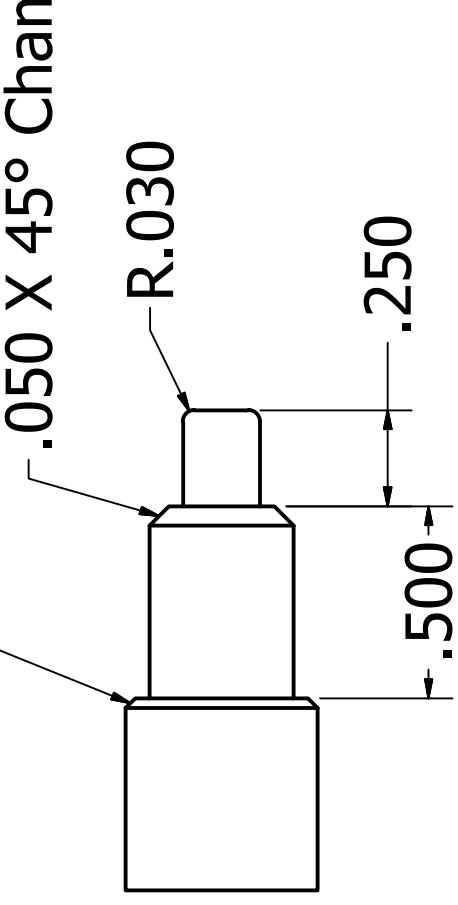
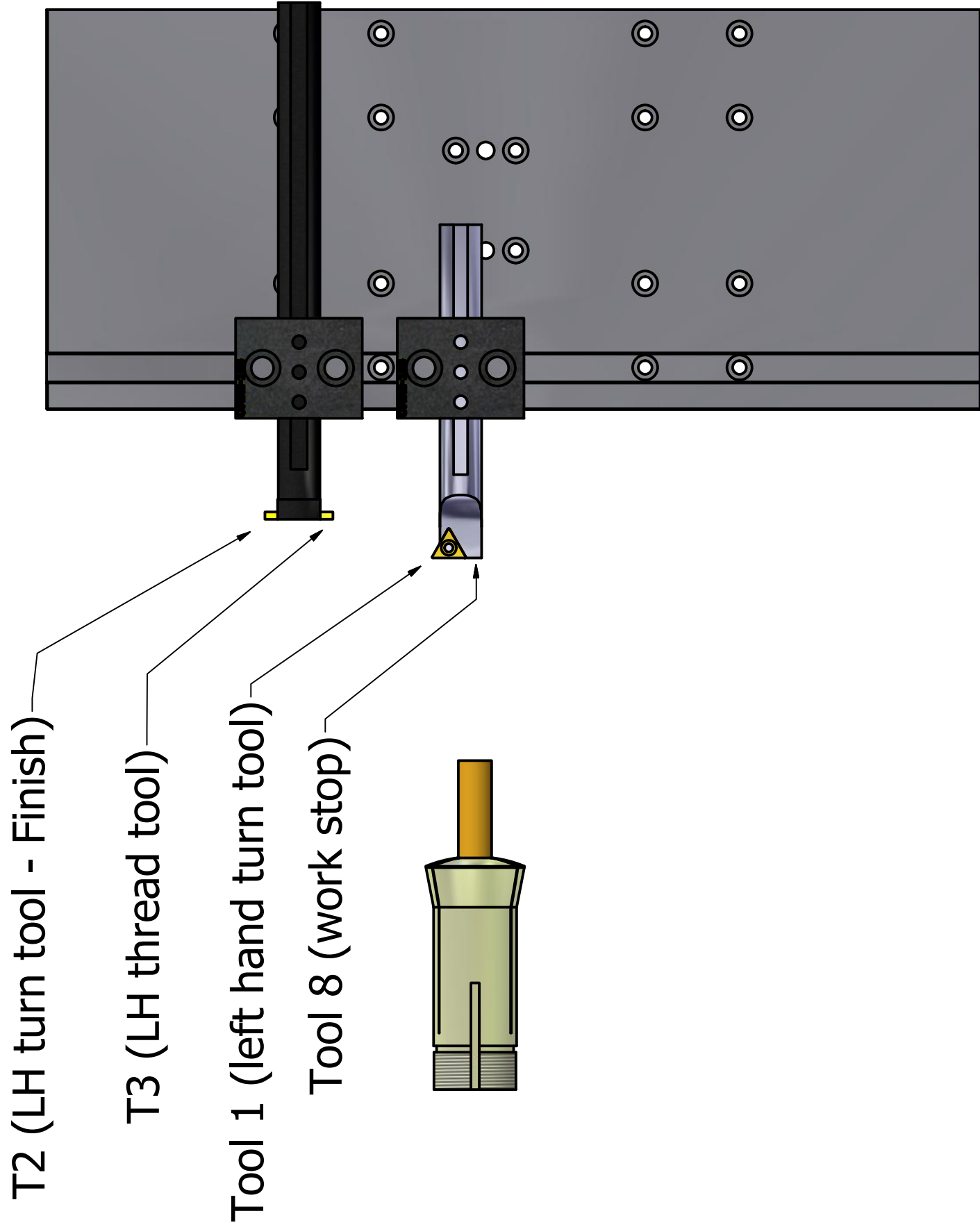


Topic: Repeat basic programming example  
 Topic: Single point threading  
 Topic: Tools on the (-) side of the spindle



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

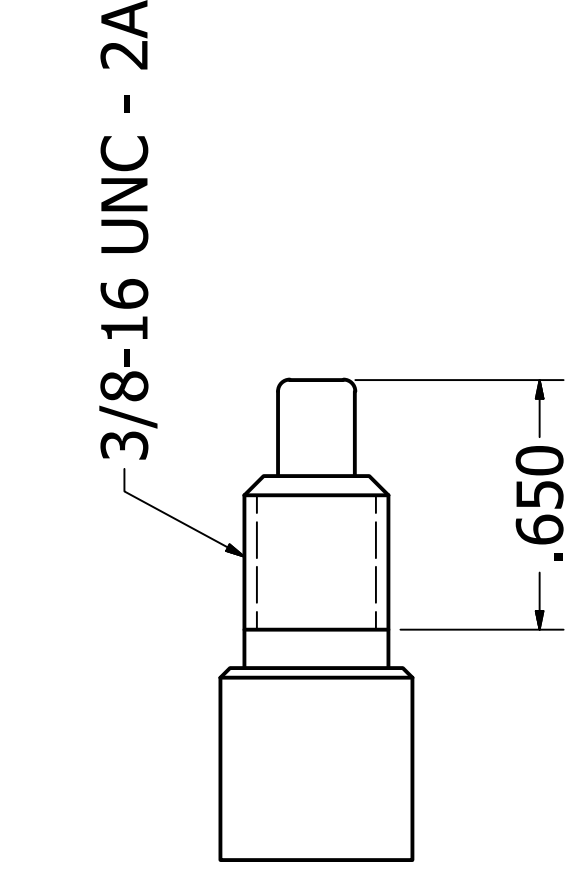
Sample 4 Process:

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

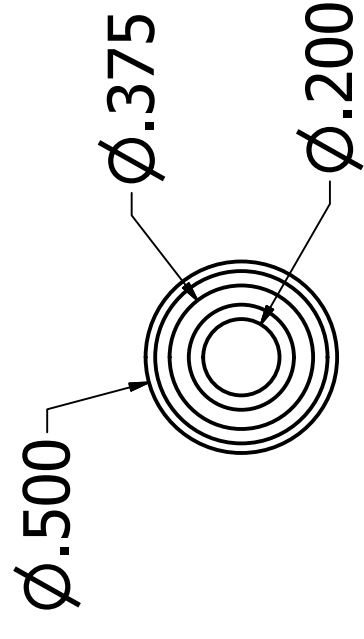
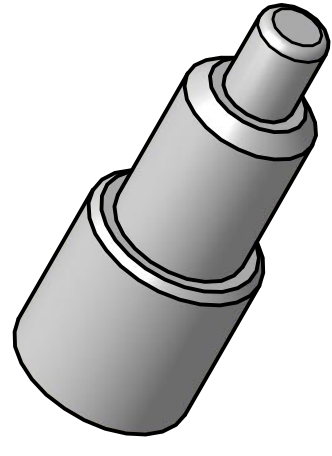
Use T2 (LH turn tool - finish)  
 perform a cleanup pass with the chamfers and radius

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

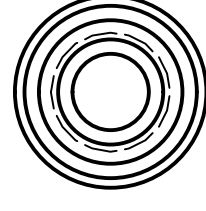


Sample 4

Sample 4



Sample 3



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