

<b>Part:</b> Cap	<b>Dwg #:</b> EX2-L1-DG1	<b>Rev:</b> A	<b>Date :</b> 2025
<b>Machine:</b> Leadwell	<b>Control:</b> Fanuc Oi	<b>Chuck:</b> 3-jaw	<b>Setup by:</b> TD
Prg #: 00032	Program: 2 of 2	Filename: EX2-L1-PG2-T	Program By: TD

Machining Operations	Tool Description	Tool /Off	R	T
<b>1: Rough Face</b> Ø1.875" +.005" on length				
<b>2: Rough Turn</b> Ø2.00" +.02" on diameter & -.005" on length	80° R/H turning tool C3-DCLNL-22040-09	01 01	.031	3
<b>3: Rough Turn</b> Ø1.875" +.02" on diameter & -.005" on length				
<b>4: Drill</b> Ø.75" hole to length	Ø.750" drill	10 10	—	—
<b>5: Rough Bore</b> Ø1.250" −.02" on diameter & −.005" on length				
<b>6: Rough Bore</b> Ø1.625" −.02" on diameter & −.005" on length	80° R/H boring tool C3-SCLCL-11065-09	02 02	.031	2
<b>7: Finish Face</b> Ø1.875"				
<b>8: Finish Turn</b> Ø1.875" to length	55° R/H turning tool C3-DDJNL-22045-11	03 03	.015	3
<b>9: Finish Turn</b> Ø2.00" to length				
<b>10: Finish Bore</b> Ø1.625" to length	55° R/H boring tool C3-SDUCL-11065-07	04	.015	2
<b>11: Finish Bore</b> Ø1.250" to length		04		

Work Offsets
G54 on X: 0"
G54 on Z: 1.75"

Material Setup
On Z: 1.875" from chuck jaw

Pre/Post Operations
Pre: See EX2-L1-SE1-T
Post: N/A

Chuck Jaw Setup	Tailstock
INFO ID	Pressure
U-2.75	200psi

Important Notes
1. Check material setup!
2: Check clearance between all tools and chuck jaws!
3: Regards <b>Chuck Jaw Setup</b> use <b>INFO ID</b> and jaw info table for setup data!
4: Adjust work offset shift to maintain 1.750" dimension!