

39-05

Comprehensive Subprogram 2

This second comprehensive project can produce a very short program, if done right. For the training purposes, use only one tool, but observe the following conditions:

- ❑ Use 0.25 center cutting end mill
- ❑ Start at zero degrees and continue counterclockwise
- ❑ Use a continuous toolpath - once you start, you only continue forward, no return motions
- ❑ Apply cutter radius offset for the circular pockets
- ❑ For all circular motions, use **I** and **J** vectors, not direct radius **R**
- ❑ All circular motions must be broken at quadrant points (a requirement to add challenge)
- ❑ Use F5.0 feedrate for cutting motions along XY axes and F3.0 for Z-axis cutting
- ❑ All coordinates relating to the groove must be in absolute coordinates
- ❑ All motions relating to the pocket must be in incremental values
- ❑ Program pocket motions as a subprogram

The listed conditions make the project more methodical and have been imposed mainly for training purposes.

