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| --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  | Title: | | Drawing No: | | | | Rev | |
| **1006 Lathe Practical** | | **CNCM1006-PE3** | | | | **1** | |
| Machine: | | Program No.: | | | | | |
| **Haas TL-15** | | **O10065** | | | | | |
| Material Type (MC number): | Material Size: | | | | Material Bhn: | | |
| **P1.1.Z.AN** | **3.5”x11/16”wallx5”** | | | | **150** | | |
| Workholding Device: | | | Operation(s): | | | | |
| **Hard Jaws** | | | **1** | of | | | **1** |
| Programmer: | | | | | | | |
| **Stephane Drouin-Moreland** | | | | | | | |

**Workholding Set-up**

|  |  |  |
| --- | --- | --- |
|  | | |
| **Work Coordinate Offset:** | **A: 3.5 +/- 0.002** | **B: 0.05** |

**Special Instructions:**

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| Chuck pressure set to 200psi |
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| Operation: | **Rough Face and OD** | | | | | | | |
| Cutting Head ID: |  | | | | Insert ID: | **DNMG-332 PM4325** | | |
| Cutting Unit ID: | **C4-DDJNR-207050-12** | | | | Clamping Unit ID: | **C4-RC2040-51030M** | | |
| Turret Position | Offset # | | Tip Code | TNR (re) | Velocity (Vc) | RPM (n) | Feed Rate (fn) | DOC Range |
| **1** | **1** | | **3** | **.0313** | **1150sfm** | **-** | **0.0118** | **0.0156-0.079** |
| Notes: |  |  | | | | | | |

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| Operation: | **Finish Face and OD** | | | | | | | |
| Cutting Head ID: |  | | | | Insert ID: | **DNMG-331 PF4325** | | |
| Cutting Unit ID: | **C4-DDJNR-207050-12** | | | | Clamping Unit ID: | **C4-RC2040-51030M** | | |
| Turret Position | Offset # | | Tip Code | TNR (re) | Velocity (Vc) | RPM (n) | Feed Rate (fn) | DOC Range |
| **3** | **3** | | **3** | **.0156** | **1150sfm** | **-** | **0.004** | **0.0156** |
| Notes: |  |  | | | | | | |

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| Operation: | **Rough and Finish ID** | | | | | | | |
| Cutting Head ID: |  | | | | Insert ID: | **CCMT 3(2.5)2 PF4225** | | |
| Cutting Unit ID: | **C4-SCLCR-13080-09** | | | | Clamping Unit ID: | **C4-NC3000-V40-03 0** | | |
| Turret Position | Offset # | | Tip Code | TNR (re) | Velocity (Vc) | RPM (n) | Feed Rate (fn) | DOC Range |
| **7** | **7** | | **2** | **.0313** | **1150sfm** | **-** | **0.0056-0.0059** | **0.0313-0.06** |
| Notes: |  |  | | | | | | |

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| Operation: | **Thread** | | | | | | | |
| Cutting Head ID: |  | | | | Insert ID: | **266RG-16UN01C200M** | | |
| Cutting Unit ID: | **C4-266RFG-27050-16** | | | | Clamping Unit ID: | **C4-RC2040-51030M** | | |
| Turret Position | Offset # | | Tip Code | TNR (re) | Velocity (Vc) | RPM (n) | Feed Rate (fn) | DOC Range |
| **9** | **9** | | **3** | **-** | **-** | **968** | **0.05** | **-** |
| Notes: |  |  | | | | | | |

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| Operation: |  | | | | | | | |
| Cutting Head ID: |  | | | | Insert ID: |  | | |
| Cutting Unit ID: |  | | | | Clamping Unit ID: |  | | |
| Turret Position | Offset # | | Tip Code | TNR (re) | Velocity (Vc) | RPM (n) | Feed Rate (fn) | DOC Range |
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| Notes: |  |  | | | | | | |

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| Operation: |  | | | | | | | |
| Cutting Head ID: |  | | | | Insert ID: |  | | |
| Cutting Unit ID: |  | | | | Clamping Unit ID: |  | | |
| Turret Position | Offset # | | Tip Code | TNR (re) | Velocity (Vc) | RPM (n) | Feed Rate (fn) | DOC Range |
|  |  | |  |  |  |  |  |  |
| Notes: |  |  | | | | | | |

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| Operation: |  | | | | | | | |
| Cutting Head ID: |  | | | | Insert ID: |  | | |
| Cutting Unit ID: |  | | | | Clamping Unit ID: |  | | |
| Turret Position | Offset # | | Tip Code | TNR (re) | Velocity (Vc) | RPM (n) | Feed Rate (fn) | DOC Range |
|  |  | |  |  |  |  |  |  |
| Notes: |  |  | | | | | | |