

(INDEX WHEEL - 24 TEETH)

(VERIFIED ON ELOX WIRE EDM MODEL H - FANUC 6)

N1 G20 G17 G40 G50 G90
N2 G92 X0.01491 Y-1.39732
N3 G01 G41 Y-1.34732 D01 F0.1
N4 G03 X-0.07878 Y-1.24751 I-0.1 J0
N5 G02 X-0.24678 Y-1.2254 I0.07878 J1.24751
N6 X-0.25882 Y-1.21069 I0.00296 J0.0147
N7 G01 Y-1.02509
N8 G02 X-0.25049 Y-1.01523 I0.01 J0
N9 G03 X-0.29069 Y-1.00445 I-0.00833 J0.0493
N10 G02 X-0.2884 Y-1.01716 I-0.00637 J-0.00771
N11 G01 X-0.3812 Y-1.1779
N12 G02 X-0.39898 Y-1.18462 I-0.01299 J0.0075
N13 X-0.55553 Y-1.11977 I0.39898 J1.18462
N14 X-0.56335 Y-1.10245 I0.00667 J0.01344
N15 G01 X-0.51531 Y-0.92317
N16 G02 X-0.50471 Y-0.9158 I0.00966 J-0.00259
N17 G03 X-0.54075 Y-0.89499 I0.00471 J0.04978
N18 G02 X-0.54183 Y-0.90786 I-0.00815 J-0.00579
N19 G01 X-0.67308 Y-1.0391
N20 G02 X-0.69199 Y-1.04099 I-0.01061 J0.01061
N21 X-0.82642 Y-0.93784 I0.69199 J1.04099
N22 X-0.82949 Y-0.91908 I0.00992 J0.01125
N23 G01 X-0.73669 Y-0.75834
N24 G02 X-0.72454 Y-0.75397 I0.00866 J-0.005
N25 G03 X-0.75397 Y-0.72454 I0.01743 J0.04686
N26 G02 X-0.75834 Y-0.73669 I-0.00937 J-0.00349
N27 G01 X-0.91908 Y-0.82949
N28 G02 X-0.93784 Y-0.82642 I-0.0075 J0.01299
N29 X-1.04099 Y-0.69199 I0.93784 J0.82642
N30 X-1.0391 Y-0.67308 I0.01249 J0.0083
N31 G01 X-0.90786 Y-0.54183
N32 G02 X-0.89499 Y-0.54075 I0.00707 J-0.00707
N33 G03 X-0.9158 Y-0.50471 I0.02897 J0.04075
N34 G02 X-0.92317 Y-0.51531 I-0.00996 J-0.00094
N35 G01 X-1.10245 Y-0.56335
N36 G02 X-1.11977 Y-0.55553 I-0.00388 J0.01449
N37 X-1.18462 Y-0.39898 I1.11977 J0.55553
N38 X-1.1779 Y-0.3812 I0.01422 J0.00479
N39 G01 X-1.01716 Y-0.2884
N40 G02 X-1.00445 Y-0.29069 I0.005 J-0.00866
N41 G03 X-1.01523 Y-0.25049 I0.03853 J0.03187
N42 G02 X-1.02509 Y-0.25882 I-0.00986 J0.00167
N43 G01 X-1.21069
N44 G02 X-1.2254 Y-0.24678 I0. J0.015
N45 X-1.24751 Y-0.07878 I1.2254 J0.24678
N46 X-1.23643 Y-0.06335 I0.01497 J0.00095
N47 G01 X-1.05714 Y-0.01531
N48 G02 X-1.04546 Y-0.02081 I0.00259 J-0.00966
N49 G03 Y0.02081 I0.04546 J0.02081
N50 G02 X-1.05714 Y0.01531 I-0.00909 J0.00416
N51 G01 X-1.23643 Y0.06335
N52 G02 X-1.24751 Y0.07878 I0.00388 J0.01449
N53 X-1.2254 Y0.24678 I1.24751 J-0.07878
N54 X-1.21069 Y0.25882 I0.0147 J-0.00296
N55 G01 X-1.02509

N56 G02 X-1.01523 Y0.25049 I0 J-0.01
N57 G03 X-1.00445 Y0.29069 I0.0493 J0.00833
N58 G02 X-1.01716 Y0.2884 I-0.00771 J0.00637
N59 G01 X-1.1779 Y0.3812
N60 G02 X-1.18462 Y0.39898 I0.0075 J0.01299
N61 X-1.11977 Y0.55553 I1.18462 J-0.39898
N62 X-1.10245 Y0.56335 I0.01344 J-0.00667
N63 G01 X-0.92317 Y0.51531
N64 G02 X-0.9158 Y0.50471 I-0.00259 J-0.00966
N65 G03 X-0.89499 Y0.54075 I0.04978 J-0.00471
N66 G02 X-0.90786 Y0.54183 I-0.00579 J0.00815
N67 G01 X-1.0391 Y0.67308
N68 G02 X-1.04099 Y0.69199 I0.01061 J0.01061
N69 X-0.93784 Y0.82642 I1.04099 J-0.69199
N70 X-0.91908 Y0.82949 I0.01125 J-0.00992
N71 G01 X-0.75834 Y0.73669
N72 G02 X-0.75397 Y0.72454 I-0.005 J-0.00866
N73 G03 X-0.72454 Y0.75397 I0.04686 J-0.01743
N74 G02 X-0.73669 Y0.75834 I-0.00349 J0.00937
N75 G01 X-0.82949 Y0.91908
N76 G02 X-0.82642 Y0.93784 I0.01299 J0.0075
N77 X-0.69199 Y1.04099 I0.82642 J-0.93784
N78 X-0.67308 Y1.0391 I0.0083 J-0.01249
N79 G01 X-0.54183 Y0.90786
N80 G02 X-0.54075 Y0.89499 I-0.00707 J-0.00707
N81 G03 X-0.50471 Y0.9158 I0.04075 J-0.02897
N82 G02 X-0.51531 Y0.92317 I-0.00094 J0.00996
N83 G01 X-0.56335 Y1.10245
N84 G02 X-0.55553 Y1.11977 I0.01449 J0.00388
N85 X-0.39898 Y1.18462 I0.55553 J-1.11977
N86 X-0.3812 Y1.1779 I0.00479 J-0.01422
N87 G01 X-0.2884 Y1.01716
N88 G02 X-0.29069 Y1.00445 I-0.00866 J-0.005
N89 G03 X-0.25049 Y1.01523 I0.03187 J-0.03853
N90 G02 X-0.25882 Y1.02509 I0.00167 J0.00986
N91 G01 Y1.21069
N92 G02 X-0.24678 Y1.2254 I0.015 J0
N93 X-0.07878 Y1.24751 I0.24678 J-1.2254
N94 X-0.06335 Y1.23643 I0.00095 J-0.01497
N95 G01 X-0.01531 Y1.05714
N96 G02 X-0.02081 Y1.04546 I-0.00966 J-0.00259
N97 G03 X0.02081 I0.02081 J-0.04546
N98 G02 X0.01531 Y1.05714 I0.00416 J0.00909
N99 G01 X0.06335 Y1.23643
N100 G02 X0.07878 Y1.24751 I0.01449 J-0.00388
N101 X0.24678 Y1.2254 I-0.07878 J-1.24751
N102 X0.25882 Y1.21069 I-0.00296 J-0.0147
N103 G01 Y1.02509
N104 G02 X0.25049 Y1.01523 I-0.01 J0
N105 G03 X0.29069 Y1.00445 I0.00833 J-0.0493
N106 G02 X0.2884 Y1.01716 I0.00637 J0.00771
N107 G01 X0.3812 Y1.1779
N108 G02 X0.39898 Y1.18462 I0.01299 J-0.0075
N109 X0.55553 Y1.11977 I-0.39898 J-1.18462
N110 X0.56335 Y1.10245 I-0.00667 J-0.01344
N111 G01 X0.51531 Y0.92317
N112 G02 X0.50471 Y0.9158 I-0.00966 J0.00259
N113 G03 X0.54075 Y0.89499 I-0.00471 J-0.04978
N114 G02 X0.54183 Y0.90786 I0.00815 J0.00579
N115 G01 X0.67308 Y1.0391

N116 G02 X0.69199 Y1.04099 I0.01061 J-0.01061
N117 X0.82642 Y0.93784 I-0.69199 J-1.04099
N118 X0.82949 Y0.91908 I-0.00992 J-0.01125
N119 G01 X0.73669 Y0.75834
N120 G02 X0.72454 Y0.75397 I-0.00866 J0.005
N121 G03 X0.75397 Y0.72454 I-0.01743 J-0.04686
N122 G02 X0.75834 Y0.73669 I0.00937 J0.00349
N123 G01 X0.91908 Y0.82949
N124 G02 X0.93784 Y0.82642 I0.0075 J-0.01299
N125 X1.04099 Y0.69199 I-0.93784 J-0.82642
N126 X1.0391 Y0.67308 I-0.01249 J-0.0083
N127 G01 X0.90786 Y0.54183
N128 G02 X0.89499 Y0.54075 I-0.00707 J0.00707
N129 G03 X0.9158 Y0.50471 I-0.02897 J-0.04075
N130 G02 X0.92317 Y0.51531 I0.00996 J0.00094
N131 G01 X1.10245 Y0.56335
N132 G02 X1.11977 Y0.55553 I0.00388 J-0.01449
N133 X1.18462 Y0.39898 I-1.11977 J-0.55553
N134 X1.1779 Y0.3812 I-0.01422 J-0.00479
N135 G01 X1.01716 Y0.2884
N136 G02 X1.00445 Y0.29069 I-0.005 J0.00866
N137 G03 X1.01523 Y0.25049 I-0.03853 J-0.03187
N138 G02 X1.02509 Y0.25882 I0.00986 J-0.00167
N139 G01 X1.21069
N140 G02 X1.2254 Y0.24678 I0 J-0.015
N141 X1.24751 Y0.07878 I-1.2254 J-0.24678
N142 X1.23643 Y0.06335 I-0.01497 J-0.00095
N143 G01 X1.05714 Y0.01531
N144 G02 X1.04546 Y0.02081 I-0.00259 J0.00966
N145 G03 Y-0.02081 I-0.04546 J-0.02081
N146 G02 X1.05714 Y-0.01531 I0.00909 J-0.00416
N147 G01 X1.23643 Y-0.06335
N148 G02 X1.24751 Y-0.07878 I-0.00388 J-0.01449
N149 X1.2254 Y-0.24678 I-1.24751 J0.07878
N150 X1.21069 Y-0.25882 I-0.0147 J0.00296
N151 G01 X1.02509
N152 G02 X1.01523 Y-0.25049 I0 J0.01
N153 G03 X1.00445 Y-0.29069 I-0.0493 J-0.00833
N154 G02 X1.01716 Y-0.2884 I0.00771 J-0.00637
N155 G01 X1.1779 Y-0.3812
N156 G02 X1.18462 Y-0.39898 I-0.0075 J-0.01299
N157 X1.11977 Y-0.55553 I-1.18462 J0.39898
N158 X1.10245 Y-0.56335 I-0.01344 J0.00667
N159 G01 X0.92317 Y-0.51531
N160 G02 X0.9158 Y-0.50471 I0.00259 J0.00966
N161 G03 X0.89499 Y-0.54075 I-0.04978 J0.00471
N162 G02 X0.90786 Y-0.54183 I0.00579 J-0.00815
N163 G01 X1.0391 Y-0.67308
N164 G02 X1.04099 Y-0.69199 I-0.01061 J-0.01061
N165 X0.93784 Y-0.82642 I-1.04099 J0.69199
N166 X0.91908 Y-0.82949 I-0.01125 J0.00992
N167 G01 X0.75834 Y-0.73669
N168 G02 X0.75397 Y-0.72454 I0.005 J0.00866
N169 G03 X0.72454 Y-0.75397 I-0.04686 J0.01743
N170 G02 X0.73669 Y-0.75834 I0.00349 J-0.00937
N171 G01 X0.82949 Y-0.91908
N172 G02 X0.82642 Y-0.93784 I-0.01299 J-0.0075
N173 X0.69199 Y-1.04099 I-0.82642 J0.93784
N174 X0.67308 Y-1.0391 I-0.0083 J0.01249
N175 G01 X0.54183 Y-0.90786

N176 G02 X0.54075 Y-0.89499 I0.00707 J0.00707
N177 G03 X0.50471 Y-0.9158 I-0.04075 J0.02897
N178 G02 X0.51531 Y-0.92317 I0.00094 J-0.00996
N179 G01 X0.56335 Y-1.10245
N180 G02 X0.55553 Y-1.11977 I-0.01449 J-0.00388
N181 X0.39898 Y-1.18462 I-0.55553 J1.11977
N182 X0.3812 Y-1.1779 I-0.00479 J0.01422
N183 G01 X0.2884 Y-1.01716
N184 G02 X0.29069 Y-1.00445 I0.00866 J0.005
N185 G03 X0.25049 Y-1.01523 I-0.03187 J0.03853
N186 G02 X0.25882 Y-1.02509 I-0.00167 J-0.00986
N187 G01 Y-1.21069
N188 G02 X0.24678 Y-1.2254 I-0.015 J0
N189 X0.07878 Y-1.24751 I-0.24678 J1.2254
N190 X0.06335 Y-1.23643 I-0.00095 J0.01497
N191 G01 X0.01531 Y-1.05714
N192 G02 X0.02081 Y-1.04546 I0.00966 J0.00259
N193 G03 X-0.02081 I-0.02081 J0.04546
N194 G02 X-0.01531 Y-1.05714 I-0.00416 J-0.00909
N195 G01 X-0.06335 Y-1.23643
N196 G02 X-0.07878 Y-1.24751 I-0.01449 J0.00388
N197 G03 X-0.18509 Y-1.34732 I-0.0063 J-0.0998
N198 G40 G01 Y-1.39732
N199 M30
%