

(CANDLE HOLDER 3.NC - PETER SMID - CNC PROGRAMMING HANDBOOK)
(NAKAMURA-TOME TMC-4SL - FANUC 10T CNC)
(1.5 DIA ALUMINUM BAR - EXTEND BAR 3.25 INCHES FROM THE FACE OF JAWS)
(--- NOTE - FLUTE OF T04 MUST BE ALIGNED TO CUT ON CENTERLINE ---)

(T01 - 55 DEG OD TOOL - 0.031 NOSE RADIUS)

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N1 G20
N2 T0100
N3 G50 S3500
N4 G96 S350 M03
(MINIMUM FACE CUT TO CENTER)
N5 G00 X1.7 Z0 T0101 M08
N6 G01 X-0.07 F0.004
N7 G00 Z0.16
N8 G42 X1.52
(ROUGH AND FINISH FRONT ONLY)
N9 G71 P10 Q19 U0.03 W0.005 D0700 F0.005
N10 G00 X0.78 Z0.16
N11 G01 Z0.06
N12 G02 X0.9 Z0 R0.06
N13 G03 X1.0 Z-0.05 R0.05
N14 G01 Z-0.1207
N15 G03 X0.9986 Z-0.1292 R0.05
N16 G02 X0.9517 Z-0.9041 R2.7977
N17 G03 X0.9532 Z-0.9177 R0.125
N18 G01 Z-1.1177
N19 X1.6
N20 G70 P10 Q19 S375
(ROUGH AND FINISH STEM AND BASE)
N21 G00 X1.52 Z-0.7177
N22 G71 P23 Q36 U0.03 W0.005 D0500 F0.005 S350
N23 G00 X0.9532 Z-0.7177
N24 G01 Z-0.9177
N25 G03 X0.9239 Z-0.9764 R0.125
N26 G01 X0.5293 Z-1.3475
N27 G02 X0.5 Z-1.4062 R0.125
N28 G01 Z-1.8835
N29 G02 X0.625 Z-1.9917 R0.125
N30 G01 X0.97 Z-2.0913
N31 G03 X1.0 Z-2.1173 R0.03
N32 G01 Z-2.1701
N33 X1.42 Z-2.2913
N34 G03 X1.45 Z-2.3173 R0.03
N35 G01 Z-2.635
N36 X1.6
N37 G70 P23 Q36 S375
N38 G00 G40 X6.0 Z5.0 T0100
N39 M01
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(T04 - 7/16 CENTER-CUTTING END MILL)

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N40 T0400
N41 G97 S1200 M03
N42 G00 X0 Z0.3 T0404 M08
N43 G01 Z-0.5 F0.005
N44 G00 Z0.05
N45 G01 U0.182
N46 U-0.16 Z-0.03 F0.002
N47 Z-0.5 F0.005
N48 X0
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N49 G00 Z0.5
N50 X6.0 Z5.0 T0400
N51 M01

(T05 - 0.125 PART-OFF TOOL - SET TO LEFT TIP)
N52 T0500
N53 G97 S1700 M03
N54 G00 X1.7 Z-2.635 T0505 M08
N55 G01 X1.3 F0.002
N56 G00 X1.5
N57 W0.06
N58 G01 U-0.1 W-0.05
N59 X0
N60 G00 X1.7
N61 X6.0 Z5.0 T0500
N62 M30
%
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