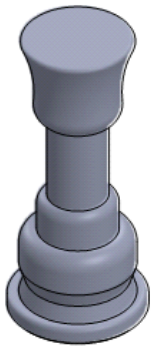
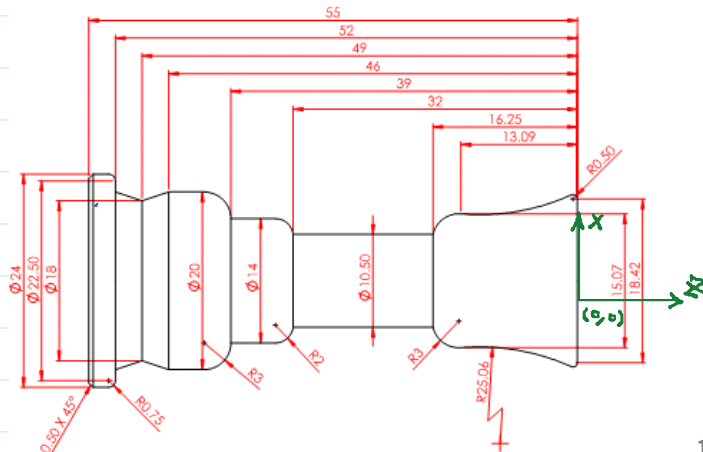
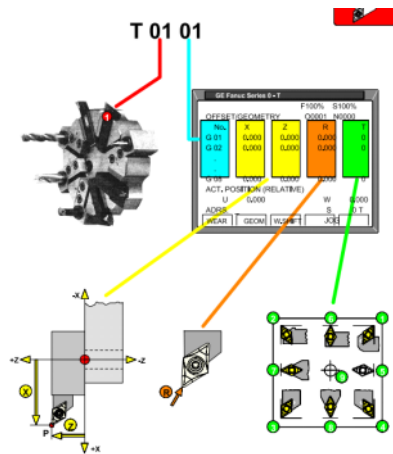


Classwork-1

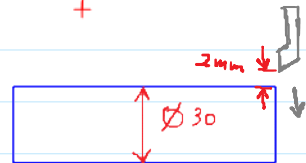
Tuesday, November 29, 2016 12:21 PM

01

N5 Tail



N10 G96 S180 G95 F0.1 M4
 Constant cutting speed (mm/min) Feed per revolution (mm/rev)



N15 G0 X32 Z0
 N20 G1 X-1 } Facing

N25 G0 X30 Z1

N30 G73 U0.5 R1
 Stock removal in turning → depth of cut
 → retract height

N35 G73 P40 Q120 U0.5 W0.1 F0.15

N40 G1 X18.42 Z0 G42

N45 G3 X19.42 Z-0.5 R0.5
 (18.42+1)

N50 G2 X15.07 Z-13.09 R25.06

N55 G3 X10.50 Z-16.25 R3

N60 G1 Z-32

N65 G3 X14 Z-34 R2

N70 G1 Z-39

N75 G3 X20 Z-42 R3

N80 G1 Z-46

N85 G1 X18 Z-49

N90 G1 X20 Z-52

N95 G1 X22.5

N100 G3 X24 Z-52.75 R0.75

N105 G1 Z-54.5

N110 G1 X22.5 Z-55

N115 G1 Z-59 (55+4)

N120 G0 X30 G40

← Q

N125 G72 P40 Q120 F0.1 S240

↓
Finishing cycle

N130 G28 U1 W1 → incremental intermediate coordinates
↳ return to reference point

N135 T0404

N140 G97 S1200 G95 F0.05 M4

N145 G0 X32 Z-55

N150 G1 X-1

N155 G0 X30

N160 G72 U1 W1

N165 M30