

Boring is a common operation on CNC lathes. This project presents a typical drawing of a contour that has to be bored. As boring cannot be done in solid material, and a prior drilling operation is necessary.

➔ To develop the part program, follow these conditions:

1. T05 - $\varnothing 1.375$ indexable insert drill (so called 'U-Drill')
2. T01 - Boring bar for roughing the contour - identify size in the program
3. T03 - Boring bar for finishing the contour - identify size in the program
4. Calculate the speeds, feeds and depth of cut for 4140 steel
5. Break two sharp corners $0.02 \times 45^\circ$ - at the $\varnothing 3.25$ and $\varnothing 1.5$
6. Use the appropriate cutting cycle for both roughing and finishing

