CNC Turning Rules

1. The total time for the contest is
    Session #1 - 8:30 am to 12:00 pm
    Lunch 12:00 pm – 12:45 pm
    Session #2 12:45 pm – 2:30 pm

2. Every contestant will be provided a basic program that is intentionally flawed. Contestant may choose to use that program or develop their own program.

3. All of the required single point tools are already loaded in the CNC Lathe. These are:
    - 55 degree OD turning tool
    - Threading tool
    - .093 wide grooving tool
    - .250" boring bar
    - .250" drill

4. At every tool change you must include a G0 G28 to clear the turret from the spindle to avoid collisions

5. You must not exceed 1500 RPM.

6. Your feeds must be safe and will be determined if so, by the judge

7. A judge will run your part on the CNC Lathe. The completion of the part **is not the responsibility** of the contestants. But, judges will determine of your submitted program will actually complete your part. Judges can refuse to run if they believe there are errors or dangers.

8. You can check your program on a simulator or on the CNC lathe. Your program will immediately be deleted after leaving either.

9. Safety glasses must be in place when entering the machine area. You do not need them in the computer room.

10. YOU MAY NOT USE YOUR CELL PHONE FOR ANY PURPOSE.

11. If you require any tools or supplies, ask the contest facilitator.

12. If you do not know how to solve a problem in a program or on the machine, the judge may help you with a minor problem. But if you are completely at a loss on what to do, the judge cannot help you.

13. During lunch students must stay in the shop during lunch time.

14. Students must ask the judge to use the bathroom. The student must surrender their cell phone.

15. Students **CAN NOT** speak to each other during the contest.