Live Tooling Lathe- Project 1



**Project 1 Overview**



Outcomes:

1. Successfully set the tool offsets manually for 328-1
2. Successfully set load, set-up, and offset both a Radial and Axial Live Tool Holder
3. Successfully load the O03281 program
4. Successfully Dry Run the part
5. Successfully produce a part to print tolerances

Topis Covered:

* Radial Tool Set-up and Offsets
* Axial Tool Set-up and Offsets

Suggested Tool List:

* T8- Axial tool holder w/ ½ endmill
* T10- Radial tool holder w/ ½ endmill

Suggested Jaws:

* Hard jaws

PRZ:

* Z- Front Face of Part
* X- Centerline of Part

**Main Program for the Part**

%

O03281

(MILL 1.00 SQUARE WITH RADIAL TOOLHOLDER)

G0 G40 G80

T1010 (RADIAL TOOL W/ ½ E.M.)

G19

G98

M154

G0 G54 C0. Y-1.0 X1.0 Z.1

G97 P1500 M133

M98 P3288

C90.

M98 P3288

C180.

M98 P3288

C270.

M98 P3288

M135

M155

M09

G53 Y0.

G53 X0. Z0.

G18 G99

M01

(MILL .750 SQUARE WITH RADIAL TOOLHOLDER)

G0 G40 G80

T808(AXIAL TOOL W/ ½ E.M.)

G17

G98

M154

G97 P2000 M133

G0 G54 C0. Y1.0 X1.25 Z1.

Z.1

M98 P3289

C90.

M98 P3289

C180.

M98 P3289

C270.

M98 P3289

M135

M155

G53 Y0.

G53 X0. Z0.

G18

G99

M30

%

**Sub Program for Radial Tool**

%

O03288

M14

G01 Z-.250 F15.

G1 Y1.0 F15.

G0 X1.5

Y-1.0

X1.0 M15

M99

%

**sub program for the axial tool**

%

O03289

M14

G01 Z-.125 F15.

Y-1.

G00 Z.1

Y1.

M15

M99

%