

(PLUG.NC)
(CNC LATHE MACHINING EXERCISE)

(1.5 DIA ALUMINUM BAR)
(EXTEND MATERIAL 2.0 INCHES FROM THE FRONT FACE OF JAWS)

(T0303 - OD TURNING AND FRONT FACING)

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N1 G20 G50 S3000 T0300
N2 G96 S600 M03
N3 G00 X1.7 Z0 T0303 M08
N4 G01 X-0.07 F0.002
N5 G00 Z0.1
N6 G42 X1.6 Z0.15
N8 G71 P9 Q20 U0.04 W0.005 D0800 F0.012
N9 G00 X-0.1 (P1)
N10 G01 Z0.05 (P2)
N11 G02 X0 Z0 R0.05 F0.001 (P3)
N12 G03 X0.375 Z-0.1875 R0.1875 F0.003 (P4)
N13 G01 X0.5 Z-0.2958 F0.004 (P5)
N14 Z-0.585 (P6)
N15 G02 X0.7 Z-0.685 R0.1 (P7)
N16 G01 X0.7726 (P8)
N17 X1.1156 Z-0.731 (P9)
N18 G03 X1.375 Z-0.9 R0.175 (P10)
N19 G01 Z-1.51 (P11)
N20 X1.575 F0.03 (P12)
N21 G70 P9 Q20 S800
N22 G00 G40 X5.0 Z4.0 T0300
N23 M01
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(T0505 - 0.125 WIDE PART-OFF TOOL)

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N24 T0500
N25 G97 S1800 M03
N26 G00 X1.7 Z0.1 T0505 M08
N27 Z-1.51
N28 G01 X1.0 F0.002
N29 G00 X1.475
N30 Z-1.425 (START OF 0.025 X 45 DEG BACK CHAMFER)
N31 G01 X1.325 Z-1.5 F0.001
N32 X-0.02 F0.002
N33 G00 X1.7
N34 X5.0 Z4.0 T0500
N35 M30
%
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