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(LINEAR HOLE PATTERN)
(VERSION 1- USING REGULAR PROGRAMMING)
(X0Y0 = LL CORNER OF PART - Z0 = TOP OF PART)
(T01 - 10 MM SPOT DRILL)
(T02 - 5 MM DRILL)

(T01 - 10 MM SPOT DRILL)
N1 G21
N2 G17 G40 G80 T01
N3 M06
(** VERTICAL PATTERN IN Y+ DIRECTION)
N4 G90 G54 G00 X7.0 Y14.0 S1800 M03 T02 (RAPID TO HOLE 1 OF THE VERTICAL PATTERN)
N5 G43 Z25.0 H01 M08
N6 G99 G82 R2.0 Z-2.75 P200 F120.0 (HOLE 1 OF THE VERTICAL PATTERN)
N7 G91 Y10.0 L5 (REMAINING HOLES OF VERTICAL PATTERN)
(** UPPER ANGULAR PATTERN IN X+Y+ DIRECTION)
N8 G90 X22.0 Y50.0 (HOLE 1 OF THE UPPER ANGULAR PATTERN)
N9 G91 X9.571 Y2.286 L7 (REMAINING HOLES OF UPPER ANGULAR PATTERN)
(** HORIZONTAL PATTERN IN X- DIRECTION)
N10 G90 X92.0 Y39.0 (HOLE 1 OF THE HORIZONTAL PATTERN)
N11 G91 X-7.0 L8 (REMAINING HOLES OF HORIZONTAL PATTERN)
(** LOWER ANGULAR PATTERN IN X-Y+ DIRECTION)
N12 G90 X90.0 Y8.0 (HOLE 1 OF THE LOWER ANGULAR PATTERN)
N13 G91 X-10.337 Y3.762 L6 (REMAINING HOLES OF LOWER ANGULAR PATTERN)
N14 G90 G80 G00 Z25.0 M09 (SPOT DRILLING CYCLE CANCELLED)
N15 G28 Z25.0 M05
N16 M01

(T02 - 5 MM DRILL)
N17 T02
N18 M06
(** VERTICAL PATTERN IN Y+ DIRECTION)
N19 G90 G54 G00 X7.0 Y14.0 S2100 M03 T01 (RAPID TO HOLE 1 OF THE VERTICAL PATTERN)
N20 G43 Z25.0 H02 M08
N21 G99 G81 R2.0 Z-15.0 F170.0 (HOLE 1 OF THE VERTICAL PATTERN)
N22 G91 Y10.0 L5 (REMAINING HOLES OF VERTICAL PATTERN)
(** UPPER ANGULAR PATTERN IN X+Y+ DIRECTION)
N23 G90 X22.0 Y50.0 (HOLE 1 OF THE UPPER ANGULAR PATTERN)
N24 G91 X9.571 Y2.286 L7 (REMAINING HOLES OF UPPER ANGULAR PATTERN)
(** HORIZONTAL PATTERN IN X- DIRECTION)
N25 G90 X92.0 Y39.0 (HOLE 1 OF THE HORIZONTAL PATTERN)
N26 G91 X-7.0 L8 (REMAINING HOLES OF HORIZONTAL PATTERN)
(** LOWER ANGULAR PATTERN IN X-Y+ DIRECTION)
N27 G90 X90.0 Y8.0 (HOLE 1 OF THE LOWER ANGULAR PATTERN)
N28 G91 X-10.337 Y3.762 L6 (REMAINING HOLES OF LOWER ANGULAR PATTERN)
N29 G90 G80 G00 Z25.0 M09 (DRILLING CYCLE CANCELLED)
N30 G28 Z25.0 M05
N31 G91 G28 X0 Y0
N32 M30
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