

Trial cut in CNC programming can have many forms. By definition, a trial cut is a physical cut that uses the current tool to make a single - *and measurable* - test cut, before the actual machining begins. This test cut is part of the CNC program, and must not interfere with the final cutting contour in any way. Trial cut is an actual cut on the part, but has some specific characteristics:

1. The trial cut can be enabled or disabled by the CNC machine operator, as needed
2. The result of the trial cut can be measured
3. The part can be machined to final size during normal program processing
4. The trial cut programming method can be used for milling or turning

The 23-02 programming exercise shows a simple, yet powerful application of a block skip function.

➡ Objective:

In this exercise, make a trial cut on the diameter for a fairly tight final tolerance, which is - in this case - applied to the 44 mm diameter. The purpose of the trial cut is to adjust the wear offset *before* the actual cut, so the turning (or boring) tool will complete the finish cut within the specified tolerance.

For the purposes of this exercise, the 65 mm diameter is clamped in a chuck and *T01* will be used for roughing, *T03* for finishing, including the trial cut.

