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|--------------------------|--------------------------|-----------------------------|-----------------------|
| Part: Shaft | Dwg #: EX4–L1-DG2 | Rev: A | Date : 2025 |
| Machine: Leadwell | Control: Fanuc Oi | Chuck: 3-jaw | Setup by: TD |
| Prg #: 00031 | Program: 1 of 1 | Filename: EX4–L1–PG1 | Program By: TD |

| Machining Operations | Tool Description | Tool /Off | R | T |
|--|----------------------|------------------|----|----------|
| 1: Rough Face Ø33 +.5 on length | 80° L/H turning tool | 01 01 | .8 | 3 |
| 2: Rough Turn Ø39 +.5 on diameter & +.5 on length | | | | |
| Rough Turn Ø38 +.5 on diameter & +.5 on length | | | | |
| Rough Turn Ø33 +.5 on diameter & +.5 on length | | | | |
| 3: Finish Face Ø33 | 55° L/H turning tool | 03 03 | .4 | 3 |
| Finish Turn Ø33 to diameter and length | | | | |
| Finish Turn Ø38 to diameter and length | | | | |
| Finish Turn Ø39 to diameter and length | | | | |
| Finish Turn Ø53.98 to diameter and length | | | | |
| 4: Part Off | 0.125 parting tool | 05 05 | .2 | 3 |

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| Work Offsets |
| G54 on X: 0 |
| G54 on Z: 77.00 from chuck jaw |

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|----------------------------|
| Material Setup |
| On Z: 80.00 from chuck jaw |

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| Program Start/End |
| On X: 100 |
| On Z: 100 |

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

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| 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 73.00 dimension! |
| 5: Units are mm |