

Full name:



Listen to the audios 1 and 2. Then drag each phrasal verb where is appropriated.



IN-DEPTH-STUDY COURSE

Greetings dear apprentice.

Welcome to your in-depth-study course of your new lathe. In this course you will _____ the different functions that this lathe can _____ and how some of its parts operates.

It is worth observing that many of these operations can be dangerous or deadly if you don't have the necessary knowledge or skills to operate this machine. If at any time you are _____ difficulties performing any operation, _____ the machine ____! Above all, your safety must come first!



out



cut



find out about



going through



carry out



Audio 2

CSS SYSTEM

This lathe is equipped with a CSS (Constant Surface Speed) system that _____ consistent finishes between surfaces with different diameters.

If the CSS switch is in the ON position, the spindle speed automatically _____ the position of the cross slide. For example, during facing operations, as the tool bit _____ the center of the workpiece, the spindle speed _____ to maintain a constant surface speed during cutting as diameter decreases. As a result of this automatic spindle speed control, surface finishes are consistent, tooling _____ longer, and fewer workpieces will be lost from mistakes.

Another benefit _____ the CSS feature is that from reduced machine shutdown and less lever shifting cycles, shorter machining time will be carried off which can mean increased productivity.

Note: When the CSS switch is in the ON position, the spindle RPM can be _____ with the spindle speed dial.

When the CSS switch is in the OFF position, the cross-slide position has no effect on spindle speed. The spindle speed is only adjusted with the spindle speed dial.



hold up



changes into



makes for



goes up



came from



set up



allows for