

This advanced project may take some time, but the job itself is not too difficult. For the XY axes, set the program zero at the center of the pocket, for the Z axis, set the program zero to the finished top of part. Program the part in one operation, using subprograms, as necessary. Use only these tools:

- ❑ T01 - Ø 3.0 Face mill to clean the top face to height
- ❑ T02 - Ø 1/2 Spot drill
- ❑ T03 - Ø 1/4 Drill
- ❑ T04 - Ø 1/4 Center cutting end mill
- ❑ T05 - Ø 3/8 Chamfering tool at 45°

For added challenge, machine the Ø1.28 circular pocket with stepovers of 0.1 and cutting depth of 0.05 maximum. Programs like this require careful planning, good organization and time.

