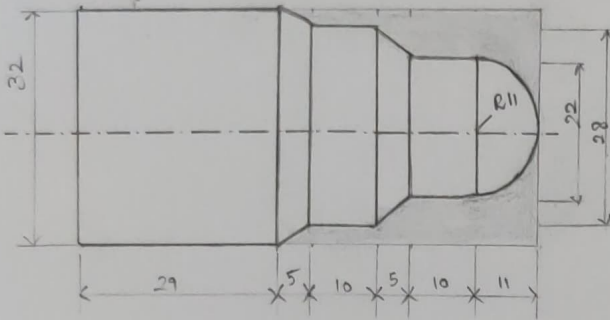


MANUFACTURING TECHNOLOGY - II
LAB

ASSIGNMENT-I, CNC PROGRAM.

MUNISHWARAN.S
2020PECME171
21/4/2011 4070
II-year Mech-'C'

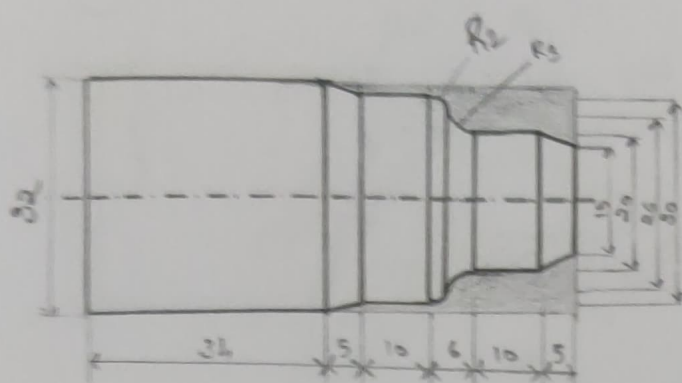
①



| S.No | G Codes | x axis | z axis | R |
|------|---------|--------|--------|-------|
| 1. | G00 | 00 | -0 | R/W - |
| 2. | G03 | 22 | -11 | R11 |
| 3. | G01 | 22 | -21 | - |
| 4. | G01 | 28 | -26 | - |
| 5. | G01 | 28 | -36 | - |
| 6. | G01 | 32 | -41 | - |

①

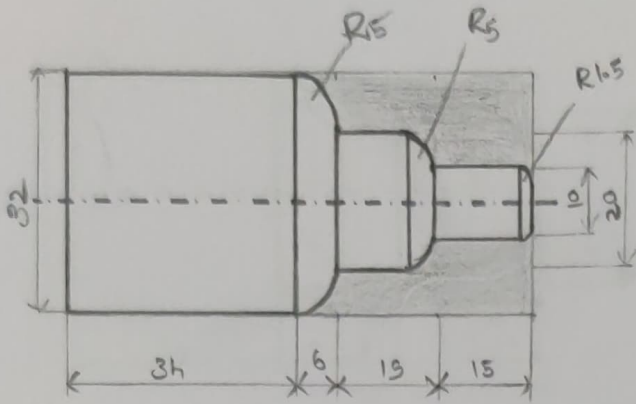
2



| S.No | G Codes | X-axis | Z-axis | R |
|------|---------|--------|--------|-------|
| 1. | G00 | 0 | 0 | - |
| 2. | G01 | 15 | 0 | - |
| 3. | G01 | 20 | -5 | - |
| 4. | G01 | 20 | -15 | - |
| 5. | G02 | 26 | -19 | R_3 |
| 6. | G03 | 30 | -21 | R_2 |
| 7. | G01 | 30 | -31 | - |
| 8. | G01 | 32 | -36 | - |

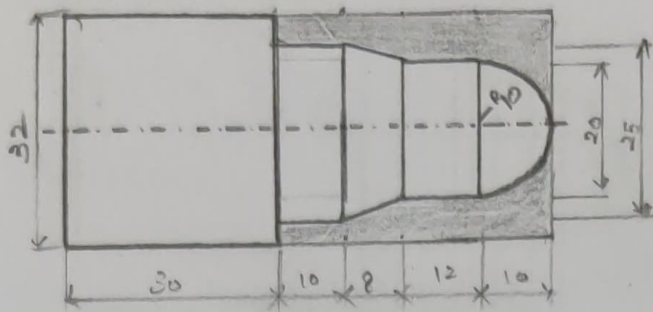
3

③



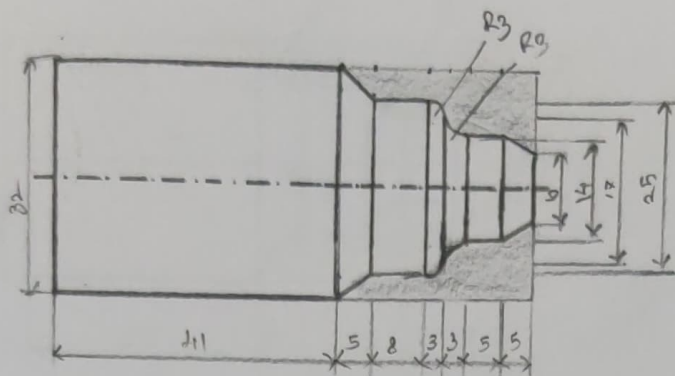
| S.No | G Codes | x-axis | Z-axis | R |
|------|---------|--------|--------|------|
| 1. | G100 | 0 | 0 | - |
| 2. | G103 | 10 | -1.5 | R1.5 |
| 3. | G101 | 10 | -15 | - |
| 4. | G103 | 20 | -20 | R5 |
| 5. | G101 | 20 | -30 | - |
| 6. | G103 | 32 | -36 | R5 |

24



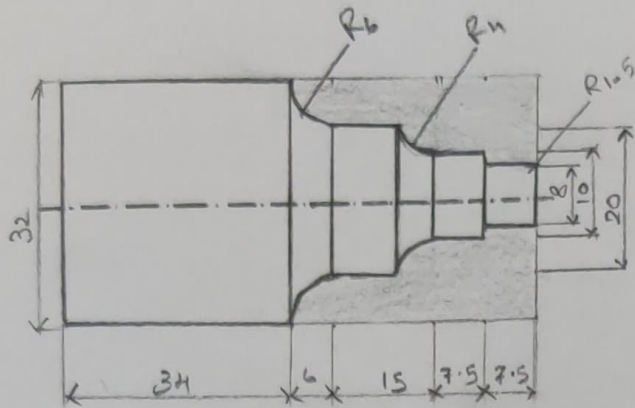
| S.No | G Codes | x-axis | Z-axis | R |
|------|---------|--------|----------------|-----------------|
| 1. | G00 | Q0 | -40 | -R40 |
| 2. | G03 | 20 | -10 | R10 |
| 3. | G01 | 20 | -22 | - |
| 4. | G01 | 25 | -30 | - |
| 5. | G01 | 25 | -40 | - |
| 6. | G01 | 32 | -40 | - |

5



| S.No | G codes | X-axis | Z-axis | R |
|------|---------|--------|--------|-------|
| 1. | G00 | 0 | 0 | - |
| 2. | G01 | 10 | 0 | - |
| 3. | G01 | 14 | -5 | - |
| 4. | G01 | 14 | -10 | - |
| 5. | G02 | 17 | -13 | R_3 |
| 6. | G03 | 25 | -16 | R_3 |
| 7. | G01 | 25 | -24 | - |
| 8. | G01 | 32 | -29 | - |

6



| S.No | G Codes | x-axis | Z-axis | R |
|------|---------|--------|--------|-----------|
| 1. | G00 | 0 | 0 | - |
| 2. | G03 | 8 | -1.5 | $R_{1.5}$ |
| 3. | G01 | 8 | -7.5 | - |
| 4. | G01 | 10 | -7.5 | - |
| 5. | G01 | 10 | -15 | - |
| 6. | G02 | 20 | -19 | R_4 |
| 7. | G01 | 20 | -30 | - |
| 8. | G02 | 32 | -36 | R_6 |