

```
(FILE NAME .... C-ROD - SQUARE CORNERS.NC)

(=====)
(SET PART VERTICALLY IN A VISE =====)
(X0Y0 = LL CORNER - Z0 = FINISHED TOP FACE =)
(OFFSETS D55/D57 ADJUSTED FROM CUTTER CENTER)
(=====)
(SPOT DRILL 1/4 HOLE TO 0.28 CHFR DIA)
(T01 - 1/2 DIA SPOT DRILL - 0.28 CHFR DIA - DIA 0.28)
N1 G20
N2 G17 G40 G80
N3 T01
N4 M06
N5 G90 G54 G00 X0.625 Y0.625 S1800 M03 T02
N6 G43 Z1.0 H01 M08
N7 G98 G82 R0.1 Z-0.14 P250 F5.0
N8 G80 Z1.0 M09
N10 G28 Z1.0 M05
N11 M01

(T02 - 3/4 DIA SPOT DRILL - 0.53 CHFR DIA - DIA 0.53)
(SPOT DRILL 1/2 HOLE TO 0.53 CHFR DIA)
N12 T02
N13 M06
N14 G90 G54 G00 X0.625 Y3.125 S1600 M03 T03
N15 G43 Z1.0 H02 M08
N16 G98 G82 R0.1 Z-0.265 P250 F5.0
N17 G80 Z1.0 M09
N19 G28 Z1.0 M05
N20 M01

(T03 - 1/2 DIA DRILL - DIA 0.5)
(DRILL 1/2 DIA HOLE)
N21 T03
N22 M06
N23 G90 G54 G00 X0.625 Y3.125 S1500 M03 T04
N24 G43 Z1.0 H03 M08
N25 G98 G81 R0.1 Z-0.7002 F7.0
N26 G80 Z1.0 M09
N28 G28 Z1.0 M05
N29 M01

(T04 - 1/4 DIA DRILL - DIA 0.25)
(DRILL 1/4 DIA HOLE)
N30 T04
N31 M06
N32 G90 G54 G00 X0.625 Y0.625 S1600 M03 T05
N33 G43 Z1.0 H04 M08
N34 G98 G83 R0.1 Z-0.6251 Q0.25 F6.0
N35 G80 Z1.0 M09
N37 G28 Z1.0 M05
N38 M01

(T05 - 3/4 DIA END MILL - DIA 0.75)
(ROUGH OUTSIDE CONTOUR)
N39 T05
N40 M06
N41 G90 G54 G00 X0.625 Y4.625 S1500 M03 T06
N42 G43 Z0.1 H05 M08
```

```
N43 G01 Z-0.24 F6.0
N44 X0.025
N45 G03 X0.625 Y4.025 I0.6
N46 G02 X1.5205 Y3.035 J-0.9
N47 G01 X1.2717 Y0.56
N48 G02 X-0.0217 I-0.6467 J0.065
N49 G01 X-0.2705 Y3.035
N50 G02 X0.625 Y4.025 I0.8955 J0.09
N51 G03 X1.225 Y4.625 J0.6
N52 G01 X0.625
N53 G00 Z0.1
(FINISH OUTSIDE CONTOUR - D55=0.0)
N54 Y4.6
N55 G01 Z-0.25
N56 G41 D55 X0.025
N57 G03 X0.625 Y4. I0.6
N58 G02 X1.4956 Y3.0375 J-0.875
N59 G01 X1.2469 Y0.5625
N60 G02 X0.0031 I-0.6219 J0.0625
N61 G01 X-0.2456 Y3.0375
N62 G02 X0.625 Y4. I0.8706 J0.0875
N63 G03 X1.225 Y4.6 J0.6
N64 G01 G40 X0.625
N65 G00 Z0.1 M09
N67 G28 Z0.1 M05
N68 M01

(T06 - 3/8 DIA END MILL - DIA 0.375)
(ROUGH POCKET TO 0.15 DEPTH)
N69 T06
N70 M06
N71 G90 G54 G00 X0.5926 Y2.3026 S2400 M03 T07
N72 G43 Z1.0 H06 M08
N73 Z0.1
N74 G01 Z-0.15 F5.0
N75 X0.625 Y1.98
N76 X0.6574 Y2.3026
N77 G02 X0.625 Y2.302 I-0.0324 J0.8224
N78 X0.5926 Y2.3026 J0.823
N79 G01 X0.625 Y2.4145
N80 G02 X0.4665 Y2.4324 J0.7105
N81 G01 X0.6019 Y1.0849
N82 G02 X0.6481 I0.0231 J-0.4599
N83 G01 X0.7835 Y2.4324
N84 G02 X0.625 Y2.4145 I-0.1585 J0.6926
N85 G00 Z1.0 M09
N87 G28 Z1.0 M05
N88 M01

(T07 - 1/8 DIA END MILL - DIA 0.125)
(CLEANUP POCKET CORNERS TO 0.08 DEPTH)
N89 T07
N90 M06
N91 G90 G54 G00 X0.4504 Y2.5032 S3000 M03 T01
N92 G43 Z0.1 H07 M08
N93 G01 Z-0.08 F4.0
N94 X0.309 Y2.6446
N95 G00 Z0.1
N96 X0.7996 Y2.5032
N97 G01 Z-0.08
```

N98 X0.941 Y2.6446
N99 G00 Z0.1
N100 X0.626 Y1.0586
N101 G01 Z-0.08
N102 X0.7674 Y0.9171
N103 G00 Z0.1
N104 X0.624 Y1.0586
N105 G01 Z-0.08
N106 X0.4826 Y0.9171
N107 G00 Z0.1
(CLEANUP POCKET CORNERS TO 0.15 DEPTH)
N108 X0.4504 Y2.5032
N109 G01 Z-0.15
N110 X0.309 Y2.6446
N111 G00 Z0.1
N112 X0.7996 Y2.5032
N113 G01 Z-0.15
N114 X0.941 Y2.6446
N115 G00 Z0.1
N116 X0.626 Y1.0586
N117 G01 Z-0.15
N118 X0.7674 Y0.9171
N119 G00 Z0.1
N120 X0.624 Y1.0586
N121 G01 Z-0.15
N122 X0.4826 Y0.9171
N123 G00 Z0.1
(SEMI-FINISH POCKET CONTOUR - 2 CUTS)
N124 X0.725 Y2.3525
N125 G01 Z-0.075
N126 Y2.4525
N127 G03 X0.625 Y2.5525 I-0.1
N128 G02 X0.3103 Y2.6467 J0.5725
N129 G03 X0.3065 Y2.6444 I-0.0014 J-0.0021
N130 G01 X0.4801 Y0.9169
N131 G03 X0.4837 Y0.9149 I0.0025 J0.0003
N132 G02 X0.7663 I0.1413 J-0.2899
N133 G03 X0.7699 Y0.9169 I0.0011 J0.0022
N134 G01 X0.9435 Y2.6444
N135 G03 X0.9397 Y2.6467 I-0.0025 J0.0003
N136 G02 X0.625 Y2.5525 I-0.3147 J0.4783
N137 G03 X0.525 Y2.4525 J-0.1
N138 G01 Y2.3525
N139 G00 Z0.1
N140 X0.725
N141 G01 Z-0.15
N142 Y2.4525
N143 G03 X0.625 Y2.5525 I-0.1
N144 G02 X0.3103 Y2.6467 J0.5725
N145 G03 X0.3065 Y2.6444 I-0.0014 J-0.0021
N146 G01 X0.4801 Y0.9169
N147 G03 X0.4837 Y0.9149 I0.0025 J0.0003
N148 G02 X0.7663 I0.1413 J-0.2899
N149 G03 X0.7699 Y0.9169 I0.0011 J0.0022
N150 G01 X0.9435 Y2.6444
N151 G03 X0.9397 Y2.6467 I-0.0025 J0.0003
N152 G02 X0.625 Y2.5525 I-0.3147 J0.4783
N153 G03 X0.525 Y2.4525 J-0.1
N154 G01 Y2.3525
N155 G00 Z0.1

(FINISH POCKET TO SIZE - D57=0.0)

N156 X0.6258 Y1.7959
N157 G01 Z-0.156
N158 X0.6767 Y2.3021
N159 X0.7001 Y2.3521
N160 X0.5499
N161 X0.5726 Y2.3084
N162 X0.6273 Y1.7646
N163 X0.6205 Y1.7146
N164 X0.6248 Y1.4459
N165 X0.6405 Y1.3771
N166 X0.6506 Y1.2771
N167 X0.625 Y1.0146
N168 X0.686 Y1.0396
N169 X0.6736 Y1.0834
N170 X0.8105 Y2.4459
N171 X0.8417 Y2.5021
N172 X0.8017 Y2.4646
N173 X0.7366 Y2.4521
N174 X0.5134
N175 X0.4483 Y2.4646
N176 X0.4083 Y2.5021
N177 X0.4382 Y2.4584
N178 X0.5758 Y1.0896
N179 X0.564 Y1.0396
N180 X0.4837 Y0.9149
N181 G02 X0.7663 I0.1413 J-0.2899
N182 G03 X0.7699 Y0.9169 I0.0011 J0.0022
N183 G01 X0.9435 Y2.6444
N184 G03 X0.9397 Y2.6467 I-0.0025 J0.0003
N185 G02 X0.625 Y2.5525 I-0.3147 J0.4783
N186 X0.3103 Y2.6467 J0.5725
N187 G03 X0.3065 Y2.6444 I-0.0014 J-0.0021
N188 G01 X0.4801 Y0.9169
N189 G03 X0.4837 Y0.9149 I0.0025 J0.0003
N190 G00 Z0.1
N191 X0.4996 Y2.3796
N192 G01 Z-0.156
N193 G41 D57 X0.5265 Y2.4694
N194 G03 X0.4636 Y2.5861 I-0.0898 J0.0269
N195 G02 X0.3158 Y2.6551 I0.1614 J0.5389
N196 G03 X0.2965 Y2.6434 I-0.0069 J-0.0104
N197 G01 X0.4701 Y0.9159
N198 G03 X0.4881 Y0.9059 I0.0124 J0.0013
N199 G02 X0.7619 I0.1369 J-0.2809
N200 G03 X0.7799 Y0.9159 I0.0055 J0.0112
N201 G01 X0.9535 Y2.6434
N202 G03 X0.9342 Y2.6551 I-0.0124 J0.0013
N203 G02 X0.625 Y2.5625 I-0.3092 J0.4699
N204 X0.4636 Y2.5861 J0.5625
N205 G03 X0.3469 Y2.5232 I-0.0269 J-0.0898
N206 G01 G40 X0.3257 Y2.4525
N207 G00 Z0.1 M09
N209 G28 Z0.1 M05
N210 G28 X0.3257 Y2.4525
N211 M30
%