

(CANDLE HOLDER 2.NC)
(PETER SMID - CNC PROGRAMMING HANDBOOK)
(PROJECT 1.5 DIA BAR 4.0 INCHES FROM THE JAW FACE)

(TOOL 04 - OFFSET 04 - 0.5 DIA SLOT DRILL)
(DRILL COUNTERBORE)

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N1 G20
N2 T0400
N3 G97 S900 M03
N4 G00 X0 Z0.5 T0404 M08
N5 G01 Z0.1 F0.03
N6 Z-0.4 F0.006
N7 G00 Z0.1
N8 U0.0625
N9 G01 Z-0.4
N10 G00 Z0.1
N11 U0.0625
N12 G01 Z-0.4
N13 X0
N14 G00 Z0.5 M09
N15 X6.0 Z5.0 T0400
N16 M01
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(TOOL 01 - OFFSET 01 - 55 DEG DNMG-432 INSERT)
(FACE - ROUGH - FINISH CONTOUR)

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N17 T0100
N18 G96 S425 M03
N19 G00 X1.7 Z0 T0101 M08
N20 G01 X0.5 F0.007
N21 G00 Z0.15
N22 G42 X1.6
N23 G71 P24 Q40 U0.06 W0.005 D0750 F0.01
N24 G00 X0.7 Z0.15
N25 G01 Z0.05 F0.006
N26 G02 X0.8 Z0 R0.05
N27 G03 X1.0 Z-0.1 R0.1
N28 G01 Z-0.3707
N29 G03 X0.8746 Z-0.6131 R0.5
N30 G01 X0.6254 Z-0.8379
N31 G02 X0.5 Z-1.0803 R0.5
N32 G01 Z-1.6207
N33 G02 X0.6254 Z-1.8631 R0.5
N34 G01 X0.8119 Z-2.0314
N35 G03 X1.0 Z-2.395 R0.75
N36 G01 Z-2.7
N37 G02 X1.35 Z-2.875 R0.175
N38 G03 X1.45 Z-2.925 R0.05
N39 G01 Z-3.26
N40 G00 X1.65
N41 G70 P24 Q40 S475
N42 G00 G40 X6.0 Z5.0 T0100
N43 M01
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(TOOL 05 - OFFSET 05 - 0.125 WIDE PART-OFF TOOL)
(PART-OFF TO 3.125 LENGTH)

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N44 T0500
N45 G97 S1700 M03
N46 G00 X2.0 Z0 T0505 M08
N47 Z-3.26
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N48 G01 X1.55 F0.02
N49 X1.25 F0.002
N50 G00 X1.51
N51 W0.08
N52 G01 X1.37 W-0.07 F0.001
N53 X-0.03 F0.003
N54 G00 X2.0 M09
N55 Z5.0 T0500
N56 G28 U0 W0
N57 M30
%