

(RADIUS BLENDING.NC)
(PETER SMID - CNC PROGRAMMING HANDBOOK)
(FANUC 10T CONTROL SYSTEM)

(Z0 = FRONT FINISHED FACE)
(EXTEND 2.375 INCHES FROM THE JAWS FACE)

(T0303 ... OD FINISH - 55 DEG)
N1 G20 G50 S3000 T0300
N2 G96 S400 M03
N3 G00 G41 X1.1 Z0 T0303 M08
N4 G01 X-0.07 F0.003
N5 G00 Z0.16
N6 G42 X1.05
N7 G71 P8 Q29 U0.03 W0.005 D0600 F0.01
N8 G00 X-0.19 Z0.16
N9 G01 Z0.06
N10 G02 X-0.07 Z0 R0.06 F0.005
N11 G01 X0
N12 G03 X0.3058 Z-0.0285 R0.425 F0.003
N13 X0.325 Z-0.0425 R0.015
N14 G01 Z-0.0569
N15 G02 X0.425 Z-0.1069 R0.05
N16 G01 X0.5523
N17 G03 X0.5725 Z-0.1109 R0.015
N18 X0.6592 Z-0.1567 R0.425
N19 X0.6631 Z-0.1725 R0.015
N20 G01 X0.6455 Z-0.1914
N21 G02 X0.7102 Z-0.2608 R0.05
N22 G01 X0.778 Z-0.2699
N23 G03 X0.7984 Z-0.2792 R0.015
N24 X0.7704 Z-0.6046 R0.425
N25 G01 X0.5188 Z-0.8743
N26 G02 X0.8938 Z-1.5092 R0.5
N27 G03 X0.95 Z-1.56 R0.06
N28 G01 Z-1.9
N29 G00 X1.1
N30 G70 P8 Q29 S450
N31 G00 G40 X3.0 Z5.0 T0300
N32 M01

(T0505 ... 0.125 WIDE PART-OFF TOOL)
N33 T0500
N34 G97 S1700 M03
N35 G00 X1.1 Z0 T0505 M08
N36 Z-1.885
N37 G01 X0.85 F0.002
N38 G00 X1.0
N39 W0.055
N40 G01 X0.91 W-0.045 F0.001
N41 X-0.02 F0.002
N42 G00 X1.1
N43 X3.0 Z5.0 T0500
N44 M30
%