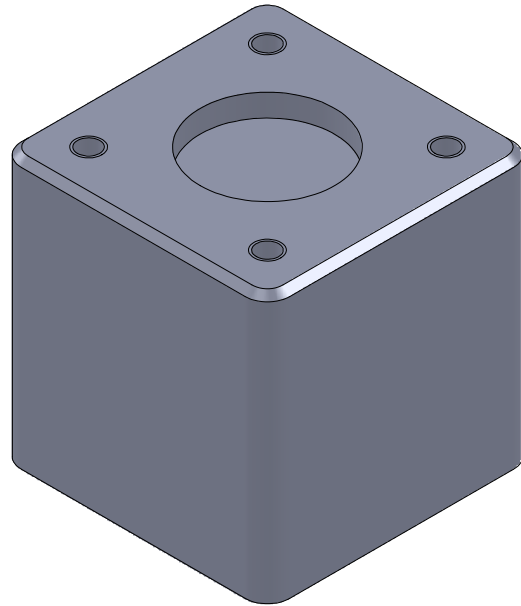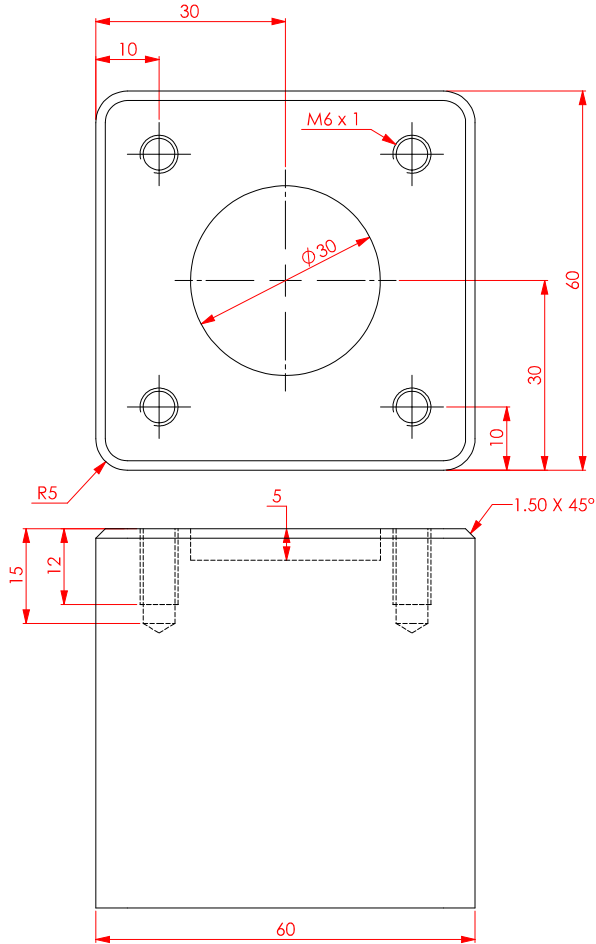# Classwork-3.1

Student Name: _____   **Grade:** $\dfrac{\quad}{5}$

Write a word address program in absolute mode for executing the CNC operations given in sheet for the part shown below. Use CNC tool and operations sheet given.

CNC TOOL AND OPERATIONS SHEET

Tool	Operation	Tooling	Speed (rpm)	Feed (mm/min)
1	Facing 0.5 mm	φ50-mm Face mill	1500	250
3	Circular pocket depth of cut 1mm	φ10-mm End mill	2500	250
3	Fillets on part edges, total depth of 15 mm	φ10-mm End mill	2500	250
7	Center drill depth of cut 1.7mm	Center drill	1200	100
4	Deep drill (4) holes	φ5-mm Twist drill	2000	150
5	Tapping	M6 tap	500	150
6	Chamfer mill	Angle cutter φ16x4mm	3000	400

SEQUENCE NUMBER	Word address command	Meaning
N5	G54	ZERO OFFSET
N10	G52 X30 Y30 Z29.5	LOCAL COORDINATE SYSTEM
N15		
N20		
N25		
N30		
N40		
N45		
N50		
N55		
N60		
N65		
N70		
N75		SUB-ROUTINE CALL
		SUB-ROUTINE
N80		
N85		
N90		
N95		
N100		
N105		
N110		
N115		
N120		
N125		
N130		
N135		
N140		

N145		
N150		
N155		
N160		
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N210		
N215		
N220		
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N330		
N335		
N340		
N345		
N350		
N355		
N360		