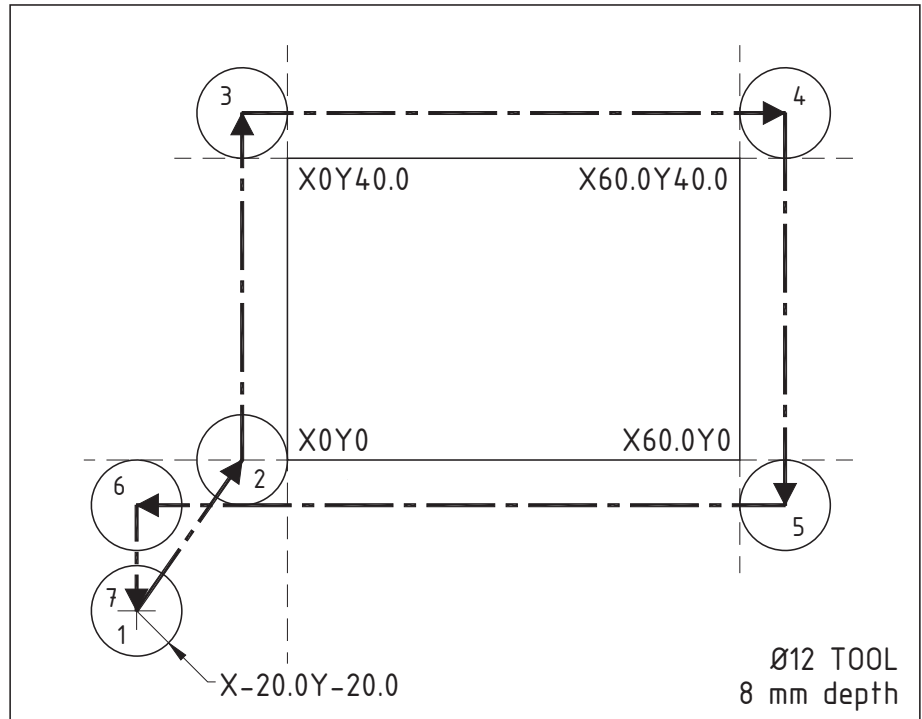


Correctly applying G41/G42 and G40 in the program is very important. In this project, there are six illustrations, and six small programs. There are two objectives - the *first* one is to match each illustration with its corresponding program. The *second* objective is to briefly describe advantages and disadvantages of each *correct* program.

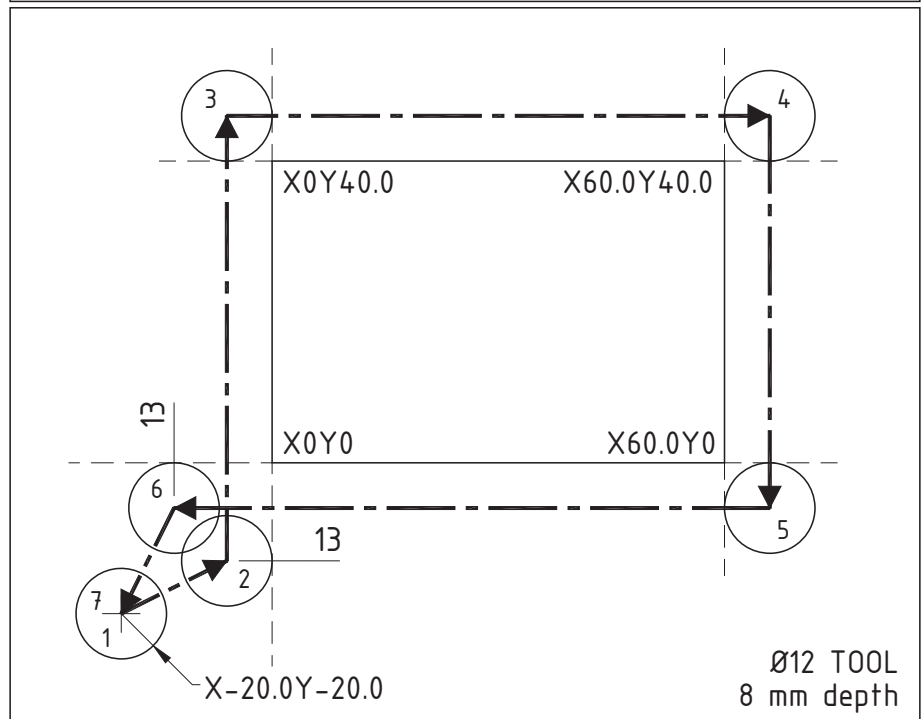
➡ Figure 30-02-A

Matching program number:



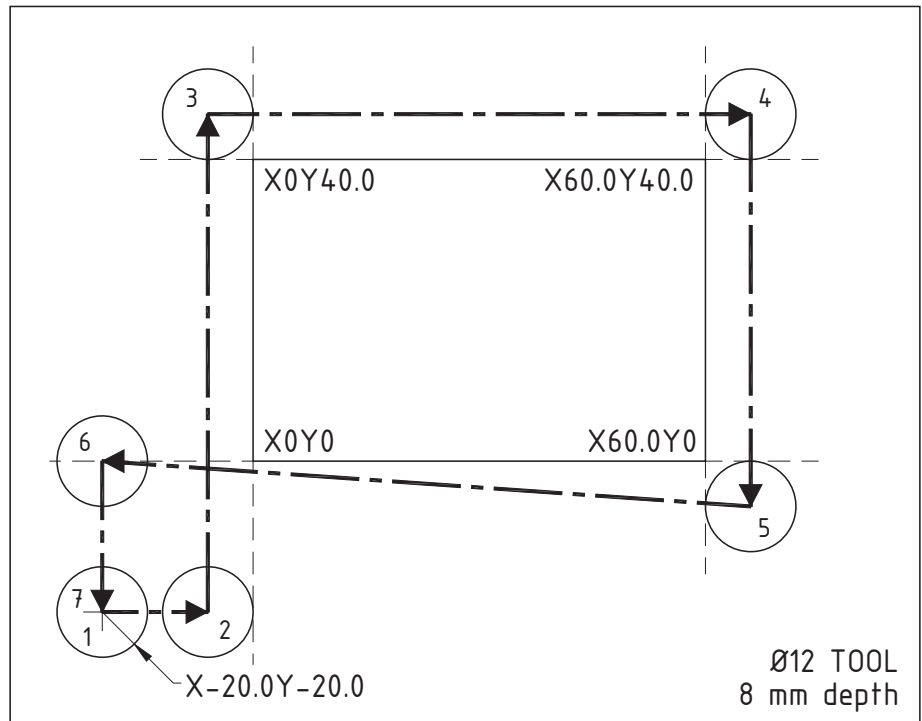
➡ Figure 30-02-B

Matching program number:



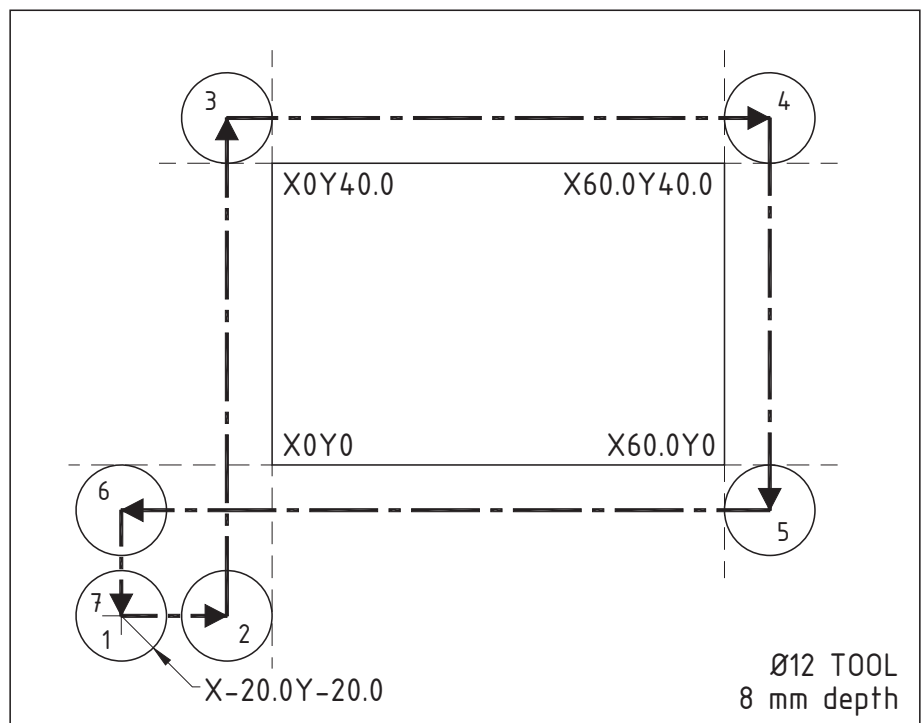
➡ Figure 30-02-C

Matching program number:



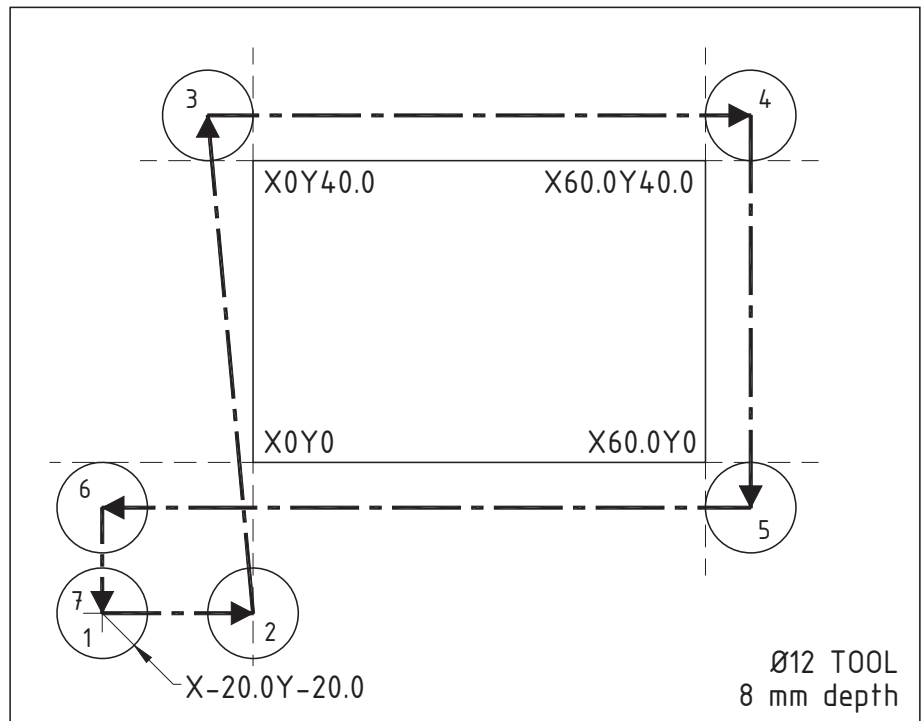
➡ Figure 30-02-D

Matching program number:



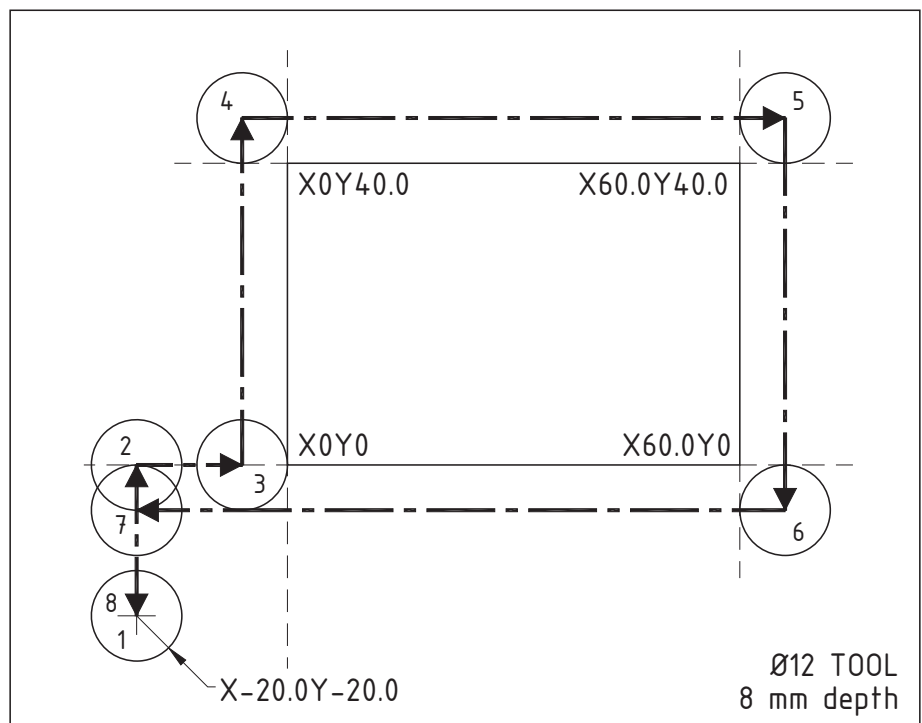
➡ Figure 30-02-E

Matching program number:



➡ Figure 30-02-F

Matching program number:



➡ Answer the following question - Which method (A-B-C-D-E-F) is the most efficient for most jobs? Explain why:

Program number 03051:	Program number 03052:
<p>(APPLYING G40/G41/G42) (T01 - 12 MM DIA END MILL - D51 = 6.0)</p> <p>N1 G21 N2 G17 G40 G80 N3 G90 G00 G54 X-20.0 Y-20.0 S450 M03 N4 G43 Z5.0 H01 M08 N5 Z-8.0 N6 X0 N7 G01 G41 Y40.0 D51 F225.0 N8 X60.0 N9 Y0 N10 X-20.0 N11 G00 G40 Y-20.0 M09 N12 G28 Z5.0 M05 N13 M30 %</p>	<p>(APPLYING G40/G41/G42) (T01 - 12 MM DIA END MILL - D51 = 6.0)</p> <p>N1 G21 N2 G17 G40 G80 N3 G90 G00 G54 X-20.0 Y-20.0 S450 M03 N4 G43 Z5.0 H01 M08 N5 Z-8.0 N6 G41 X0 D51 N7 G01 Y40.0 F225.0 N8 X60.0 N9 Y0 N10 X-20.0 N11 G00 G40 Y-20.0 M09 N12 G28 Z5.0 M05 N13 M30 %</p>
Program number 03053:	Program number 03054:
<p>(APPLYING G40/G41/G42) (T01 - 12 MM DIA END MILL - D51 = 6.0)</p> <p>N1 G21 N2 G17 G40 G80 N3 G90 G00 G54 X-20.0 Y-20.0 S450 M03 N4 G43 Z5.0 H01 M08 N5 Z-8.0 N6 G01 G41 X0 Y0 D51 F400.0 N7 Y40.0 F225.0 N8 X60.0 N9 Y0 N10 X-20.0 N11 G00 G40 Y-20.0 M09 N12 G28 Z5.0 M05 N13 M30 %</p>	<p>(APPLYING G40/G41/G42) (T01 - 12 MM DIA END MILL - D51 = 6.0)</p> <p>N1 G21 N2 G17 G40 G80 N3 G90 G00 G54 X-20.0 Y-20.0 S450 M03 N4 G43 Z5.0 H01 M08 N5 Z-8.0 N6 Y0 N7 G01 G41 X0 D51 F225.0 N8 Y40.0 N9 X60.0 N10 Y0 N11 X-20.0 N12 G00 G40 Y-20.0 M09 N13 G28 Z5.0 M05 N14 M30 %</p>
Program number 03055:	Program number 03056:
<p>(APPLYING G40/G41/G42) (T01 - 12 MM DIA END MILL - D51 = 6.0)</p> <p>N1 G21 N2 G17 G40 G80 N3 G90 G00 G54 X-20.0 Y-20.0 S450 M03 N4 G43 Z5.0 H01 M08 N5 Z-8.0 N6 G41 X0 Y-13.0 D51 F400.0 N7 G01 Y40.0 F225.0 N8 X60.0 N9 Y0 N10 X-13.0 N11 G00 G40 X-20.0 Y-20.0 M09 N12 G28 Z5.0 M05 N13 M30 %</p>	<p>(APPLYING G40/G41/G42) (T01 - 12 MM DIA END MILL - D51 = 6.0)</p> <p>N1 G21 N2 G17 G40 G80 N3 G90 G00 G54 X-20.0 Y-20.0 S450 M03 N4 G43 Z5.0 H01 M08 N5 Z-8.0 N6 G41 X0 D51 F400.0 N7 G01 Y40.0 F225.0 N8 X60.0 N9 Y0 N10 G40 X-20.0 N11 G00 Y-20.0 M09 N12 G28 Z5.0 M05 N13 M30 %</p>