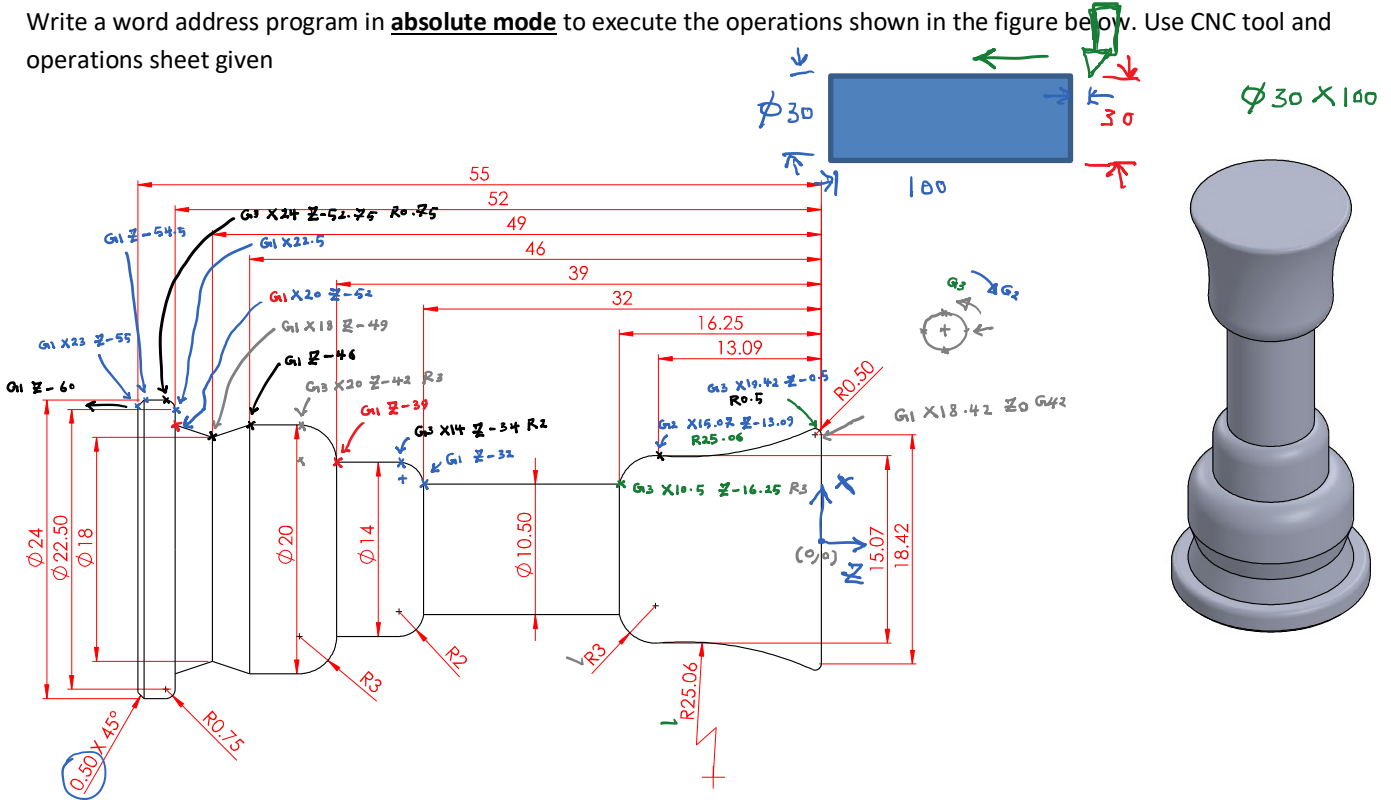


Classwork-1

Student Name: _____

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

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, U= 0.5, R = 1	Right hand tool	180	-	0.15
2	Finishing, U=0.5, W=0.1	Right hand tool	240	-	0.1
6	Parting	Parting tool	-	1200	0.05



SEQUENCE NUMBER	Word address command	Meaning
	01	
N5	T0202	
N10	G96 S180 G95 F0.1 M3	
N15	G0 X32 Z0	← Facing
N20	G1 X-1	←
N25	G0 X30 Z1 ←	
N30	G73 U0.5 R1	
N35	G73 P40 Q120 U0.5 W0.1 F0.15	
N40		
N45		
N50		
N55		
N60		
N65		
N70		
N75		
N80		
N85		
N90		
N95		
N100		
N105		
N110		
N115		
N120	→	
N125	G72 P40 Q120 S240 F0.1	
N130		
N135		
N140		
N145		
N150		
N155		
N160		
N165		
N170		
N175		
N180		
N185		
N190		
N195		
N200		
N205		
N210		
N215		
N220		

