Student Name: ID No.:

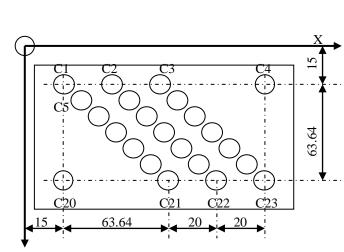
Sheet (1) CNC M/C Tools Turn Points

Get the turn points for the following WP.

1)		
Pi	X _i	Y _i
C1		
C2		
C3		
P _i C1 C2 C3 C4 C5 C6		
C5		
C7		
C8		
C9		
C10		
C11		
C12		
C13		
C14		
C15		
C16		
C17		
C18		
C19		
C20		
C21		
C22		
C23		

Design and Production Department MDP 471: Numerical Control Machine

Date: Sec No:

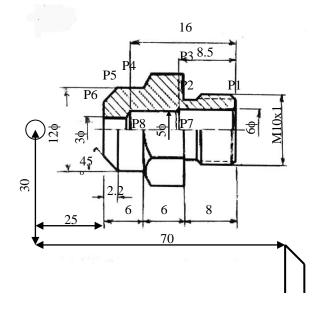


Hole to hole center distance is 15mm

-Y

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2)			
Pi	Xi	Zi	
P1			
P2			
P3			
P4			
P5			
P4 P5 P6			
P7			
P8			

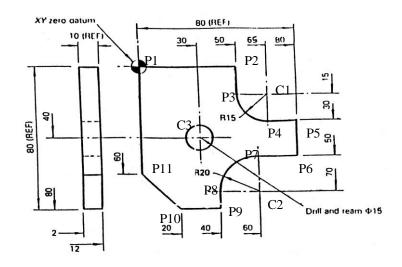


2 Dr Mohamed L. Zamzam Sheet (1)

3)			
Pi	X _i	Y _i	
P1			
P2			
P3			. 64
P4			
P5			
P6			
P7			
P8			<u>⊼</u> ▲ 01
P9			
P10			
P11			$R5 \qquad 64 \qquad 64$
P12			
P13			
P14			
P15			
P16			P13
C1			
C2			
C3			
C4			
C5			P9 0
C6			P4 P3
C7			
C8			т Fig. –1-
C9			-

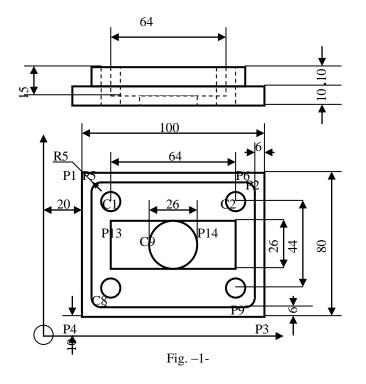
4)

Pi	X _i	Y _i
P1		
P2		
P3		
P4		
P5		
P6		
P7		
P8		
P9		
P10		
P11		
C1		
C2		
C3		



Section Work:

It is required to drill the 4 corner holes (C1, C2, C3, C4) with 8mm diameter on CNC machine center. Wright the required part program with a suitable machining condition given that the work piece alloy is Al-Si alloy and the machined W.P. surface is 180mm below Z zero



5 Dr Mohamed L. Zamzam Sheet (1)