

HAAS PROGRAMMER COURSE OUTLINE LATHE

I. Power up defaults

- A.) G00 - Rapid
- B.) G18 - Plane selection X,Z
- C.) G40 - Cancel Cutter Compensation
- D.) G80 - Canned Cycle Cancel
- E.) G99 - Feed per Revolution

II. Program Structure

- 1.) Introduction
- 2.) Body
- 3.) Ending

III. Stock Removal

1. Rough Turning / Boring

A.) G71 Roughing

- 1.) D - Depth of Cut
- 2.) P - Starting Block of Path
- 3.) Q - Ending Block of Path
- 4.) U - X axis Finish Stock amount
- 5.) W - Z axis Finish Stock amount

B.) G73 "Casting / Forging"

- 1.) D - Number of Passes
- 2.) P - Start Block
- 3.) Q - Ending Block
- 4.) U - X axis Finish Stock Amount
- 5.) W - Z axis Finish Stock Amount

2.) Finishing

A.) G70

- 1.) P - Starting Block
- 2.) Q - Ending Block

IV. Drilling

- 1.) Drilling - G81
- 2.) Peck Drilling - G83

V. Cutter Compensation

- 1.) G41 - Left
- 2.) G42 - Right
- 3.) G40 - Cancel Cutter Compensation

VI. Threading

- 1.) G76 - Multiple Pass Threading
 - A.) D - First Depth of Cut
 - B.) K - Thread Height
 - C.) Z - Finish Length of Thread
 - D.) F - Feed Rate (Pitch of Thread)
 - E.) Use of M24