

Programming pockets almost always offers a good possibility of subprograms. This project presents a medium to advanced exercise to program the three circular pockets in the most efficient way, using subprograms.

☛ To develop the part program, observe the following conditions:

1. Minimum cleanup off the top face is required - use a $\varnothing 3.0$ face mill (for one operation only)
2. Use $\varnothing 0.625$ center cutting end mill for *roughing and finishing* all three pockets
3. Use $\varnothing 0.375$ chamfering tool - $0.01 \times 45^\circ$ - program at Z-0.1 depth (suggest the D-offset value)
4. Subprogramming method is expected for all three pockets (do *NOT* use the G12/G13 method)

