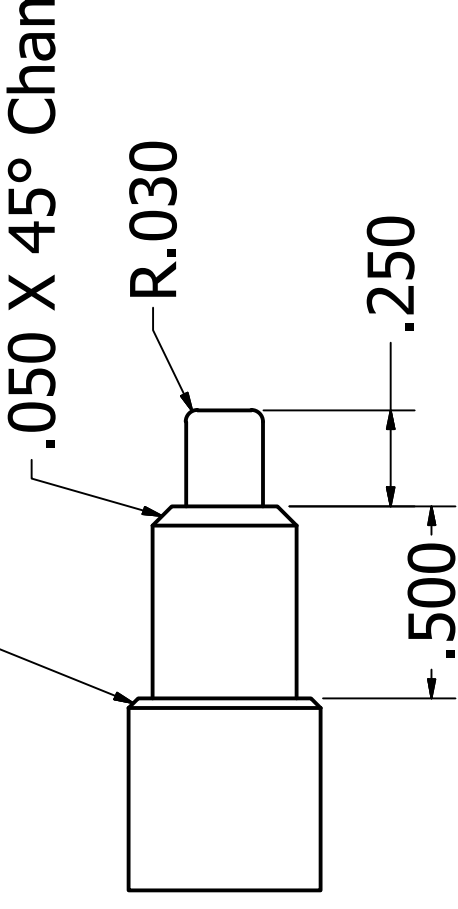
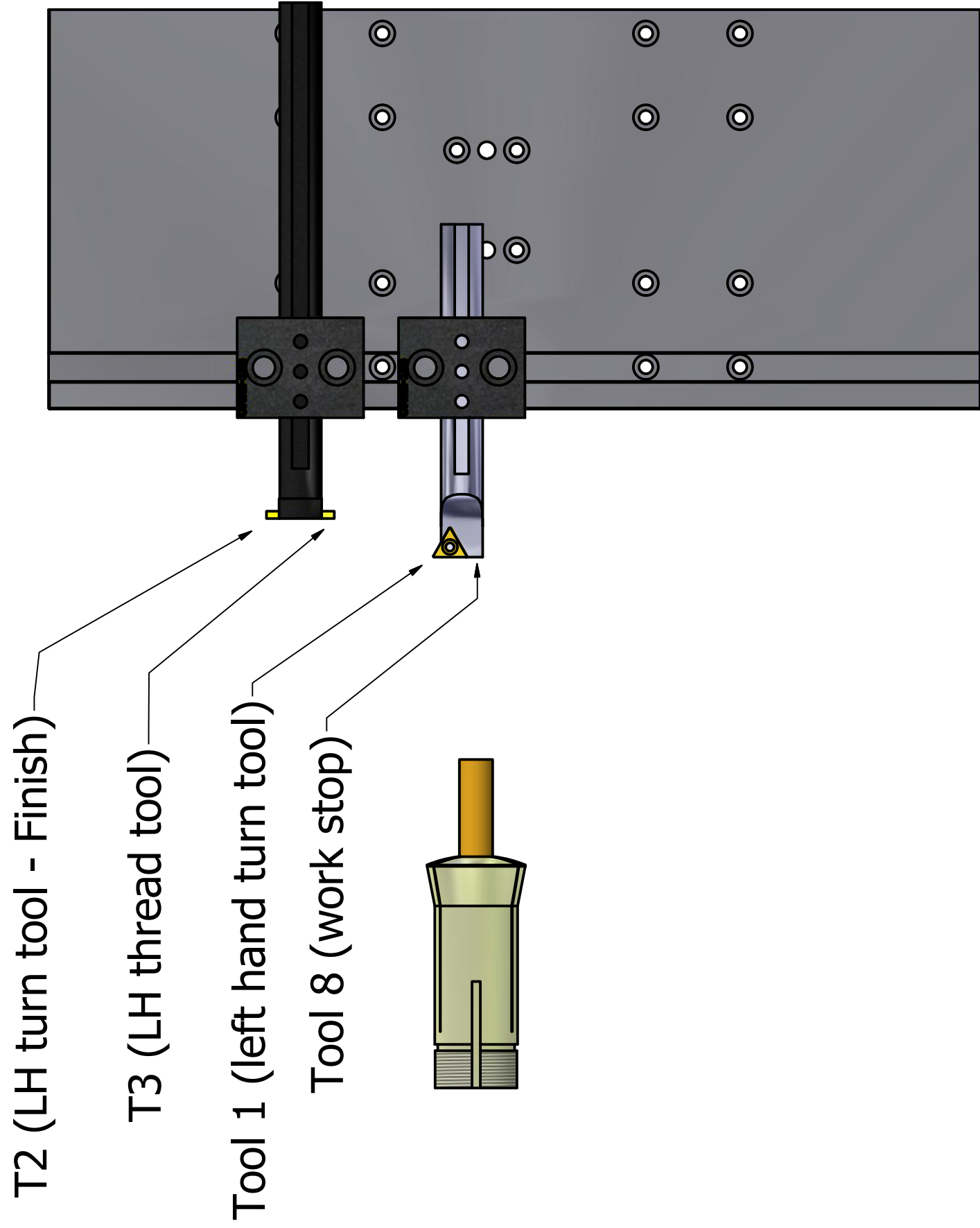


Topic: Repeat basic programming example
 Topic: Single point threading
 Topic: Tools on the (-) side of the spindle



Sample 3 Process:

Use the front of the tool as a work stop
 T8, stop motion, pull part to stop, close collet

Use T1 (LH turn tool) to rough the part as shown
 Leave .01 to clean up on a finish pass

Use T2 (LH turn tool - finish)
 perform a cleanup pass with the chamfers and radius

Sample 3

Sample 4 Process:

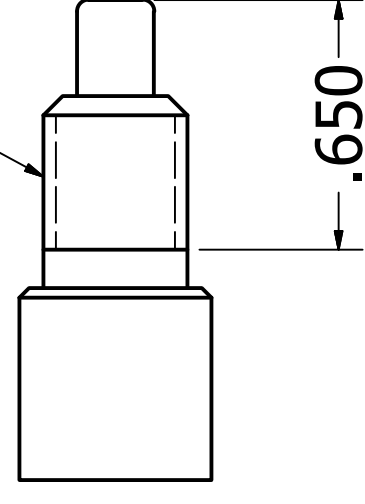
Use the front of the tool as a work stop
 T8, stop motion, pull part to stop, close collet

Use T1 (LH turn tool) to rough the part as shown
 Leave .01 to clean up on a finish pass

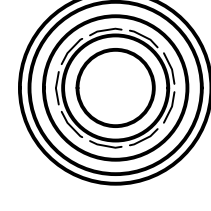
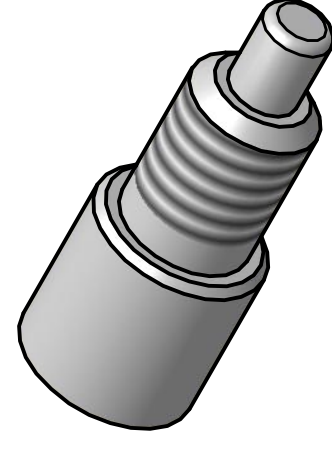
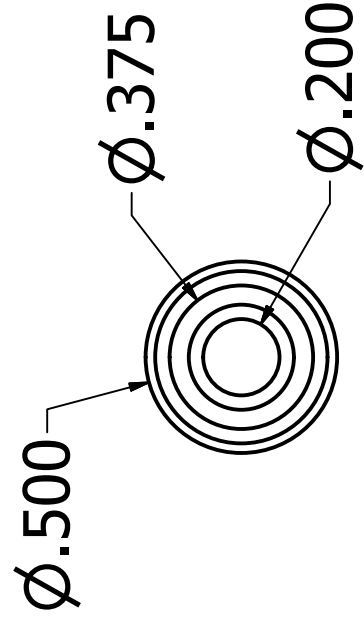
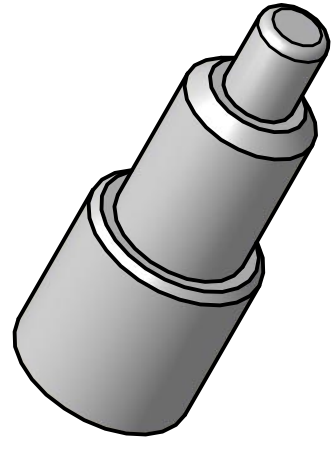
Use T2 (LH turn tool - finish)
 perform a cleanup pass with the chamfers and radius

Use T3 (LH thread tool) to thread OD
 Major diameter .375, minor diameter .298

3/8-16 UNC - 2A



Sample 4



DRAWN JRichlin	3/17/2010	Richlin Machinery Inc Engineered - To - Order
TITLE		
Part #3 and Part #4		
Material:	SIZE C	REV DWG NO OmniTurn Training
SHEET 3 OF 11		A

G90G72G94F300 (PART-3)
G10X0Z2
T8(WORK STOP)
X0Z2
Z.2
F50Z.01
M00 (PULL PART TO STOP)
M12
Z2F300
M03S1500
M08
T1(LH TURN TOOL - rough)
X.6Z2
Z0
G95F.003X-.015
X.22F.01
Z-.24F.003
X.395
Z-.74
X.6
G94F300Z2
T2(LH TURN TOOL - finish)
X.2Z2
Z.2
G95F.003
Z-.25F.003
X.375C.05
Z-.75
X.6C.075
Z-.95
G94F300Z2
M30

G90G72G94F300 (PART-4)
G10X0Z2
T8(WORK STOP)
X0Z2
Z.2
F50Z.01
M00 (PULL PART TO STOP)
M12
Z2F300
M03S1500
M08
T1(LH TURN TOOL - rough)
X.6Z2
Z0
G95F.003X-.015
X.22F.01
Z-.24F.003
X.395
Z-.74
X.6
G94F300Z2
T2(LH TURN TOOL - finish)
X.2Z2
Z.2
G95F.003
Z-.25F.003
X.375C.05
Z-.75
X.6C.075
Z-.95
G94F300Z2
T3 (THREADING TOOL)
X-.365Z2
Z.2
G95
G33X-.298Z-.65K.0625I.03C
M30