

Part Name: Cap	Drawing: EX2–L1-DG1	Revision: A
Material: Ø3" X 2" STEEL 12L14		Date: 2025
Machine: Leadwell	Control: Fanuc Oi	Prepared by: TD

O	Program # Prefix: O
0031	Program #: 0031

N2	Block #: 2
G20	Positioning: Inch
G40	Tool nose radius compensation: Cancel
G99	Feedrate: Distance/revolution

N4	Block #: 4
G50	Spindle: Maximum RPM
S2500	2500 RPM

N6	Block #: 6
T1	Tool select #: 1: 80° R/H turning tool
01	Compensation: Tool offsets # 01

N8	Block #: 8
G96	Spindle: Constant surface speed
S400	Spindle: Speed 400 FPM
M4	Spindle: Counter-Clockwise

N10	Block #: 10
G0	Positioning: Rapid
G54	Part zero selection: One
X5.	Positioning on X axis: X5.
Z5.	Positioning on Z axis: Z5.
M8	Coolant: On

N12	Block #: 12
X3.2	Positioning on X axis: X3.2
Z.1	Positioning on Z axis: Z.1

N14	Block #: 14
G94	Cycle: Facing
X–.1	Positioning on X axis: X–.1
Z.005	Positioning on Z axis: Z.005
F.005	Feedrate: .005 IPR

N16	Block #: 16
G0	Positioning: Rapid
X3.	Positioning on X axis: X3.

N18	Block #: 18
G90	Cycle: Turning
X2.8	Positioning on X axis: X2.8
Z–.625	Positioning on Z axis: Z–.625
F.01	Feedrate: .01 IPR

N20	Block #: 20
X2.77	Positioning on X axis: X2.77

N22	Block #: 22
G0	Positioning: Rapid
X5.	Positioning on X axis: X5.
Z5.	Positioning on Z axis: Z5.
M9	Coolant: Off

N24	Block #: 24
T1	Tool select #: 1: 80° R/H turning tool
00	Compensation: Cancel
M5	Spindle: Stop

N26	Block #: 26
M1	Program: Optional stop

N28	Block #: 28
G50	Spindle: Maximum RPM
S3000	3000 RPM

N30	Block #: 30
T3	Tool select #: 3: 55° R/H turning tool
03	Compensation: Tool offsets # 03

N32	Block #: 32
G96	Spindle: Constant surface speed
S400	Spindle: Speed 400 FPM
M4	Spindle: Counter-Clockwise

N34	Block #: 34
G54	Part zero selection: One
X2.87	Positioning on X axis: X2.87
Z.05	Positioning on Z axis: Z.05
M8	Coolant: On

N36	Block #: 36
G94	Cycle: Facing
X-.1	Positioning on X axis: X-.1
Z0.	Positioning on Z axis: Z0.
F.003	Feedrate: .003 IPR

N38	Block #: 38
G0	Positioning: Rapid
X2.6	Positioning on X axis: X2.6

N40	Block #: 40
G1	Positioning: Linear
X2.75	Positioning on X axis: X2.75
Z-.025	Positioning on Z axis: Z-.025
F.005	Feedrate: .005 IPR

N42	Block #: 42
Z-.625	Positioning on Z axis: Z-.625

N44	Block #: 44
X2.77	Positioning on X axis: X2.77

N46	Block #: 46
G0	Positioning: Rapid
Z.05	Positioning on Z axis: Z.05

N48	Block #: 48
X5.	Positioning on X axis: X5.
Z5.	Positioning on Z axis: Z5.
M9	Coolant: Off

N50	Block #: 50
T3	Tool select #: 3: 55° R/H turning tool
00	Compensation: Cancel
M5	Spindle: Stop

N52	Block #: 52
G28	Reference position: Return to
U0.	Positioning on X axis from: U0.
W0.	Positioning on Z axis from: W0.

N54	Block #: 54
M30	Program: End