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(=== BISHOP ===)
(FANUC 10/11T/15T CYCLE METHOD)
(25 DIA MM ALUMINUM OR BRASS BAR)
(EXTEND 80-85 MM FROM JAWS FACE)

(PART STOPPER MOUNTED IN TURRET)
N1 G21 T0800
N2 G00 X20.0 Z0 T0808
N3 M00 (EXTEND BAR STOCK AGAINST STOPPER)
N4 G28 U0 W0 T0800
N5 M01

(35 DEGREE DIAMOND TOOL - LEFT HAND)
N6 T0300 G50 S2000
N7 G96 S100 M03
N8 G00 X28.0 Z0 T0303 M08
N9 G01 X-1.8 F0.1
N10 G00 Z4.0
N11 G42 X26.0
N12 G71 P13 Q32 U1.2 W0.1 D1500 F0.25
N13 G00 X-4.0 Z4.0
N14 G01 Z2.0
N15 G02 X0 Z0 R2.0 F0.1
N16 G03 X2.0 Z-1.0 R1.0
N17 G02 X5.0 Z-2.5 R1.5
N18 G01 X10.0 R-1.5
N19 Z-7.0
N20 G02 X13.0 Z-8.5 R1.5
N21 G03 X14.0 Z-9.0 R0.5
N22 G01 Z-13.5
N23 X10.0 Z-18.5
N24 Z-34.5
N25 G02 X18.0 Z-38.5 R4.0
N26 G01 X20.0 Z-39.5
N27 Z-42.0
N28 X18.0 Z-44.0
N29 X20.0 Z-46.0
N30 X24.0 R-0.75
N31 G01 Z-52.5
N32 U3.0
N33 G70 P13 Q32 S125
N34 G00 G40 Z4.0
N35 G28 U0 W0 T0300 M09
N36 M01

(3.175 MM - 0.125 INCH - WIDE PART-OFF TOOL)
N37 T0500
N38 G97 S1700 M03
N39 G00 X28.0 Z-51.925 T0505 M08
N40 G01 X18.0 F0.1
N41 G00 X26.0
N42 W1.75
N43 G01 U-3.0 W-1.5 F0.05
N44 X-0.5 F0.1
N45 G00 X28.0
N46 G28 U0 W0 T0500 M09
N47 M30
%
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