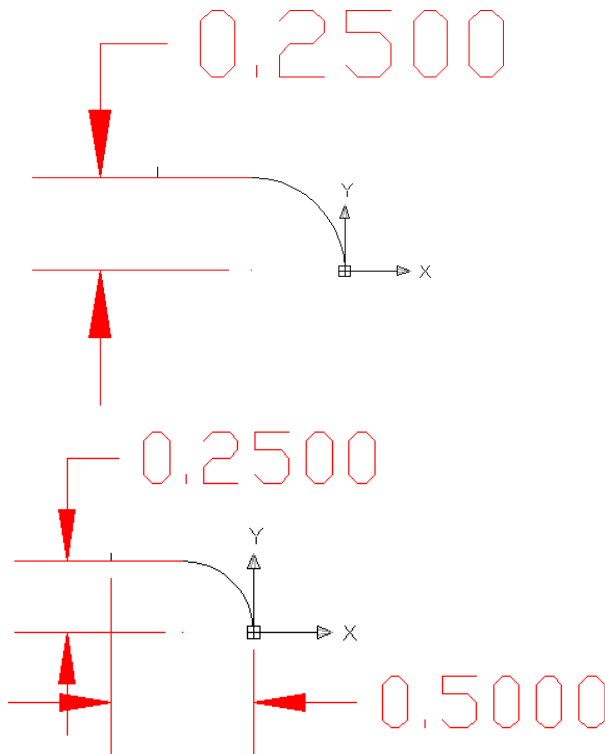
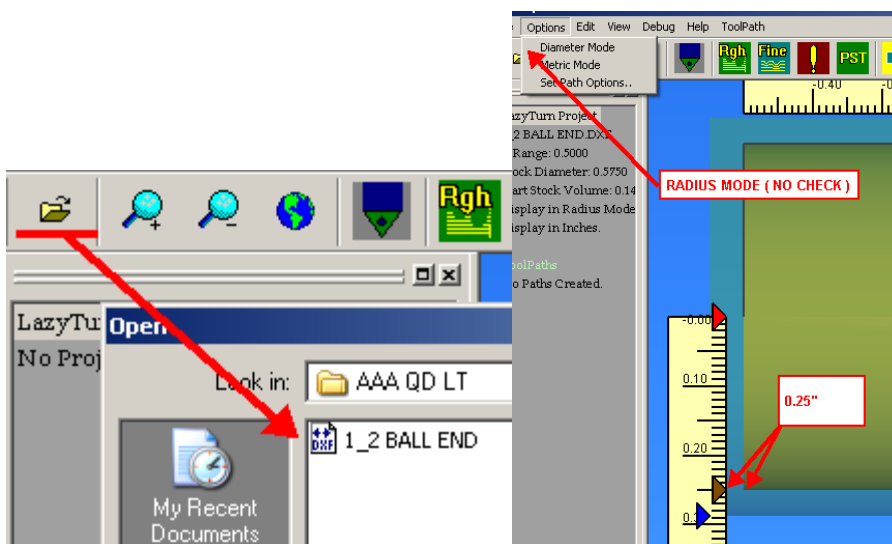


QUICK AND DIRTY LAZYTURNTURN

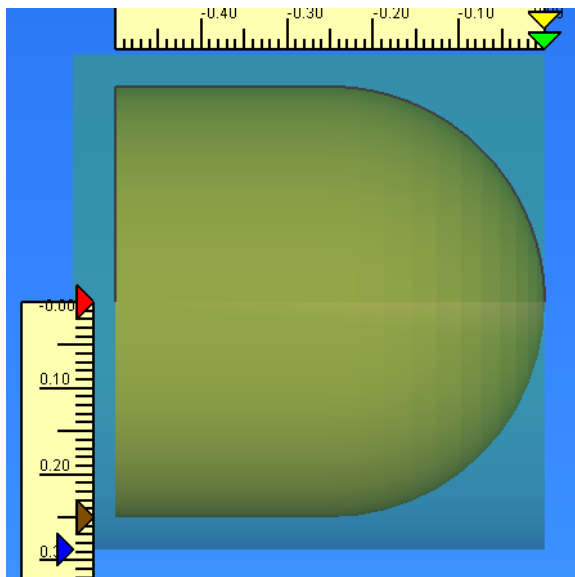
1. A drawing is made in CAD and exported as a version 12 DXF. The following shows a drawing for making a ball on the end of a 1/2" diameter piece. Note that the radius is 0.25".



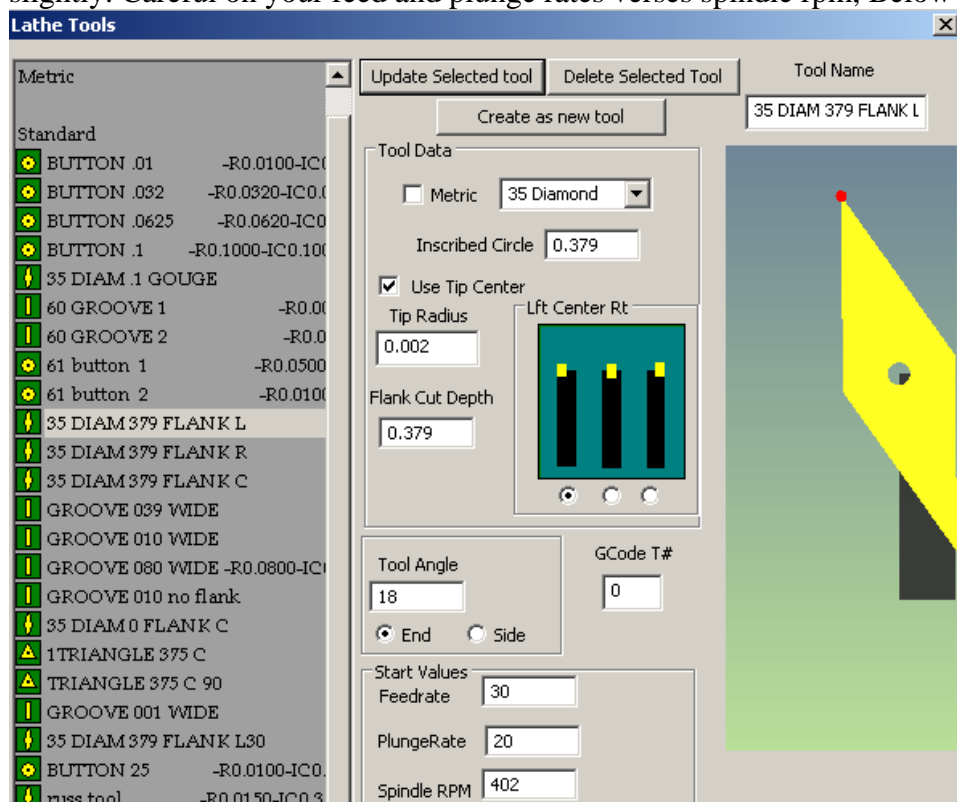
2. Run LazyTurn and open the DXF drawing. Note you draw, import, export, and machine in radius mode.



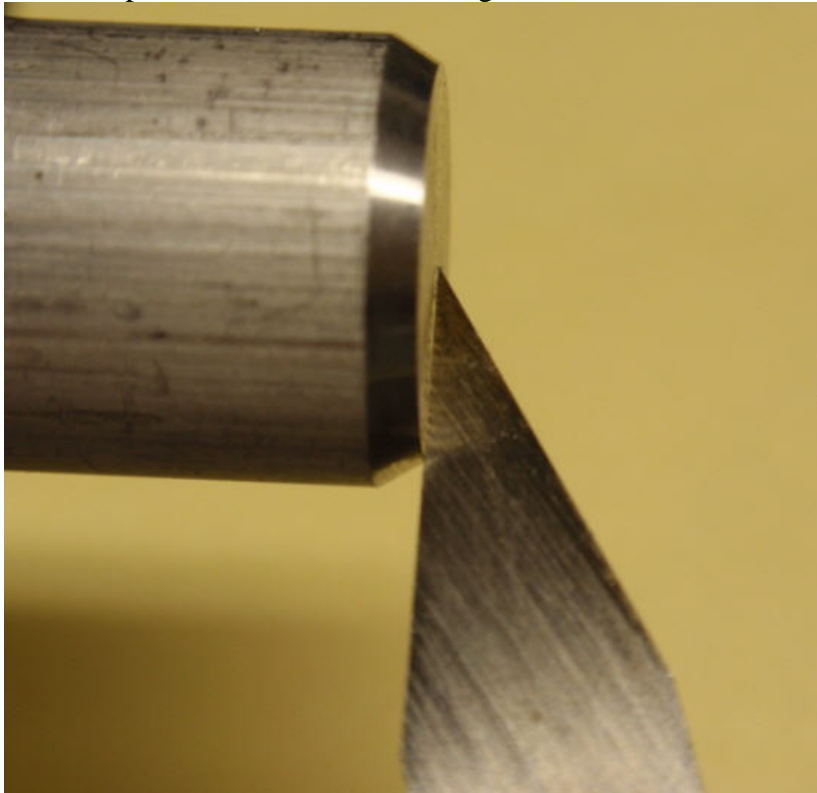
3. Here is the billet shown after being imported by LazyTurn.



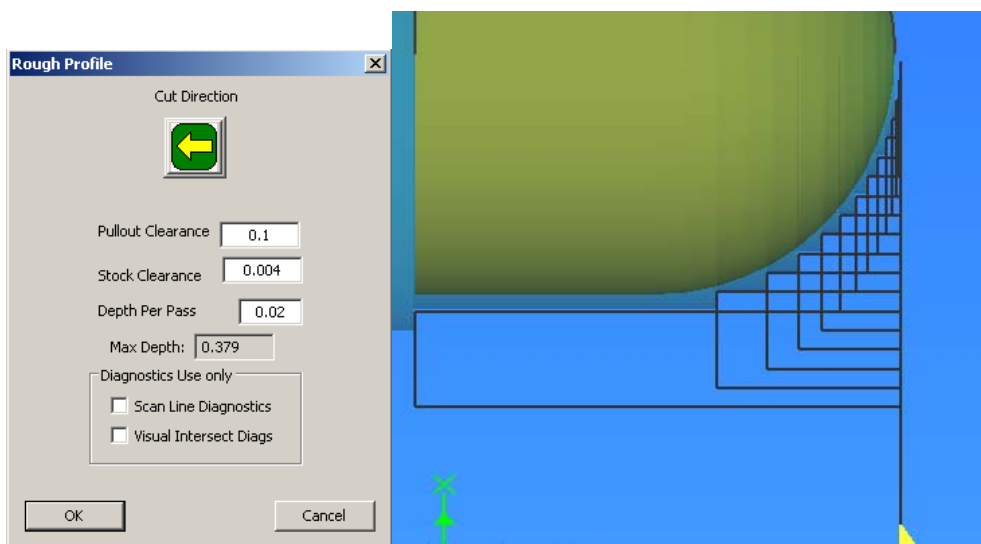
Select a roughing tool from the Lathe Tool Table. If none is shown you will need to create one. The following 35 diamond tool will be used. Note that the tool is rotated slightly. Careful on your feed and plunge rates verses spindle rpm, Below is not practical!



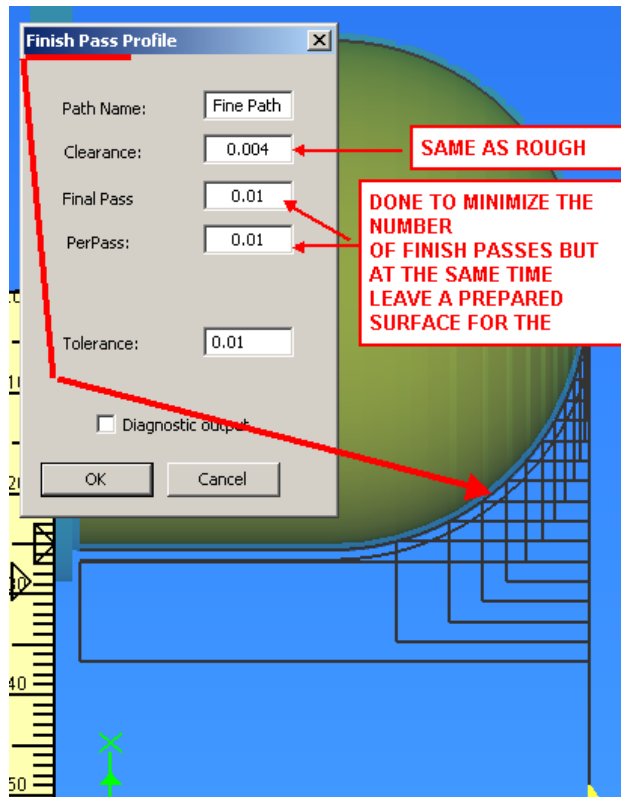
Here is a picture of the actual tool aligned to X & Z=0 on the billet.



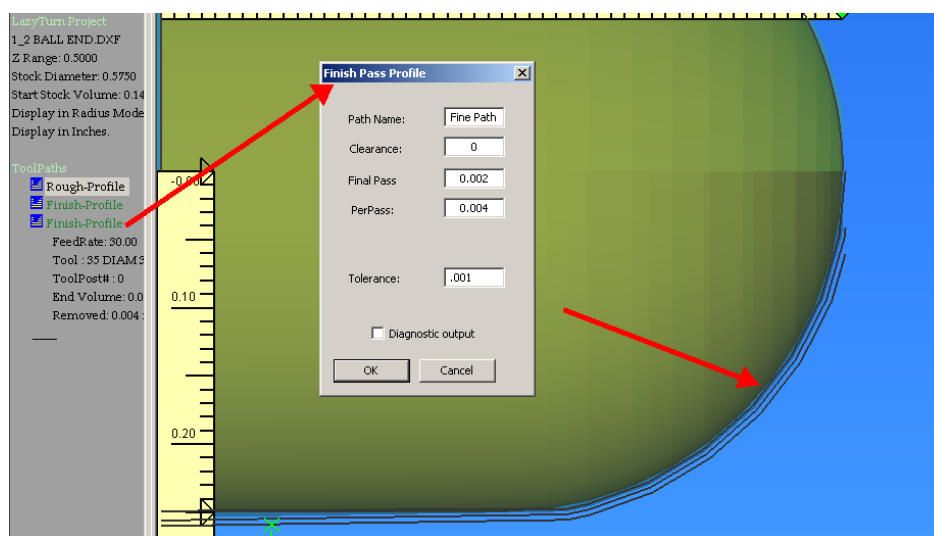
5. A rough pass will be made to quickly remove the bulk of the material. The created pathing is shown to the right.



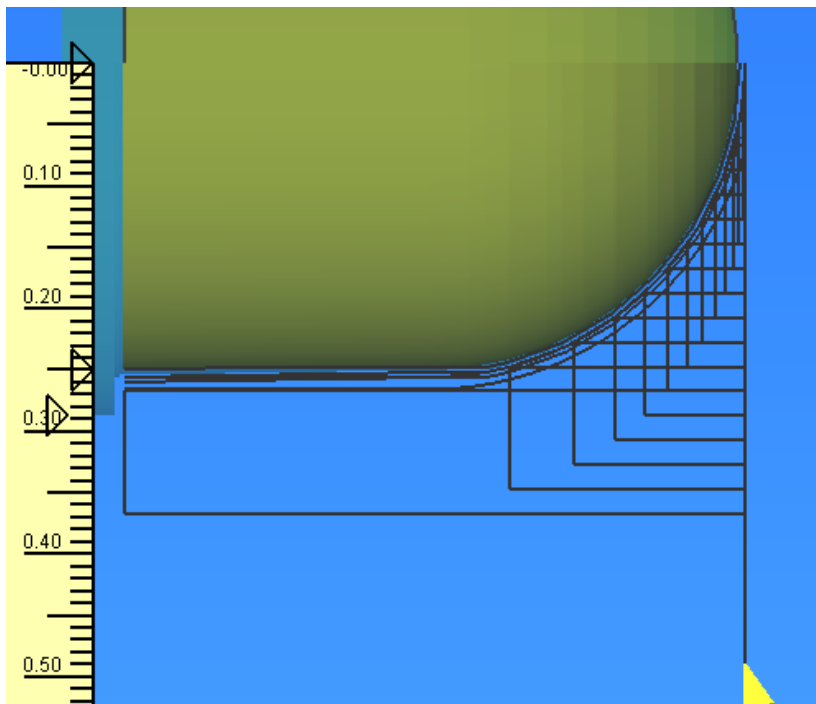
6. A finish pass will now be done to smooth out the rough notches left around the ball by the rough pass. The passes are selected to minimize the number of finish passes created.



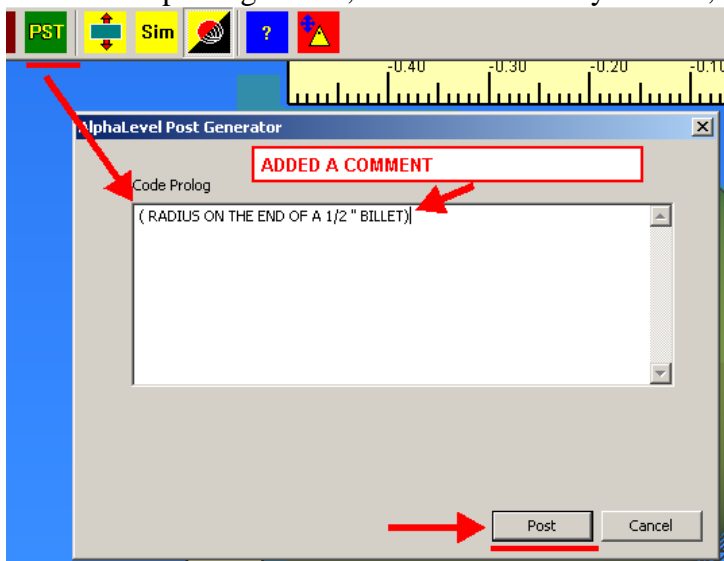
Another finish cut is done cut with finer settings. Note the tolerance increase. (.000? would have been better)



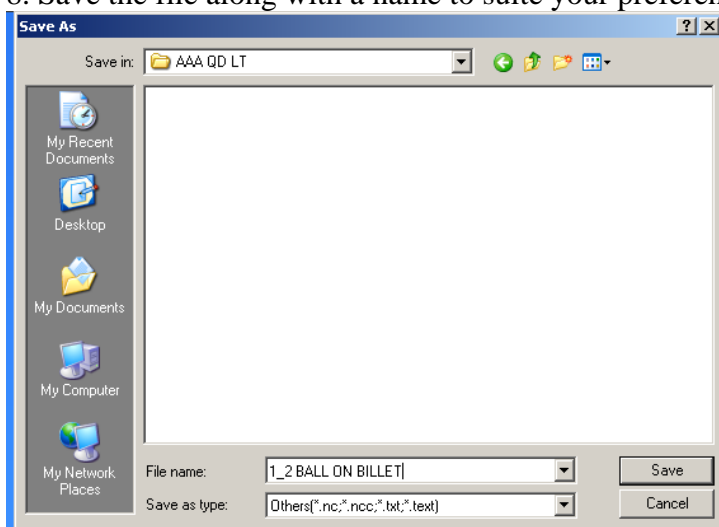
With all the pathing now created the file is posted for cutting in Mach3 turn. Here is a picture of all the pathing which will be done.



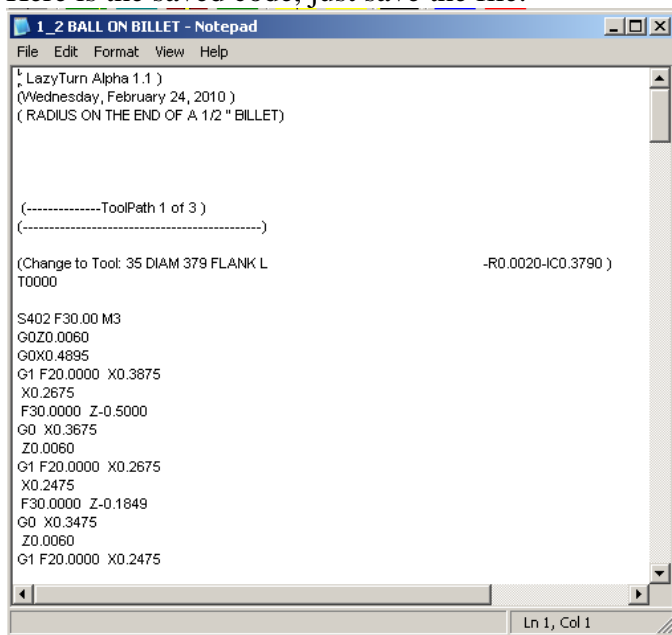
7. Click the posting button, add comments as you wish, and click post.



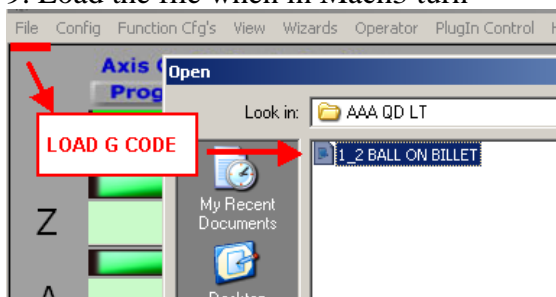
8. Save the file along with a name to suite your preference.



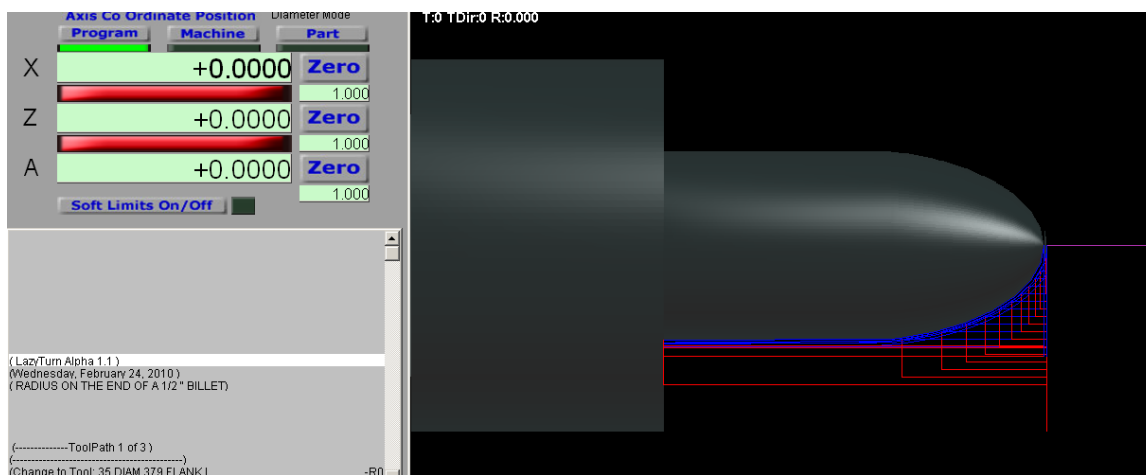
Here is the saved code, just save the file.



9. Load the file when in Mach3 turn



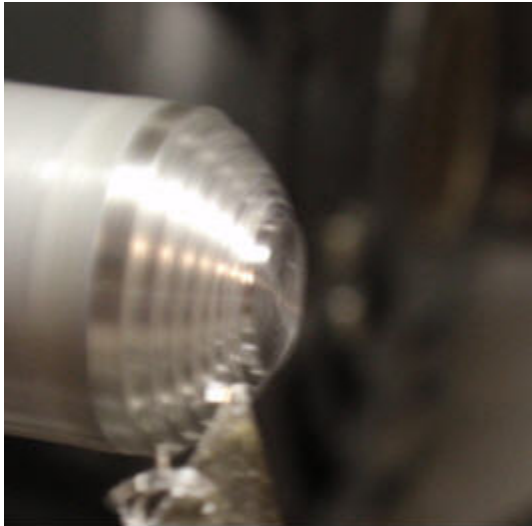
Here is the file loaded into Mach3 Turn.



I will have additional comments relative to Mach3 Turn.

LATER ON!

Here is the turned piece.



ROUGHING



1ST FINISH



2ND FINISH



COMPLETED BALL END