

This is a simple metric project for facing, turning and threading. The drawing is identical to the one in 35-03, except a thread has been added. Retrieve the previous program from a disk and add the thread - OR - develop the complete program - see *Project 35-03*.

➔ To develop the part program, follow these conditions:

1. Use only one tool - T02 - to face, rough and finish the part as shown in the drawing
2. Use tool number 4 for threading
3. Use only one cut for facing
4. Use tool nose radius offset for all cuts
5. Use automatic corner breaking where possible
6. Use speeds, feeds and depth of cut for 4140 steel
7. Use the appropriate cutting cycle for roughing, finishing and threading

