

Lathe Test Coordinate Map

John Bush

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Point	X	Z	Comment
	1.700	0.050	Safe
	1.700	0.0	Prepare to face
	-0.050	0.0	Face
	-0.050	0.050	Safe Z
5	1.625	0.050	Turn first OD
	1.625	-2.100	Pass 1
	1.700	-2.100	Safe x
	1.700	0.050	Safe z
	1.575	0.050	
10	1.575	-2.100	Pass 2
	1.700	-2.100	
	1.700	0.050	
	1.525	0.050	
	1.525	-2.100	Pass 3
15	1.700	-2.100	
	1.700	0.050	
	1.510	0.050	Final rough pass
	1.510	-2.100	Pass 4
	1.700	-2.100	Safe X
20	1.700	0.050	Safe Z
	1.460	0.050	Turn second OD
	1.460	-1.000	Pass 1
	1.550	-1.000	Safe X
	1.550	0.050	Safe Z
25	1.410	0.050	
	1.410	-1.000	Pass 2
	1.550	-1.000	
	1.550	0.050	
	1.360	0.050	
30	1.360	-1.000	Pass 3

Point	X	Z	Comment
	1.550	-1.000	
	1.550	0.050	
	1.310	0.050	
	1.310	-1.000	Pass 4
35	1.550	-1.000	
	1.550	0.050	
	1.260	0.050	
	1.260	-1.000	Pass 5
	1.550	-1.000	
40	1.550	0.050	
	1.210	0.050	
	1.210	-1.000	Pass 6
	1.550	-1.000	
	1.550	0.050	
45	1.160	0.050	
	1.160	-1.000	Pass 7
	1.550	-1.000	
	1.550	0.050	
	1.110	0.050	
50	1.110	-1.000	Pass 8
	1.550	-1.000	
	1.550	0.050	
	1.060	0.050	
	1.060	-1.000	Pass 9
55	1.550	-1.000	
	1.550	0.050	
	1.010	0.050	Prepare final rough pass
	1.010	-1.000	Pass 10
	1.510	-1.050	First chamfer, first pass
60	1.510	-1.000	
	1.010	-1.000	
	1.510	-1.100	Pass 2
	1.510	-1.000	
	1.010	-1.000	
65	1.510	-1.150	Pass 3
	1.510	-1.000	
	1.010	-1.000	
	1.510	-1.200	Pass 4
	1.510	-1.000	
70	1.010	-1.000	

Point	X	Z	Comment
	1.510	-1.250	Pass 5
	1.510	-1.000	
	1.010	-1.000	
	1.510	-1.300	Pass 6
75	1.510	-1.000	
	1.010	-1.000	
	1.510	-1.350	Pass 7
	1.510	-1.000	
	1.010	-1.000	
80	1.510	-1.400	Pass 8
	1.510	-1.000	
	1.010	-1.000	
	1.510	-1.450	Pass 9
	1.510	-1.000	
85	1.010	-1.000	
	1.510	-1.500	Pass 10, last rough pass
	1.510	0.050	Prepare for second chamfer
	0.510	0.050	
	0.510	0.0	
90	1.010	-0.050	Chamfer pass 1
	1.010	0.050	Safe z
	0.510	0.050	
	0.510	0.0	
	1.010	-0.100	Pass 2
95	1.010	0.050	
	0.510	0.050	
	0.510	0.0	
	1.010	-0.150	Pass 3
	1.010	0.050	
100	0.510	0.050	
	0.510	0.0	
	1.010	-0.200	Pass 4
	1.010	0.050	
	0.510	0.050	
105	0.510	0.0	
	1.010	-0.250	Pass 5, last rough pass
	1.010	0.050	Safe Z
	0.500	0.050	Prepare for final pass
	0.500	0.0	
110	1.000	-0.250	Finish second chamfer
	1.000	-1.000	Finish second OD
	1.500	-1.500	Finish first chamfer
	1.500	-2.100	Finish first OD
	1.700	-2.100	Safe X
115	1.700	6.000	Move away tool