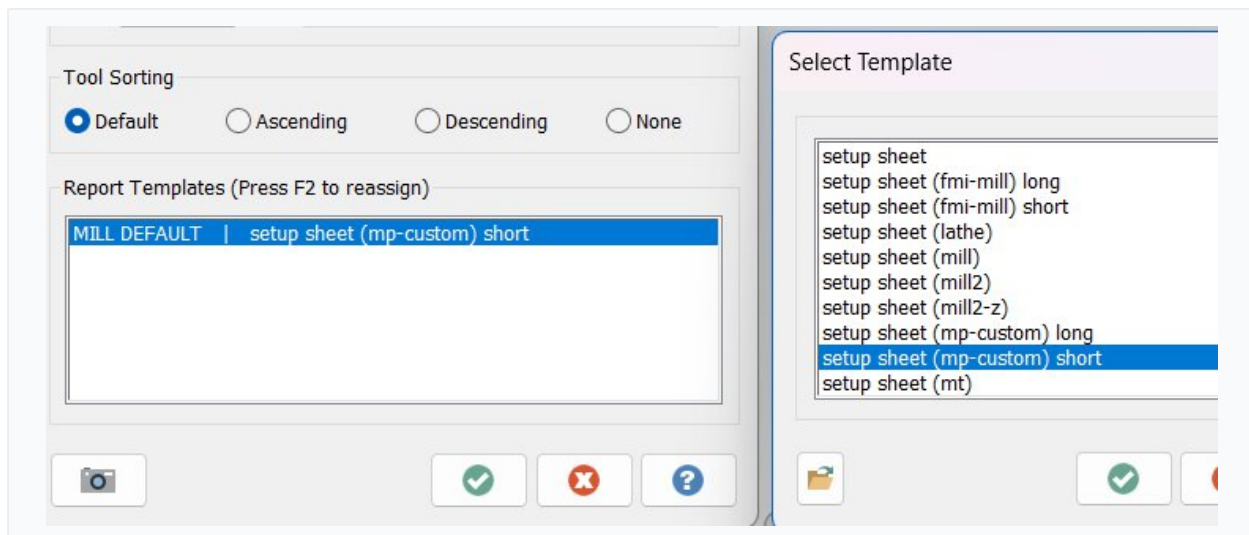
Step 3 — Select the Setup Sheet in Mastercam

In Mastercam, right-click the toolpath menu (as you would when creating a tool list) and select "Setup Sheet" this time.



▲ Figure 5 — Right-click toolpath menu, select Setup Sheet

Double-click the report name under Report Template. When the pop-up appears, choose "(mp-custom) short" or "(mp-custom)long". You may need to navigate to your custom sheets the first time.



▲ Figure 6 — Selecting the MachiningPartner report template

Step 4 — Choose Your Template Version

Two template versions are available — the difference is in how toolpath information is displayed:

Regular

Prints the complete Mastercam setup book. Ideal for detailed feedback when proving out new jobs.

Short

Designed for snipping the toolpath section and integrating into the setup workbook. Used for first-run setup books.

WJ10390-03-A-OP2-JAWS.NCI

TOTAL CYCLE TIME:

0 HOURS, 6 MINUTES, 10 SECONDS

OPERATION LIST

ID#	TOOL #	DESCRIPTION OF OPERATION											
11	13	MILL ROUGH POCKET											
CYCLE	FEEDRATE	SPINDLE	DEPTH	RETRACT	STOCK LEFT WALLS/FLOOR	TIP CO							
00:03:36	50.0 inch/min	10000 RPM	-0.3	0.2	0.01	YES							
MACHINIST FEEDBACK													

ID#	TOOL #	DESCRIPTION OF OPERATION											
12	13	ROUGH MILL REF POINT											
CYCLE	FEEDRATE	SPINDLE	DEPTH	RETRACT	STOCK LEFT WALLS/FLOOR	TIP CO							
00:00:06	30.0 inch/min	10000 RPM	-0.2	0.2	0.01	YES							
MACHINIST FEEDBACK													

ID#	TOOL #	DESCRIPTION OF OPERATION											
13	4	ROUGH MILL STEPS											
CYCLE	FEEDRATE	SPINDLE	DEPTH	RETRACT	STOCK LEFT WALLS/FLOOR	TIP CO							

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ID	T#	OPERATION DESCRIPTION	D	H	RPM	FEED
11	13	MILL ROUGH POCKET			10000 RPM	50.0 inch/min
12	13	ROUGH MILL REF POINT			10000 RPM	30.0 inch/min
13	4	ROUGH MILL STEPS			9500 RPM	50.0 inch/min
14	5	FINISH MILL STEPS			9500 RPM	50.0 inch/min
15	14	FINISH REF POINT			10000 RPM	50.0 inch/min
16	14	FINISH POCKET FLOOR			10000 RPM	50.0 inch/min
17	14	FINISH POCKET WALLS			10000 RPM	50.0 inch/min
18	6	CHAMFER			10000 RPM	50.0 inch/min
19	15	SPOT 1/4-20			3500 RPM	25.0 inch/min
20	16	DRILL 1/4-20			4500 RPM	20.0 inch/min
21	17	TAP 1/4-20			400 RPM	20.0 inch/min

SHORT

REGULAR

REGULAR

▲ Figure 7 — Regular (left) vs Short (right) toolpath display

NOTE

See the file "Sample-Setupsheet-WJ10390-03-A.xlsx" for an example of how the Short toolpath output integrates into the setup workbook. (optional, may not be included)

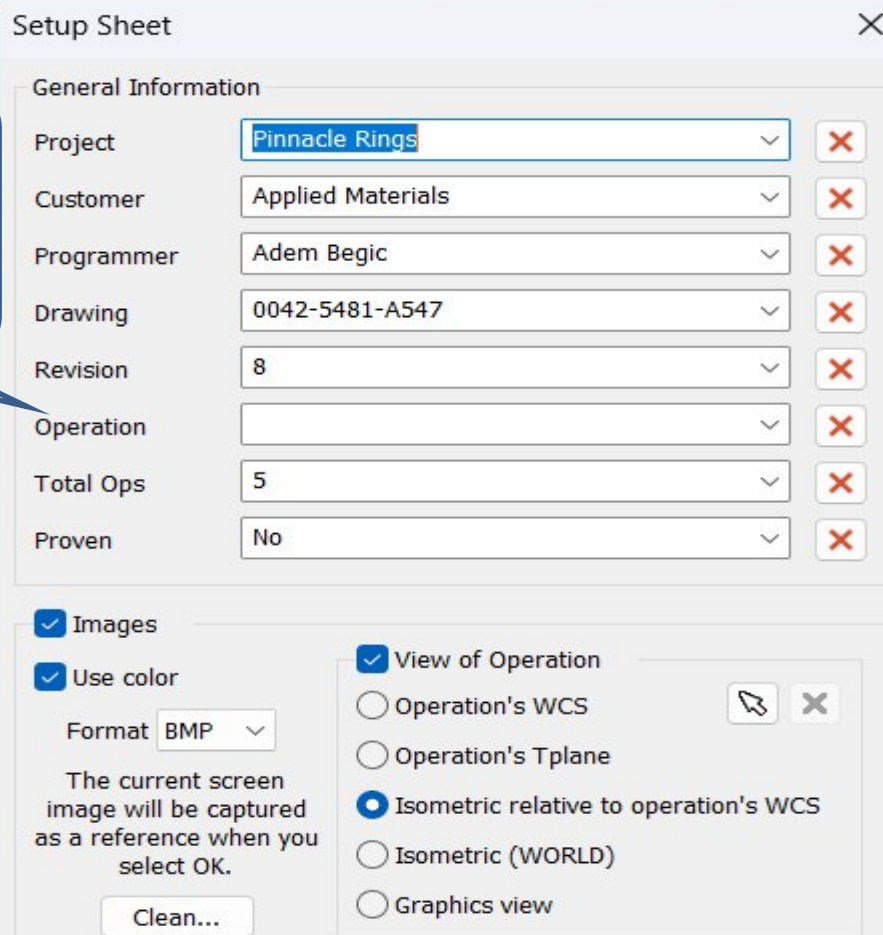
Step 5 — Modify General Information Titles

Customize the General Information field titles to match your shop's terminology. You only need to do this once — after that, simply update the right-hand values per job.

NOTE

To edit a title: click on the text, type your changes, then press Enter to confirm.

Double click to edit field title.



The screenshot shows the 'Setup Sheet' dialog box with the 'General Information' tab selected. The fields are as follows:

Field	Value	Edit Icon
Project	Pinnacle Rings	✕
Customer	Applied Materials	✕
Programmer	Adem Begic	✕
Drawing	0042-5481-A547	✕
Revision	8	✕
Operation		✕
Total Ops	5	✕
Proven	No	✕

Below the fields, there are two sections of options:

- Images:**
 - ☒ Images
 - ☒ Use color
 - Format: BMP
 - The current screen image will be captured as a reference when you select OK.
 - Clean...
- View of Operation:**
 - ☒ View of Operation
 - ☐ Operation's WCS
 - ☐ Operation's Tplane
 - ☒ Isometric relative to operation's WCS
 - ☐ Isometric (WORLD)
 - ☐ Graphics view

▲ Figure 8 — General Information titles configuration