

This typical turning project requires a facing and turning operation, undercut (recess) and part-off. Save the completed program to disk, and use it later for adding a threading operation to it - see *Project 38-05*.

➡ To develop the part program, follow these conditions:

1. Use three tools:
 T01 - 80° or 55° tool to face and rough OD
 T05 - 0.125 wide part off tool to cleanup the undercut and part-off with chamfer
 T06 - 35° OD tool to finish the undercut
2. Use only one cut for facing
3. Use tool nose radius offset for the turning
4. Use speeds, feeds and depth of cut for aluminum
5. Use one-block turning cycle - use care in machining method selection (*see tool selection above*)

