Turning – Internal Boring 3 Pass Method

- Machine <u>Haas TL 1</u>
- Material 4140 Alloy Steel (CMC 2.1)
- Start Vc = 300 , Ap = .040", Fn = .006
- Tool Holder A570 3C D12 10-20 CR
 - (10 X Dampened Carbide Reinforced Bar)
- Cutting Head 570-SDUCR 20-11
- Insert DCMT 32.52 PM 4325







6. Use of the product

3-pass method

Method for achieving high accuracy in internal turning with slender boring bars where the deflection of the bar affects the obtained diameter.

Example:

1:	Enter the desired finished dia	40.000	
2:	Measure the dia before the first pass	37.000	
3:	Run the first pass. The programmed dia is:		
	37.000 + (40.000 - 37.000) / 3 = 38.000		
4:	Measure the dia before second pass:	37.670	
5:	Run the second pass. The programmed dia is:		
	38.000 + (40.000 - 37.670) / 2 = 39.165		
6:	Measure the dia before third pass:	38.825	
7:			
••	Run the third pass. The programmed dia is:		
	Run the third pass. The programmed dia is: 40.000 + 39.165 - 38.825 = 40.340		
8:	Run the third pass. The programmed dia is: 40.000 + 39.165 - 38.825 = 40.340 Measure the final dia:	40.020	
8:	Run the third pass. The programmed dia is: 40.000 + 39.165 - 38.825 = 40.340 Measure the final dia: Deviation:	40.020	

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Template for 3-pass method

Copy this template and fill in your own values to make a 3-pass calculation.

Template:

