

%

O0090(0090296)

(HEAD 1)

(1.25 DIA. X 2.375 303SS)

(77 SECONDS)

G54

#5222=2.5(MATERIAL LENGTH FROM COLLET)

G20

M63(CHIP CONVEYOR ON)

T101G0Z1.25(SAFETY CLEAR TOOLS)

M300

M15(BLOCK SKIP ON,MUST BE SEPERATE LINE)

M8

G50S2500

T202(CCMT .016)

G99G96S550M3

G0Y0.0X1.32

Z0.

G1X1.22F0.005

X-0.03

X-0.04

G99

G0Z0.05

X1.09

G1Z-2.117F.01

X1.2167

G3X1.2379Z-2.1214R0.015

G1X1.2412Z-2.123

X1.35

G0Z0.05

X0.93

G1Z-2.117

X1.09

X1.1041Z-2.1099

G0Z0.05

X0.77

G1Z-0.0624

X0.7725Z-0.0637

G3X0.8Z-0.0969R0.047

G1Z-2.117

X0.93

X0.9441Z-2.1099

G0Z0.05

X0.6539

G1Z-0.0044

X0.77Z-0.0624

X0.7841Z-0.0554

G0X1.35

G99

G0Z0.0141

X0.5619

G1X0.5902Z0.F0.007

G3X0.6213Z-0.0064R0.022

G1X0.7371Z-0.0643

G3X0.75Z-0.0799R0.022

G1Z-2.125

X1.196

G3X1.2172Z-2.1294R0.015

G1X1.2412Z-2.1414

X1.3119Z-2.1767

G0X1.35

G0X3.0Z1.5

M5

T707(1/2" CROSS SPOT_)

M54(ENABLE C AXIS)

G99G97S1200M103

G0Y0.C0.

Z-0.188

X0.85

G1X0.601F.004

G0X0.85

C180.0

G4X.3

G1X0.601F.004

G0X3.0

T808(.156 DRILL CROSS_)

G99G97S1500M103

G0Y0.

Z-0.188

X0.85

G87X-0.9Q800F.003

G80

M105

M55(DISABLE C AXIS)

G18

G0X2.8Z1.0

M01

N100

M105

(PULL WITH SUB SPINDLE)

T101M9

G0X3.4Y0.0M5

G0Z-1.0

M302

M304

M34(MAIN_OPEN)

G4P500

G0W2.485

M35(MAIN_CLOSE)

G0W.004

M306

M50(Z2 FOLLOW Z1)

M308

T101(PART .098 CYCLONE)

M08G18

G50S2500

G99G96S400M253

G0Y0.

Z0.

X1.328

M310

G99

G1X1.198F0.0035

G0X1.328

G0X1.3143Z0.0536

G1X1.2436Z0.0182

X1.2136Z0.0032

G3X1.198Z0.R0.011

G1X-0.022

X-0.032

M9

M51(Z1 Z2 SYNC ON)

M312

M255(RPM SYNC OFF)

G0X2.5Z1.25M5

M314

M316

M6(COUNT PART)

/M98P5000(BAR CHANGE SUB PROG)

M318

M01

M99

%