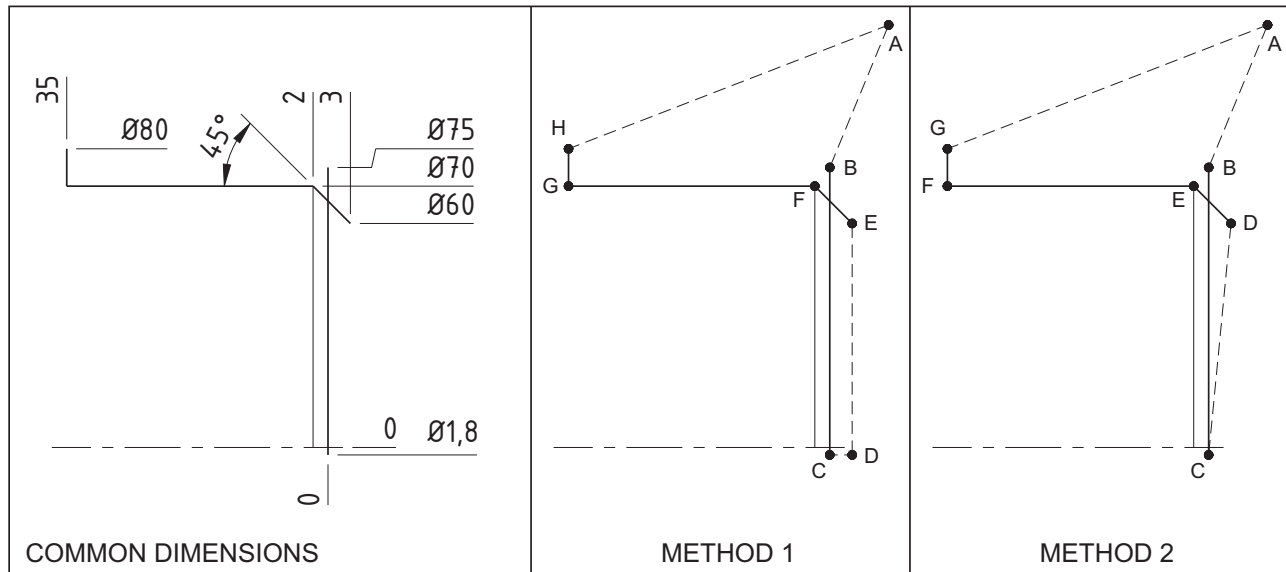


In most turning jobs, whenever there is a facing operation, the same tool that does the facing, usually continues to turn the stock, either for roughing or finishing. In this project, the transition from a facing cut to a finishing cut is explored. The objective of the project is to evaluate the four similar programs and identify those that are correct and those that are not, with an explanation. The tool used is an 80° external tool, with 0.8 mm nose radius.



34-02-A - USING METHOD 1

N1 G21 T0100	(POINT A)
N2 G96 S130 M03	
N3 G00 G41 X75.0 Z0 T0101 M08	(POINT B)
N4 G01 X-1.8 F0.25	(POINT C)
N5 G00 Z1.0	(POINT D)
N6 G42 X60.0	(POINT E)
N7 G01 X70.0 Z-2.0	(POINT F)
N8 Z-35.0 F0.2	(POINT G)
N9 X80.0	(POINT H)
N10 G00 G40 X200.0 Z100.0 T0100 M09	(CLEAR OFF PART)
N11 M30	
%	

34-02-B - USING METHOD 1

N1 G21 T0100	(POINT A)
N2 G96 S130 M03	
N3 G00 G41 X75.0 Z0 T0101 M08	(POINT B)
N4 G01 X-1.8 F0.25	(POINT C)
N5 G00 Z3.0	(POINT D)
N6 G42 X60.0	(POINT E)
N7 G01 X70.0 Z-2.0	(POINT F)
N8 Z-35.0 F0.2	(POINT G)
N9 X80.0	(POINT H)
N10 G00 G40 X200.0 Z100.0 T0100 M09	(CLEAR OFF PART)
N11 M30	
%	

➡ 34-02-C - USING METHOD 2

N1 G21 T0100	(POINT A)
N2 G96 S130 M03	
N3 G00 X75.0 Z0 T0101 M08	(POINT B)
N4 G01 X-1.8 F0.25	(POINT C)
N5 G00 G42 X60.0 Z3.0	(POINT D)
N6 G01 X70.0 Z-2.0	(POINT E)
N7 Z-35.0 F0.2	(POINT F)
N8 X80.0	(POINT G)
N9 G00 G40 X200.0 Z100.0 T0100 M09	(CLEAR OFF PART)
N10 M30	
%	

➡ 34-02-D - USING METHOD 2

N1 G21 T0100	(POINT A)
N2 G96 S130 M03	
N3 G00 G41 X75.0 Z0 T0101 M08	(POINT B)
N4 G01 X-1.8 F0.25	(POINT C)
N5 G00 G42 X60.0 Z3.0	(POINT D)
N6 G01 X70.0 Z-2.0	(POINT E)
N7 Z-35.0 F0.2	(POINT F)
N8 X80.0	(POINT G)
N9 G00 G40 X200.0 Z100.0 T0100 M09	(CLEAR OFF PART)
N10 M30	
%	

➡ 34-02-A ☐ CORRECT ☐ INCORRECT
Explain:

➡ 34-02-B ☐ CORRECT ☐ INCORRECT
Explain:

➡ 34-02-C ☐ CORRECT ☐ INCORRECT
Explain:

➡ 34-02-D ☐ CORRECT ☐ INCORRECT
Explain: