\_\_\_\_\_ Steps for CNC 2, Part 1:

Face the end of the stock manually

Use a #2 center drill for the live center

Reset stock – use live center

Set TOOL CHANGE REFERENCE POSITION so carriage does NOT collide with tailstock

Check coolant position at machining and tool change positions

Add the threading operation at the end of the imported program. It is to be programmed at the machine, not in FeatureCAM!

Check tool/tool post clearances to the tailstock, move carriages to each X, Z position

Trak each new tool through first cut

\_\_\_\_\_ All RPMs must be less than 2200.

\_\_\_\_\_ Use the proper nose radius when describing the tooling:

Right hand 55° tooling has a .031” radius

\_\_\_\_\_ Use the tailstock to drill all holes, NEVER cnc drill.

\_\_\_\_\_ Use SFM (surface feet per minute), except for grooving and threading operations.

\_\_\_\_\_ Tooling is set properly. Check tooling clearance with the tail stock.

\_\_\_\_\_ Correct post was used (Southwest).

\_\_\_\_\_ Correct tool library was used (COE Student Shop).

\_\_\_\_\_ Check tool path to make sure part shape is not violated by a rapid or machine move.

\_\_\_\_\_There should not be any nose radius in the tool table description.

\_\_\_\_\_ Rough pass increments for turning should be .050”.