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

Face the end of the stock manually

Drill ¾” hole through stock, if not already done

Bore the inside profile first, then the outside, for rigidity

Trak each new tool through first cut, except the finish boring operation

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

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

Right hand 55° tooling has a .031” radius

Small diamond shaped 80° boring bar tooling has a .015” radius

Small triangular shaped boring bar has a .015” 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.

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

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

\_\_\_\_\_ Use the diamond shaped insert for rough boring, the triangle shaped insert for finishing.

\_\_\_\_\_ 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”.

\_\_\_\_\_ Rough pass increments for boring should be .030”.