

## Program Change

The solution to this project affects only the two turning tools, the part-off tool is not affected. In the following program, the changes have been highlighted in larger font and italics, with new sequence numbers.

(35-01 - PROGRAM CHANGE - SOLUTION)  
(EXTEND BAR 2.75 FROM THE JAWS FACE)

(T03 - 55 DEG ROUGHING TOOL)

N1 G20

N2 G50 S2000 T0300

N3 G96 S500 M03

N4 G00 X1.2 Z0 T0303 M08

N5 G01 X-0.07 F0.006

N6 G00 Z0.1

N7 G42 X1.05

N8 G71 U0.06 R0.05

***N9 G71 P10 Q20 U0.05 W0.004 F0.01***

***N10 G00 X0.075 Z0.1***

***(Z-AXIS REQUIRED FOR UNDERCUT)***

N11 G01 X0.375 Z-0.05 F0.002

N12 Z-0.35 F0.005

N13 G02 X0.475 Z-0.4 R0.05

N14 G01 X0.575 Z-0.45

***N15 Z-0.8***

***N16 X0.4 Z-1.1***

***N17 Z-1.4***

N18 X0.9 Z-1.65

N19 Z-2.03

N20 U0.2 F0.02

N21 G00 G40 X3.0 Z5.0 T0300

N22 M01

(T01 - 35 OR 55 DEG FINISHING TOOL)

N23 G50 S2000 T0100

N24 G96 S600 M03

N25 G00 G42 X1.2 Z0.1 T0101 M08

***N26 G70 P10 Q20***

N27 G00 G40 X3.0 Z5.0 T0100

N28 M01

(T05 - 0.125 WIDE PART-OFF TOOL)

N29 T0500

N30 G97 S1800 M03

N31 G00 Z-2.01 T0505 M08

N32 X1.2

N33 G01 X0.7 F0.001

N34 G00 X1.0

N35 W0.08

N36 G01 U-0.14 W-0.07 F0.002

N37 X-0.02

N38 G00 X3.0

N39 Z5.0 T0500 M09

N40 M30

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