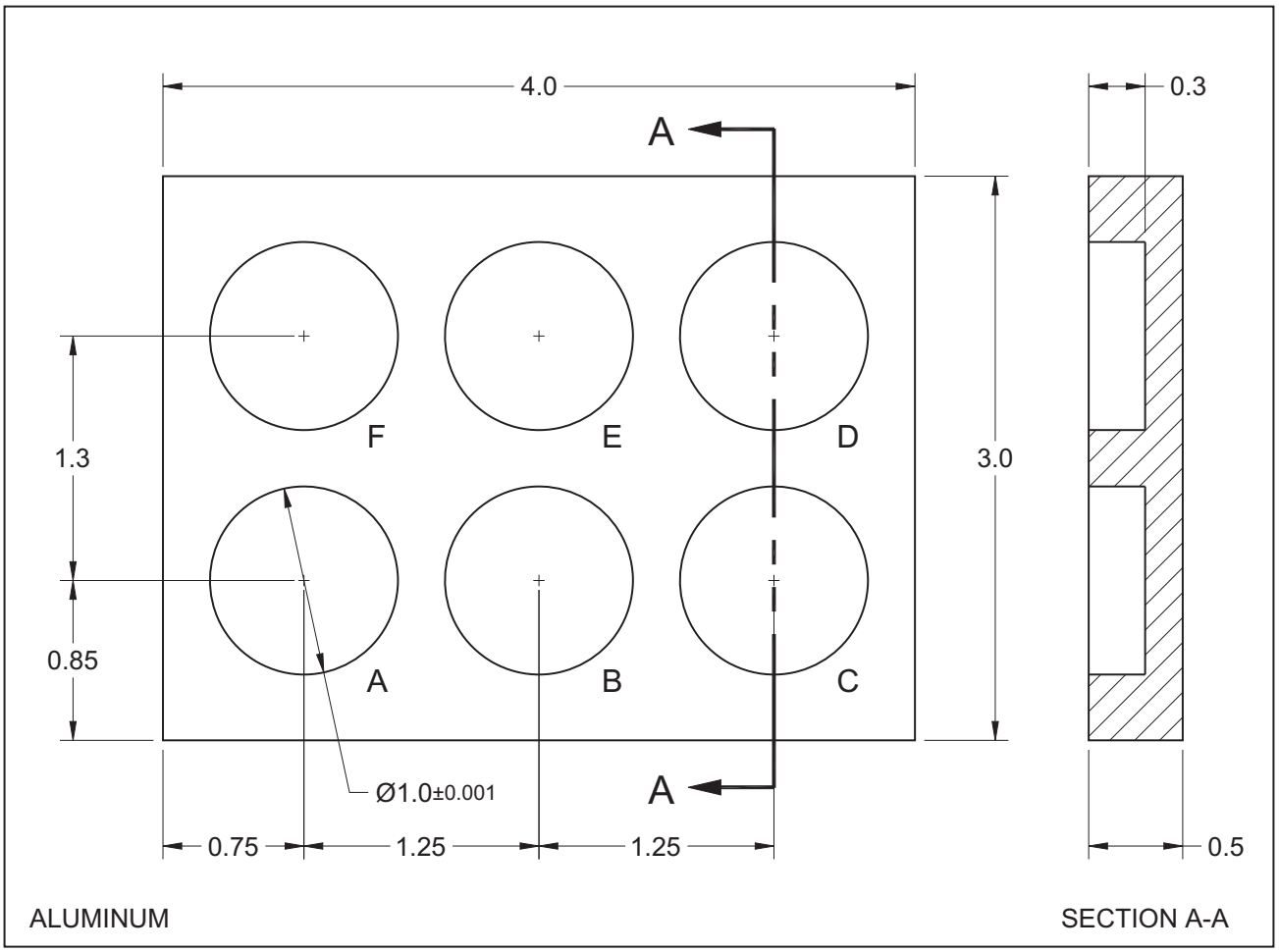
39-08 Six Pockets

In this comprehensive project (intermediate to advanced), there are six circular pockets identified from *A* to *F*. Pocket *A*, pocket *B*, and pockets *C-D-E-F* will be programmed as three groups, in three different ways. Normally, all pockets would be programmed and machined the same way, but for the purposes of training, three different requirements have been imposed.

➲ To develop the part program, observe the following ***common*** conditions for ALL pockets:

1. Only ONE main program is required for all three methods.
2. Use a single ∅0.375 center-cutting end mill for both roughing and finishing. Start at the center of the pocket, and continue in the order of A-B-C-D-E-F.
3. First, rough each pocket to ∅0.975 and leave 0.01 stock on the bottom for finishing, then finish all six pockets to size.



➔ Individual Requirements:

For pocket A only

Rough at a single depth with multiple stepovers, at the location A
Stepover = 0.1

For pocket B only

Rough at a multiple depths with single stepovers, at the location B
Depth = 0.1 for each stepover

For pockets C-D-E-F only

Rough at a multiple depths with multiple stepovers, at locations C-D-E-F
Stepover = 0.1, Depth = 0.1 for each stepover