

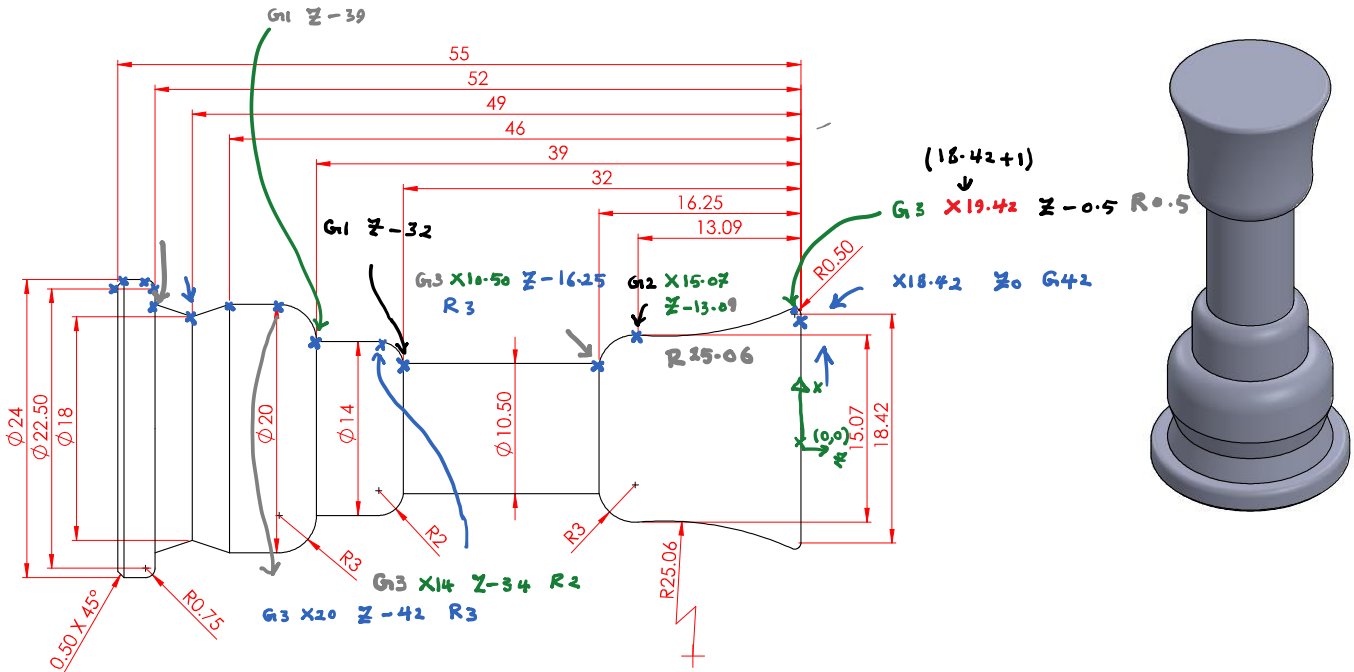


Classwork-1

Student Name: _____

Grade: $\frac{-}{5}$

Write a word address program in **absolute mode** to execute the operations shown in the figure below. Use CNC tool and operations sheet given



CNC TOOL AND OPERATIONS SHEET

| Tool | Operation | Tooling | Constant cutting speed | Speed(rpm) | Feed (mm/rev) |
|------|---------------|-----------------|------------------------|------------|---------------|
| 2 | Facing | Right hand tool | 180 | - | 0.1 |
| 2 | Rough Turning | Right hand tool | 180 | - | 0.15 |
| 2 | Finishing | Right hand tool | 240 | - | 0.1 |
| 6 | Parting | Parting tool | - | 1200 | 0.05 |



| SEQUENCE NUMBER | Word address command | Meaning |
|-----------------|----------------------|---------|
| N5 | | |
| N10 | | |
| N15 | | |
| N20 | | |
| N25 | | |
| N30 | | |
| N35 | | |
| N40 | | |
| N45 | | |
| N50 | | |
| N55 | | |
| N60 | | |
| N65 | | |
| N70 | | |
| N75 | | |
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| N130 | | |
| N135 | | |
| N140 | | |
| N145 | | |
| N150 | | |
| N155 | | |
| N160 | | |
| N165 | | |
| N170 | | |
| N175 | | |
| N180 | | |
| N185 | | |
| N190 | | |
| N195 | | |
| N200 | | |
| N205 | | |
| N210 | | |
| N215 | | |
| N220 | | |