

(NAPKIN HOLDER 1.NC - 1.5 DIA BRASS BAR)
(PETER SMID - CNC PROGRAMMING HANDBOOK)
(FANUC 10T CONTROL)

(EXTEND BAR 2.5 INCHES FROM THE FACE OF JAWS)

(T08 - CENTER DRILL)

N1 G20 G40 G99 T0800
N2 G97 S1400 M03
N3 G00 X0 Z0.5 T0808 M08
N4 G01 Z0.1 F0.02
N5 Z-0.22 F0.004
N6 G00 Z0.5 T0800 M09
N7 X5.0
N8 Z5.0
N9 M01

(T07 - 0.625 DIA DRILL)

N10 T0700
N11 G97 S850 M03
N12 G00 Z0.5 T0707 M08
N13 X0
N14 G01 Z0.1 F0.02
N15 Z-0.5 F0.005
N16 W0.01
N17 Z-1.3
N18 G00 Z0.5 T0700 M09
N19 X5.0 Z1.0
N20 M01

(T03 - 55 OD TOOL - FACE AND RADIUS)

N21 G50 S3250 T0300
N22 G96 S650 M03
N23 G00 X1.65 Z0.005 T0303 M08
N24 G01 X0.3 F0.005
N25 Z0.105
N26 G00 X0.5 S700
N27 G01 Z0 F0.003
N28 X1.0376
N29 G03 X1.4 Z-0.1812 K-0.1812
N30 G01 Z-0.3
N31 X1.6
N32 G00 G40 X3.0 Z5.0 T0300 M09
N33 M01

(T06 - 35 DEG STRAIGHT TOOL)

(ROUGH PROFILE)

N34 G50 S3000 T0600
N35 G96 S650 M03
N36 G00 X1.68 Z0.0688 T0606 M08
N37 G01 X1.48 F0.005
N38 Z-0.15
N39 G03 X1.375 Z-0.2931 I-0.2212
N40 G02 X1.3772 Z-0.3639 I0.041 K-0.0348
N41 G03 Z-0.7611 I-0.2198 K-0.1986
N42 G02 X1.375 Z-0.8319 I0.0399 K-0.036
N43 G03 X1.48 Z-0.975 I-0.1687 K-0.1431
N44 G01 Z-1.1938
N45 X1.68

(FINISHING PROFILE)

N46 G00 Z0.0187
N47 G01 X1.4
N48 Z-0.15
N49 G03 X1.314 Z-0.2672 I-0.1812
N50 G02 X1.3178 Z-.3907 I.0715 K-.0607
N51 G03 Z-.7343 I-.1901 K-.1718
N52 G02 X1.314 Z-.8578 I.0696 K-.0628
N53 G03 X1.4 Z-.975 I-.1382 K-.1172
N54 G01 Z-1.1438
N55 X1.6
N56 G00 G40 X3.0 Z5.0 T0600 M09
N57 M01

(T04 - BORING BAR)

N58 G50 S2750 T0400
N59 G96 S400 M04
N60 G00 X0.625 Z0.15 T0404 M08
N61 G71 P62 Q65 U-0.02 W0.002 D0400 F0.004
N62 G00 X1.24
N63 G01 X1.0 Z-0.02 F0.002
N64 Z-1.2 F0.004
N65 X0.6
N66 G70 P62 Q65 S500
N67 G00 Z0.2 T0400 M09
N68 X4.0
N69 Z4.0 M05
N70 M01

(T05 - 0.125 PART-OFF TOOL)

N71 G97 S1500 M03 T0500
N72 G00 Z-1.27 T0505 M08
N73 X1.68
N74 G01 X1.2 F0.003
N75 G00 X1.68
N76 Z-1.24
N77 G01 X1.3262
N78 G00 X1.68
N79 Z-1.21
N80 G01 X1.385
N81 G00 X1.68
N82 Z-.925
N83 G01 X1.4
N84 Z-1.1 F0.002
N85 G03 X1.1 Z-1.25 I-.15
N86 G01 X0
N87 G00 X1.7
N88 G00 G40 X5.0 Z5.0 T0500 M09
N89 M30
%