

In this simple - but typical - metric part-off exercise, the goal is to cut off 55 mm length of the completed part from 35 mm diameter bar stock. In this exercise, there is a 1 mm chamfer at the back of the part, to be cut with the part-off tool.

➡ Follow these conditions to complete the project:

1. Use standard turning tool and a 3 mm wide part-off tool
2. Face, chamfer and turn diameter (use tool number 3 at 120 m/min)
3. Part-off to 55 mm length (use tool number 5 at 1700 r/min) with a 1 mm back chamfer

