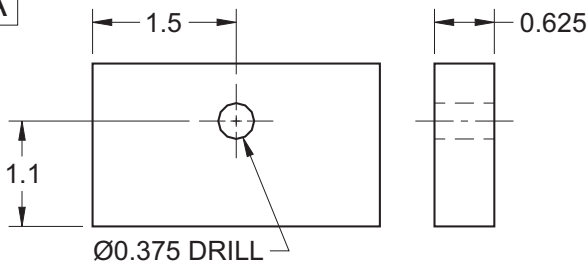
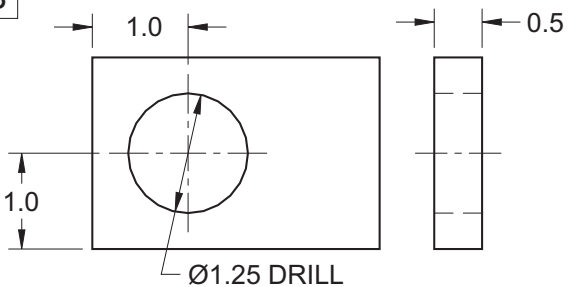
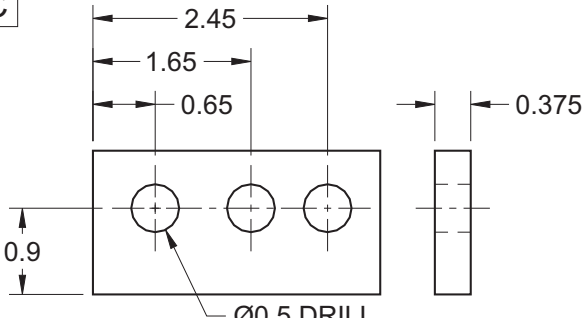


Spot Drill - Drill

The answers below are based on the requirements of the exercise. Since the hole in 26-03B for the spot drill is too large for the spot drill diameter, an arbitrary depth of Z-0.3 has been selected as reasonable. Theoretically, any Z-depth greater than zero and less than 0.375 is correct for the $\varnothing 0.75$ spot drill.

| | |
|---|--|
| <p>A</p>  <p>Ø0.375 DRILL</p> | <p>26-03A - SPOT DRILL</p> <p>G99 G82 X1.5 Y1.1 R0.1 Z-0.1995 P300 F5.0 G80</p> <p>26-03A - DRILL</p> <p>G99 G81 X1.5 Y1.1 R0.1 Z-0.7875 F7.0 G80</p> |
| <p>B</p>  <p>Ø1.25 DRILL</p> | <p>26-03B - SPOT DRILL</p> <p>G99 G82 X1.5 Y1.1 R0.1 Z-0.3 P300 F5.0 G80</p> <p>** HOLE IS TOO LARGE FOR CHAMFER **</p> <p>26-03B - DRILL</p> <p>G99 G81 X1.5 Y1.1 R0.1 Z-0.925 F10.0 G80</p> |
| <p>C</p>  <p>Ø0.5 DRILL</p> | <p>26-03C - SPOT DRILL</p> <p>G99 G82 X0.65 Y0.9 R0.1 Z-0.262 P300 F5.0 X1.65 X2.45 G80</p> <p>26-03C - DRILL</p> <p>G99 G81 X0.65 Y0.9 R0.1 Z-0.575 F6.0 X1.65 X2.45 G80</p> |