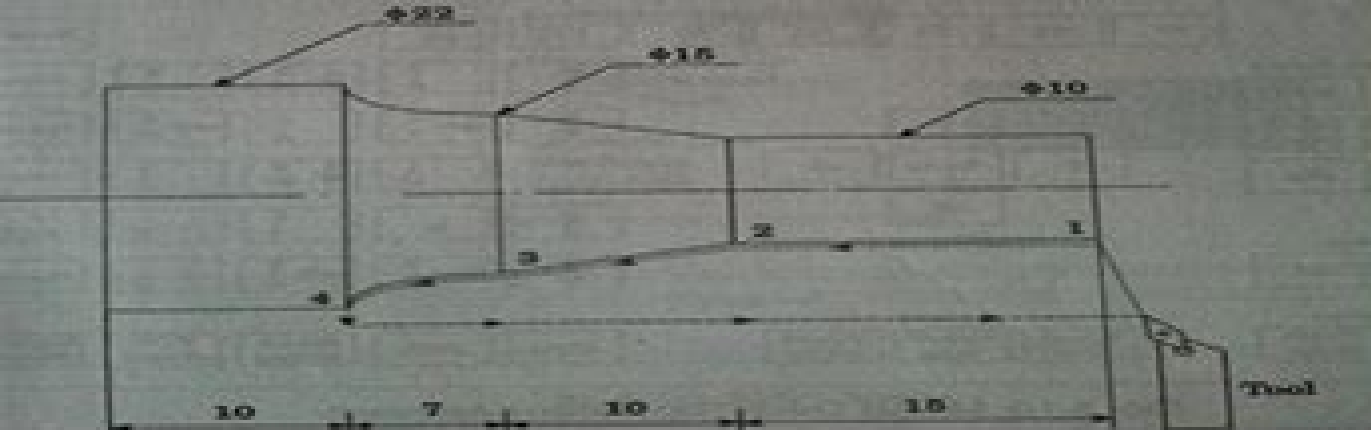




|                              |                                                                                                                                     |
|------------------------------|-------------------------------------------------------------------------------------------------------------------------------------|
| O000                         | Programmer number                                                                                                                   |
| BILLET X23 Z45               | Billet size                                                                                                                         |
| N10 G21 G98                  | Feed & depth of cut in MKS units                                                                                                    |
| N20 G28 U0 W0                | Tool post home position                                                                                                             |
| N30 M06 T0202                | Tool number                                                                                                                         |
| N40 M03 S1200                | Speed of the spindle                                                                                                                |
| N50 G00 X23 Z2               | Rapid feed to start position                                                                                                        |
| N60 G71 U0.25 R1             | Multi turning operation, 0.25 depth of cut, 1 mm tool retraction, 0.1 mm finishing allowance, 60 mm/min feed, from line N60 to N130 |
| N70 G71 P80 Q120 U0.1 W0 F60 |                                                                                                                                     |
| N80 G01 X10                  | Linear motion of the tool                                                                                                           |
| N90 G01 X10 Z-15             |                                                                                                                                     |
| N100 G01 X15 Z-25            |                                                                                                                                     |
| N110 G03 X22 Z-32 R7         | Counter clockwise arc X22                                                                                                           |
| N120 G01 X22 Z-42            |                                                                                                                                     |
| N130 G70 P60 Q120            | Finishing cycle                                                                                                                     |
| N140 G28 U0 W0               | Home position for the tool post                                                                                                     |
| N150 M05                     | Spindle stop                                                                                                                        |
| N160 M30                     | END OF THE PROGRAMME                                                                                                                |

Example for Drilling

# Lathe Machine Experiment Manual

**Zhe Xu**



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