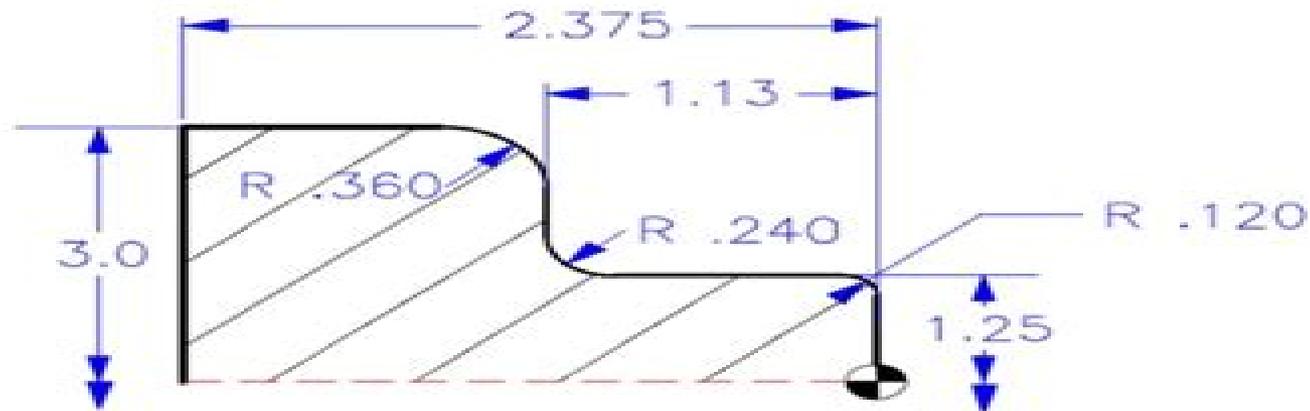


## Circular Interpolation Calculation

Manually calculate compensation for a lathe tool with a .031 TNR to machine a radius on your part.



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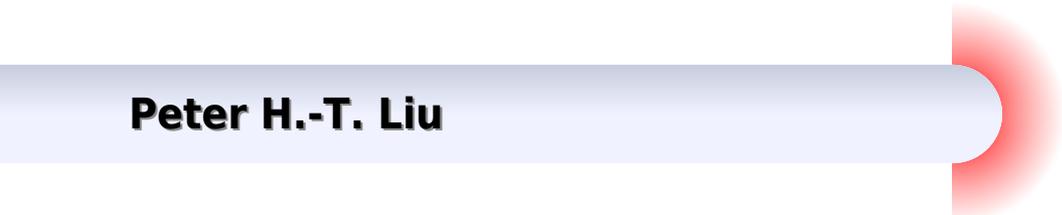
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O0102
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T101
G97 S1200 M03
G54 G00 X.92 Z.05
G01 Z0. F.01
X.948 F.006
G03 X1.25 Z-.151 I0. K-.151
G01 Z-.921
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G03 X3. Z-1.521 I0. K-.391
G01 Z-2.375
G00 U.01 Z1.0
G28
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### Manual Programming A Radius (G02 & G03 using R)

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O0103
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G54 G00 X.92 Z.05
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G03 X1.25 Z-.151 R.151
G01 Z-.921
G02 X1.668 Z-1.13 R.209
G01 X2.218
G03 X3. Z-1.521 R.391
G01 Z-2.375
G00 U.01 Z1.0
G28
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# Haas Lathe Programming

**Peter H.-T. Liu**



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