

Okuma

Factory Training

for

Fundamental Programming and Operation of 2 Axis Lathes

Course Code : TC501
Prerequisite : None
Credits : 0
Course length : 5 days
Class Size : 6 persons

COURSE OBJECTIVES - Upon completion, the individual will be proficient in all basic skills necessary to allow the functional / productive operation of the machine tool, and associated safety practices.

The course is aligned to providing the knowledge and skills required to "translate" the part drawing into a finished product. The individual will be capable of defining the list of required processes, their logical / optimum sequence, create the complete CNC part program, install the appropriate tools correctly, establish the program zero point, and perform corresponding tool offsets.

Course emphasis is a blend of classroom instructional theory, time spent on the machine tool, and individually displayed skills.

Comprehension of the topics is measured by both actual demonstration and an exam.

COURSE REGISTRATION - please contact *Von Pickett* at (803-981-7000) the Institute for Manufacturing Productivity to obtain program availability dates, or check our website <http://imp.okuma.com>

TC501 Course Outline

Monday

- Introductions
- Course Objectives
- Overview of lathes - major components and terminology
- Basic workholding methods and cutting tools
- Machine axes - unit systems - coordinate systems
- Tool path Illustrations
- Program words - S, T, M, G, F, format lists
- Linear and Circular Interpolation
- Basic CNC Program Example - Absolute/Incremental
- Tool Nose Radius Compensation Function
- Create Part Program per print and Debug
- Day's Review

Tuesday

- Q & A on previous day
- Today's Objectives
- Programming Structure/Format Options
- Fixed and Non Fixed Compound/Canned Cycles
- Drilling, Grooving, Threading Routines
- OSP LAP3/LAP 4 Auto Program Function - G85 & G87
- Program Creation and Review
- User Task I & II overview / comparison
- Programs using CALL Statements
- Use of Common Variables
- Create Part Programs per print and Debug
- Safety issues in program creation
- Day's Review

Wednesday

- Q & A on previous day
- Today's Objectives
- OSP LAP3/LAP 4 Auto Program Function - G83, G84, G86, G88
- Using M00, M01, and Block Delete in programs
- Constant Surface Speed - charts & formulas
- Program flexibility - Local Variables
- Main Spindle - ranges, horsepower, and nomograms
- Basic Barfeed Program
- Schedule Data File Programming

- Graphic Animation Commands
- Create Part Program to use at machine
- Day's Review

Thursday

Note: the balance of instructional time will be at the machine

- Q & A on previous day
- Today's Objectives
- Using machine manuals
- OSP 5020L / 7000L / 700L - CNC Control
- OSP Control Modes - Manual, Edit, Parameter, Zeroset
- OSP Tool Data Mode / Offset Registers
- OSP MS DOS Function (OSP 7000/700 only)
- OSP Mac Man Overview (condensed)
- Operation Panel
- Control Modes - MDI, Auto
- Upload program by Disk & or RS232C Serial Port
- Machine Operation Safety
- Zero Set Procedure
- Machine Lock & Dry Run Program Execution
- Graphic Simulation Function
- Single Block 1st piece
- Day's Review

Friday

- Q & A on previous day
- Today's Objectives
- Completion of machined parts
- Program restart function
- Open Discussion
- Student Evaluation and Test
- Review of Test
- Certificates
- Overview of common lathe options
- View Video Case Studies (if time allows)
- Dismissal (typically at Noon)

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COURSE MATERIALS

OTI will utilize an array of materials to assure the most effective means of material presentation. Most typically, routine presentation devices will include overhead projector, VCR & monitor. In addition, an OSP simulator will reside in the active classroom, allowing for a immediate means of graphic reinforcement to the learning process/subject.

Upload/downloading of part programs will be done using laptop computers, and either Procomm, or Windows Terminal communication software; and either Disk Drive (on 7000L / 700L), or by RS232C port.

For those classes requiring the use of PC's, Okuma will provide an independent workstation for each attendee.

Attendees will be furnished with all appropriate manuals, handbooks, examples, etc. - in short, those constructive reference material that correlate to the course content and its ultimate goals.

Additional copies of course materials are available, and can be obtained by contacting your local Okuma distributor. Charges will be appropriately based on the actual material(s) being sought.

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PRE ATTENDANCE EVALUATION

Course Code : TC501

Prerequisite : None

Credits : 0

Course length : 5 days

Class Size : 6 persons

Name _____

Company _____

Okuma Distributor _____ Class Date Requested _____

Have you ever attended any course offerings at Okuma?.

Please list the current Okuma equipment at your present facility ?.

Of the above list, what has **your Okuma experience** been todate ? - I.e. setup, operator, processing, etc..

What other related CNC machinery have you operated; or are familiar with its general operation, and programming format ?

Do you have any technical training that is related to CNC machine tools ? If so, please list.

In your daily job responsibilities, please check all that apply:

- | | | |
|--|---|--|
| <input type="checkbox"/> tooling selection | <input type="checkbox"/> program creation | <input type="checkbox"/> machine setup |
| <input type="checkbox"/> process editing | <input type="checkbox"/> production runs | <input type="checkbox"/> inspection |

What specific skill(s) do you wish to strengthen by attending the attached course. Please list in the order of importance - (1-5).

- | | | |
|---|---|--|
| <input type="checkbox"/> Machine safety | <input type="checkbox"/> setup techniques | <input type="checkbox"/> manual operations |
| <input type="checkbox"/> CNC program creation | <input type="checkbox"/> tool path/layout | <input type="checkbox"/> other _____ |

Check **all** that apply; - I am familiar with:

- | | | |
|--|--|--|
| <input type="checkbox"/> interpreting blueprints | <input type="checkbox"/> basic measuring tools | <input type="checkbox"/> basic math |
| <input type="checkbox"/> angular measurement | <input type="checkbox"/> geometry | <input type="checkbox"/> trigonometry |
| <input type="checkbox"/> tool selection | <input type="checkbox"/> materials knowledge | <input type="checkbox"/> speed/feeds |
| <input type="checkbox"/> chucking methods | <input type="checkbox"/> inspection methods | <input type="checkbox"/> stat. process control |

For what **specific machine model** is training being sought ?

What, if any, **specific topics** are *not* listed in the attached course outline that you feel are *critical* for your complete satisfaction in attending **this** course.

☺ Thank you for completing the above questions. These responses will assist Okuma to better evaluate your needs/expectations regarding the attached course offering.

Other:

The Okuma Institute for Manufacturing Productivity has a dress attire as follows:

Men Sports shirts or other with collar
Casual or Dress slacks
No bluejeans, shorts, T shirts, or sneakers

Women
Shirt or blouse with collar
Dress slacks, shirts or dresses
No bluejeans, shorts, sandals

Safety glasses are required when in the showroom / shop areas, and are supplied at no charge.

Lunch is provided for students attending classes. Students eating lunch off campus are to refrain from alcohol consumption due to safety regulations.