

The two pockets in this project are similar. The objective is to make a program for both pockets. Subprograms are discussed in *Chapter 39*. Control is *Fanuc O-M* on a simple VMC.

➡ To develop the part program, follow these conditions:

1. Same pocket tool return
2. Address *H* is used for both tool length *and* cutter radius offset
3. XY machine zero is set at upper left corner
4. Offset number cannot be passed from a subprogram call block
5. Automatic block numbering by the control is in increments of 5 (for manual program entry)
6. Material is A2 tool steel - ground all faces - leave 0.02 per side for pocket finishing cuts

