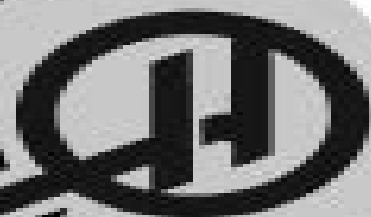


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Lisa Keenan-Lindsay, Gloria Leifer



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manufacturers could not make complex profiles or shapes with high accuracy As a result the production rate tended to be slow production costs were very high rejection rates were high and manufacturers often could not complete tasks on time Industry was boosted by the introduction of the semi automatic manufacturing machine known as the NC machine which was introduced in the 1950 s at the Massachusetts Institute of Technology in the USA After these NC machine started to be used typical profiles and complex shapes could get produced more readily which in turn lead to an improved production rate with higher accuracy Thereafter in the 1970 s an even larger revolutionary change was introduced to manufacturing namely the use of the CNC machine Computer Numerical Control Since then CNC has become the dominant production method in most manufacturing industries including automotive aviation defence oil and gas medical electronics industry and the optical industry Basics of CNC Programming describes how to design CNC programs and what cutting parameters are required to make a good manufacturing program The authors explain about cutting parameters in CNC machines such as cutting feed depth of cut rpm cutting speed etc and they also explain the G codes and M codes which are common to CNC The skill set of CNC program writing is covered as well as how to cut material during different operations like straight turning step turning taper turning drilling chamfering radius profile profile turning etc In so doing the authors cover the level of CNC programming from basic to industrial format Drawings and CNC programs to practice on are also included for the reader

The Well-Trained Mind Susan Wise Bauer, Jessie Wise, 2016-08-09 Is your child getting lost in the system becoming bored losing his or her natural eagerness to learn If so it may be time to take charge of your child s education by doing it yourself The Well Trained Mind will instruct you step by step on how to give your child an academically rigorous comprehensive education from preschool through high school one that will train him or her to read to think to understand to be well rounded and curious about learning Veteran home educators Susan Wise Bauer and Jessie Wise outline the classical pattern of education called the trivium which organizes learning around the maturing capacity of the child s mind and comprises three stages the elementary school grammar stage when the building blocks of information are absorbed through memorization and rules the middle school logic stage in which the student begins to think more analytically and the high school rhetoric stage where the student learns to write and speak with force and originality Using this theory as your model you ll be able to instruct your child whether full time or as a supplement to classroom education in all levels of reading writing history geography mathematics science foreign languages rhetoric logic art and music regardless of your own aptitude in those subjects Thousands of parents and teachers have already used the detailed book lists and methods described in The Well Trained Mind to create a truly superior education for the children in their care This extensively revised fourth edition contains completely updated curricula and book lists links to an entirely new set of online resources new material on teaching children with learning challenges cutting edge math and sciences recommendations answers to common questions about home education and advice on practical matters such as standardized testing working with your

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