

O3326 (POCKET AND GROOVE.NC)

(T06 - 5/8 DIA CUTTER = 15.875 MM)

(T02 - 3/16 DIA CUTTER = 4.7625 MM - D52=2.381)

(X0Y0 - LL CORNER OF PART - Z0 TOP OF PART)

(T06 - 5/8 DIA CUTTER = 15.875 MM)

N1 G21

N2 G17 G40 G80 T06

N3 M06

N4 G90 G54 G00 X50.0 Y37.0 S1800 M03 T02 (1)

N5 G43 Z25.0 H06 M08

N6 Z3.0

N7 G01 Z-4.0 F75.0 (POCKET FULL DEPTH)

N8 Y42.188 F125.0 (2)

N9 X40.479 (3)

N10 Y31.813 (4)

N11 X59.521 (5)

N12 Y42.188 (6)

N13 X50.0 (2)

N14 Y47.375 (7)

N15 X30.958 (8)

N16 Y26.625 (9)

N17 X69.042 (10)

N18 Y47.375 (11)

N19 X50.0 (7)

N20 Y52.563 (START FINAL CUT 12)

N21 X25.0 (13)

N22 G03 X21.438 Y49.0 I0 J-3.563 (14)

N23 G01 Y25.0 (15)

N24 G03 X25.0 Y21.438 I3.563 J0 (16)

N25 G01 X75.0 (17)

N26 G03 X78.563 Y24.99 I0 J3.563 (18)

N27 G01 Y49.0 (19)

N28 G03 X75.0 Y52.563 I-3.563 J0 (20)

N29 G01 X50.0 (12)

N30 Y37.0 F300.0 (RETURN TO PART CENTER 1)

N31 G00 Z25.0 M09

N32 G28 Z25.0 M05

N33 M01

(T02 - 3/16 DIA CUTTER = 4.7625 MM - D52=2.381)

N34 T02

N35 M06

N36 G90 G54 G00 X50.0 Y16.0 S2500 M03 T06 (A)

N37 G43 Z25.0 H02 M08

N38 Z3.0

N39 G01 Z-6.8 F50.0 (ROUGH OUT CENTER OF GROOVE)

N40 X75.0 F120.0 (B)

N41 G03 X84.0 Y25.0 I0 J9.0 (C)

N42 G01 Y49.0 (D)

N43 G03 X75.0 Y58.0 I-9.0 J0 (E)

N44 G01 X25.0 (F)

N45 G03 X16.0 Y49.0 I0 J-9.0 (G)

N46 G01 Y25.0

N47 G03 X25.0 Y16.0 I9.0 J0

N48 G01 X50.0 (A)

N49 Z-7.0 S2800 F50.0 (FINAL GROOVE DEPTH)

N50 G41 X47.0 D52 F110.0 (START OUTER WALL WITH R12)

N51 G03 X50.0 Y13.0 I3.0 J0

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N52 G01 X75.0
N53 G03 X87.0 Y25.0 I0 J12.0
N54 G01 Y49.0
N55 G03 X75.0 Y61.0 I-12.0 J0
N56 G01 X25.0
N57 G03 X13.0 Y49.0 I0 J-12.0
N58 G01 Y25.0
N59 G03 X25.0 Y13.0 I12.0 J0
N60 G01 X50.0
N61 G03 Y19.0 I0 J3.0
N62 G01 X25.0 (START INNER WALL WITH R6)
N63 G02 X19.0 Y25.0 I0 J6.0
N64 G01 Y49.0
N65 G02 X25.0 Y55.0 I6.0 J0
N66 G01 X75.0
N67 G02 X81.0 Y49.0 I0 J-6.0
N68 G01 Y25.0
N69 G02 X75.0 Y19.0 I-6.0 J0
N70 G01 X50.0
N71 G03 X47.0 Y16.0 I0 J-3.0
N72 G40 G01 X50.0
N73 G00 Z25.0 M09
N74 G28 Z25.0 M05
N75 X50.0 Y200.0
N76 M30
%
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