To enter a Program Name, type in the number and press INC SET.

Event #1: Start the program by using CYCLE. Enter the following:

* X BEGIN…………………….. .500
* Z BEGIN …………………….. 0.000
* Depth of Pass………….... .050
* Approach ………………….. Z
* RPM /SURFACE SPEED 1200RPMs *You need to press INC SET to input the speed as RPM’s. ABS SET inputs as SFM.*
* Feed per MIN or REV .015 per revolution
* Tool #........................... 1
* FIN CUT ……………………… .010
* Fin RPM/SURF SPEED… 1500
* Fin Feed MIN/REV…….. .003 per revolution
* Fin Tool # ………………….. 1

Event #2: Next, use CYCLE TURN.

* X END………………………… .500
* Z END………………………… -.625
* CHAMFER…………………. 0

Event #3: CYCLE TURN again.

* X END……………………….. .729
* Z END……………………….. -1.026
* CHAMFER ………………… 0

Event #4: Now use CYCLE ARC.

* DIRECTION……………….. CCW
* X END……………………….. .825
* Z END……………………….. -1.063
* Radius………………………. .050
* CHAMFER………………… 0

Event #5: CYCLE TURN.

* X END……………………….. 1.000
* Z END……………………….. -1.063
* CHAMFER………………… .030

Event #6: CYCLE TURN.

* X END……………………….. 1.000
* Z END……………………….. -1.200
* CHAMFER…………………. 0

Event #7: CYCLE TURN.

* X END……………………….. 1.100
* Z END……………………….. -1.200
* CHAMFER…………………. 0

Event #8: CYCLE POS.

* X END……………………….. 1.100
* Z END……………………….. 0

Event #9: END CYCLE, Yes to close the CYCLE.

Event 10: Make the Groove behind the threads. Select MORE, then GROOVE.

* OD/ID or FACE………….. OD/ID GROOVE
* X BEGIN……………………. .550
* Z1……………………………… -.500
* Z2……………………………… -.500
* X END……………………….. .400
* Z3……………………………… -.625
* Z4……………………………… -.625
* Chamfer Top……………… 0
* Chamfer Bottom……….. 0
* RPM/SURFACE SPEED.. 1000 RPMS
* FEED PER REV…………… .003
* FIN CUT ……………………. .001
* FIN RPM…………………… 1000
* FIN FEED PER REV……. .003
* TOOL #....................... 2

Event #11: THREAD.

* X BEGIN……………………. .500
* Z BEGIN ……………………. .050
* X END………………………. .500
* Z END……………………….. -.600
* PITCH……………………….. .050
* DEPTH OF PASS……..... .005
* # OF SPRING PASSES… 2
* PLUNGE ANGLE……….. 29.5
* SIDE…………………………. OUTSIDE
* # OF STARTS…………….. 1
* RPM………………………... 155
* Tool #......................... 3