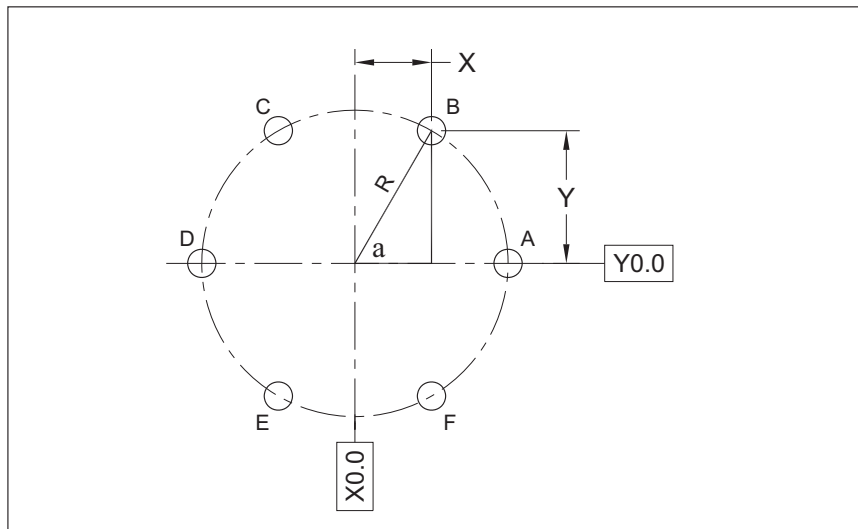


Bolt Hole Pattern - Normal

The calculation of XY coordinates in a bolt hole array requires fairly simple trigonometry. Only two calculations are necessary for the whole bolt hole pattern of six equally spaced holes:



➡ Given values:

- $R = 65/2 = 32.5$
- $\alpha = 360/6 = 60$

➡ Calculated values:

- $X = R \times \cos\alpha$
 $X = 32.5 \times \cos 60$

$$X = 16.250$$

- $Y = R \times \sin\alpha$
 $Y = 32.5 \times \sin 60$

$$Y = 28.146$$

Hole	X-axis Coordinate	Y-axis Coordinate
A	X32.500	Y0.000
B	X16.250	Y28.146
C	X-16.250	Y28.146
D	X-32.500	Y0.000
E	X-16.250	Y-28.146

(27-03.NC)

(T01 - SPOT DRILL)

N1 G21

N2 G17 G40 G80 T01

N3 M06

N4 G90 G54 G00 X32.5 Y0 S1200 M03 T02 (A)

N5 G43 Z10.0 H01 M08

N6 G99 G82 R2.0 Z-3.3 P200 F130.0

N7 X16.25 Y28.146

N8 X-16.15

N9 X-32.0 Y0

N10 X-16.25 Y-28.146

N11 X16.25

N12 G80 Z10.0 M09

N13 G28 Z10.0 M05

N14 M01

(T02 - 6 MM DIA DRILL)

N15 T02

N16 M06

N17 G90 G54 G00 X32.5 Y0 S1000 M03 T01 (A)

N18 G43 Z10.0 H02 M08

N19 G99 G81 R2.0 Z-13.3 F160.0

N20 X16.25 Y28.146

N21 X-16.15

N22 X-32.0 Y0

N23 X-16.25 Y-28.146

N24 X16.25

N25 G80 Z10.0 M09

N26 G28 X16.25 Y-28.146 Z10.0 M05

N27 M30

%