

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				
2: Rough Turn Ø39 +.5 on diameter & +.5 on length	80° L/H turning tool	01 01	.8	3
Rough Turn Ø38 +.5 on diameter & +.5 on length				
Rough Turn Ø33 +.5 on diameter & +.5 on length				
3: Finish Face Ø33				
Finish Turn Ø33 to diameter and length	55° L/H turning tool	03		
Finish Turn Ø38 to diameter and length		03	.4	3
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

Work Offsets	Material Setup
G54 on X: 0	On Z: 80.00 from chuck jaw
G54 on Z: 77.00 from chuck jaw	

Program Start/End	Chuck Jaw Setup	Tailstock
On X: 100	INFO ID	Pressure
On Z: 100	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 73.00 dimension!
5: Units are mm