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(=== ROOK/CASTLE ===)
(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 T0800
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 Q24 U1.2 W0.1 D1500 F0.25
N13 G00 X15.0 Z4.0
N14 G01 Z2.0
N15 G02 X19.0 Z0 R2.0 F0.1
N16 G03 X20.0 Z-0.5 R0.5
N17 G01 Z-6.0
N18 G02 X20.0 Z-29.0 R15.725
N19 G01 Z-33.5
N20 X18.0 Z-35.5
N21 X20.0 Z-37.5
N22 X24.0 R-0.75
N23 Z-44.0
N24 U3.0
N25 G70 P13 Q24 S125
N26 G00 G40 Z4.0
N27 G28 U0 W0 T0300 M09
N28 M01

(11 MM CENTER CUTTING END MILL)
(ALIGN WITH CENTERLINE)
N29 T0400
N30 G97 S900 M03
N31 G00 Z10.0 T0404 M08
N32 X0
N33 G01 Z2.0 F0.5
N34 Z-5.0 F0.1
N35 G00 Z2.0
N36 U3.0
N37 G01 Z-5.0
N38 X0
N39 G00 Z10.0
N40 G28 U0
N41 G28 W0 T0400 M09
N42 M01

(3.175 MM - 0.125 INCH - WIDE PART-OFF TOOL)
N43 T0500
N44 G97 S1700 M03
N45 G00 X28.0 Z-43.425 T0505 M08
N46 G01 X18.0 F0.1
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N47 G00 X26.0
N48 W1.75
N49 G01 U-3.0 W-1.5 F0.05
N50 X-0.5 F0.1
N51 G00 X28.0
N52 G28 U0 W0 T0500 M09
N53 M30
%