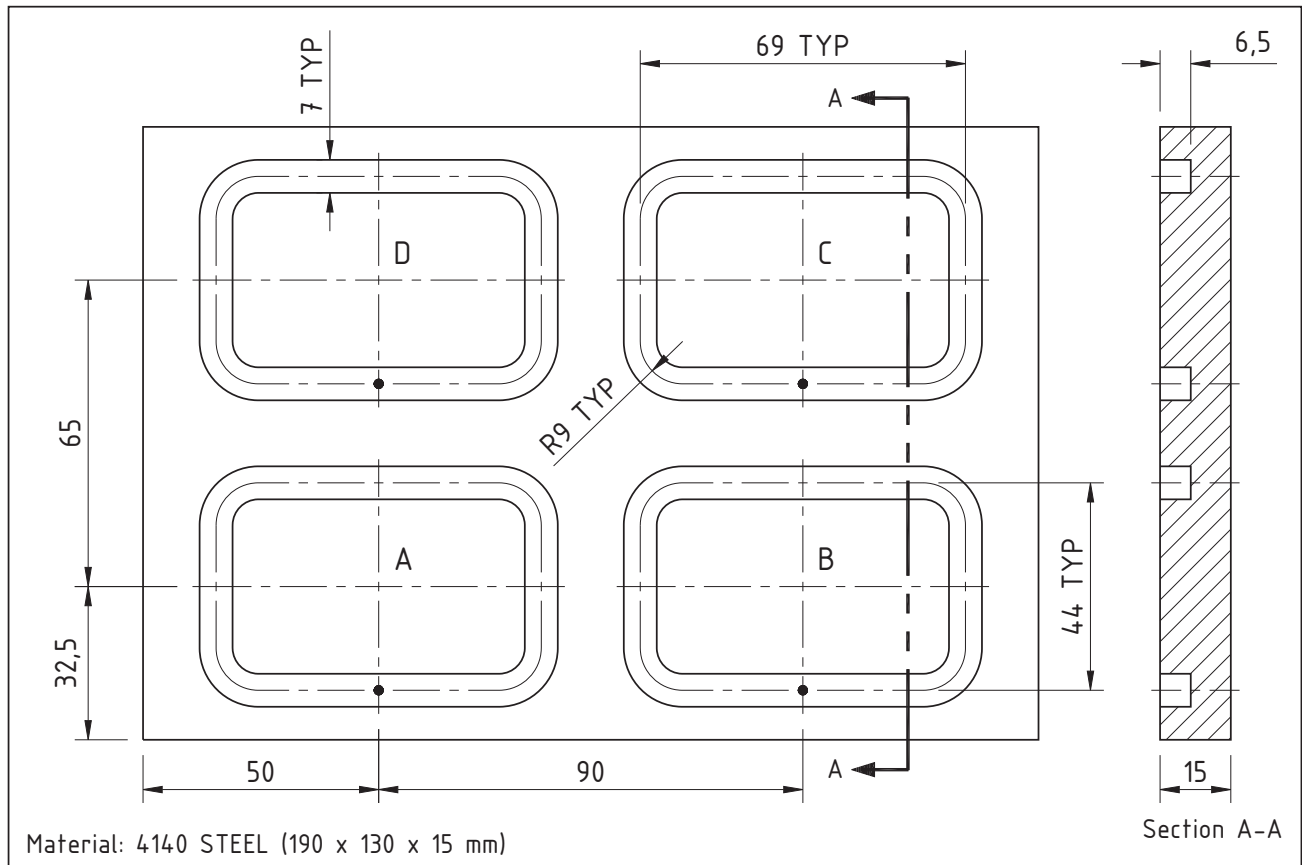


In this yet another subprogram project, there are two versions of a CNC program development for the grooves in the drawing below.



➡ 39-09-A - To develop the first version of the part program, observe the following conditions:

1. Use a single $\varnothing 7$ mm center-cutting end mill
2. Start at the bottom midpoint of groove A, plunge to full depth and machine the groove
3. Repeat *Step 2* for the remaining three pockets, in the order of B-C-D

➡ 39-09-B - To develop the second version of the part program, observe the following conditions:

1. Use two center-cutting end mills - $\varnothing 6$ mm for roughing and $\varnothing 5$ mm for finishing
2. Program five (5) equal rough depth cuts for each groove
3. Leave 0.25 mm on the bottom for finishing - finish each wall with radius offset in effect
4. Program grooves in the order of A-B-C-D, starting at the bottom midpoint of groove A