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(=== KING ===)
(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
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 Q31 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 X5.0 Z-2.5 R2.5
N17 X15.0 Z-7.5 R5.0
N18 G01 X18.0 R-0.5
N19 Z-12.0
N20 X14.0 Z-20.0
N21 Z-25.254
N22 G02 X14.0 Z-40.746 R16.0
N23 G01 X14.0 Z-47.5
N24 G02 X19.0 Z-50.0 R2.5
N25 G03 X20.0 Z-50.5 R0.5
N26 G01 Z-54.5
N27 X18.0 Z-57.5
N28 X20.0 Z-60.5
N29 X24.0 R-0.75
N30 Z-69.0
N31 U3.0
N32 G70 P13 Q31 S125
N33 G40 G00 Z4.0
N34 G28 U0 W0 T0300 M09
N35 M01

(3.175 MM - 0.125 INCH - WIDE PART-OFF TOOL)
N36 T0500
N37 G97 S1700 M03
N38 G00 X28.0 Z-68.425 T0505 M08
N39 G01 X18.0 F0.1
N40 G00 X26.0
N41 W1.75
N42 G01 U-3.0 W-1.5 F0.05
N43 X-0.5 F0.1
N44 G00 X28.0
N45 G28 U0 W0 T0500 M09
N46 M30
%
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