Program for CNC Keyway Broaching

For HAAS CNC 2 axis lathe

**Try using this format to reduce programming time.
Just enter your broach information in the highlighted fields shown.**

(You must enter the values for your tool and part information correctly)

```
%
O1234 (HAAS 2 AXIS LATHE BROACH SAMPLE)
G28 U0 W0

T0101 (ENTER BROACH TOOL NUMBER HERE, IE.. T5 =T0505)

M05
M19

G00 X1.0 Z.5 (X= BORE SIZE, Z=STARTING POSITION OF TOOL)

M08

(NO DECIMAL ON L)
M97 P100 L130 (L= NUMBER OF PASSES MUST BE DIVISIBLE BY D.O.C. )

G00 G99 Z1.0 M09
G28 U0 W0
M30

N100
G00 U.001 ( U IS D.O.C.)

G01 G98 Z-1.0 F100. ( Z = END OF TOOL POSITION, F = FEED IMP )
G00 U-.250
Z.5
U.250
M99
%
```