

## Face - Turn - Part-Off

The part-off tool is used to open up the undercut. If the part-off tool is not suitable for this operation, use a grooving tool instead. This program is repeated in project 38-05, where several versions of a thread will be added:

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(35-05 - FACE - TURN - PART-OFF)
(T01 - 80/55 DEG OD - ROUGH OD ONLY - NO U/CUT)
N1 G20 G50 T0100
N2 G96 S550 M03
N3 G00 X1.2 Z0 T0101 M08
N4 G01 X-0.07 F0.003
N5 G00 Z0.1
N6 G42 X1.03
N7 G71 P8 Q13 U0.02 W0.002 D0500 F0.01
N8 G00 X0.535
N9 G01 X0.875 Z-0.07 F0.002
N10 Z-1.5
N11 X0.975 K-0.02
N12 Z-2.125
N13 U0.2 F0.03
N14 G00 G40 X4.0 Z4.0 T0100 M09
N15 M01

(T05 - 0.125 WIDE PART-OFF TOOL - CLEAN-UP U/CUT)
N16 T0500
N17 G97 S1750 M03
N18 G00 Z-1.46 T0505 M08
N19 X1.2
N20 G01 X0.795 F0.003
N21 G00 X1.2
N22 X4.0 Z4.0 T0500 M09
N23 M01

(T06 - 35 DEGREE OD TOOL)
N24 T0600
N25 G96 S750 M03
N26 G00 G42 X0.535 Z0.2 T0606 M08
N27 G01 Z0.1 F0.02
N28 X0.875 Z-0.07 F0.002
N29 Z-1.25
N30 X0.775 Z-1.3366
N31 Z-1.46
N32 G02 X0.855 Z-1.5 R0.04
N33 G01 X0.975 K-0.025 F0.001
N34 Z-2.125 F0.002
N35 U0.2 F0.03
N36 G00 G40 X4.0 Z4.0 T0600 M09
N37 M01

(T05 - 0.125 WIDE PART-OFF TOOL - BACK CHAMFER AND PART-OFF)
N38 T0500
N39 G97 S1750 M03
N40 G00 Z-2.135 T0505 M08
N41 X1.2
N42 G01 X0.75 F0.003
N43 X1.075 F0.03
N44 Z-2.05
N45 X0.925 Z-2.125 F0.002
N46 G01 X-0.005
N47 G00 X1.2
N48 X4.0 Z4.0 T0500 M09
N49 M30
%
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