

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

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

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	Pressure
U–2.75	200psi	–

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