

Part: Cap	Dwg #: EX2-L1-DG1	Rev: A	Date : 2025
Machine: Leadwell	Control: Fanuc Oi	Chuck: 3-jaw	Setup by: TD
Prg #: 00031	Program: 1 of 2	Filename: EX2-L1-PG1-T	Program By: TD

Machining Operations	Tool Description	Tool /Off	R	T
1: Rough Face 2.750" +.005" on length	80° R/H turning tool C3-DCLNL-22040-09	01 01	.031	3
2: Rough Turn Ø2.750" +.02" on diameter & +.125" on length				
3: Finish Face Ø2.750"	55° R/H turning tool C3-DDJNL-22045-11	03 03	.015	3
4: Finish Turn Ø2.750" to length +.125"				

Work Offsets	Material Setup
G54 on X: 0"	On Z: 2" from chuck jaw
G54 on Z: 1.875"	

Pre/Post Operations	Chuck Jaw Setup	Tailstock
Pre: Cut as per drawing EX2-L1-DG1	INFO ID	Pressure
Post: See EX2-L1-SE2-T	J-3	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!