

(MATCHING PARTS - CORE - TOP PART - PETER SMID)
(OPPOSITE PART IS MATCHING PARTS - CAVITY)
(D58 - ROUGHING | D57 - FINISHING - EXTERNAL | D87 - FINISHING - INTERNAL)

N1 G20 (T08 - 1.0 DIA CENTER CUTTING END MILL - ROUGHING)
N2 G17 G40 G80 T08
N3 M06
N4 G90 G54 G00 X0 Y-2.25 S2300 M03 T07
N5 G43 Z0.1 H08 M08
N6 G01 Z-0.32 F25.0
N7 M98 P7001 D58 F12.0 (OUTSIDE CONTOUR AT Z-0.320)
N8 G01 Z-0.245 F25.0
N9 M98 P7002 D58 F12.0 (OUTSIDE WALL AT Z-0.245)
N10 G00 Z0.1
N11 Y0 S1950
N12 G01 Z-0.295 F1.0
N13 M98 P7003 D58 S2300 F12.0 (INSIDE WALL AT Z-0.295)
N14 G01 Z-0.395 S1950 F1.0
N15 M98 P7004 D58 S2300 F12.0 (CIRCULAR POCKET AT Z-0.395)
N16 G00 Z1.0 M09
N17 G28 Z1.0 M05
N18 M01

N19 T07 (T07 - 0.75 DIA CENTER CUTTING END MILL - FINISHING)
N20 M06
N21 G90 G54 G00 X0 Y-2.25 S4250 M03 T28
N22 G43 Z0.1 H07 M08
N23 G01 Z-0.325 F25.0
N24 M98 P7001 D57 F15.0 (OUTSIDE CONTOUR AT Z-0.325)
N25 G01 Z-0.25 F25.0
N26 M98 P7002 D57 F15.0 (OUTSIDE WALL AT Z-0.25)
N27 G00 Z0.1
N28 Y0
N29 G01 Z-0.3 F50.0
N30 M98 P7003 D87 F15.0 (INSIDE WALL AT Z-0.3)
N31 G01 Z-0.4 F2.0
N32 M98 P7004 D57 F15.0 (CIRCULAR POCKET AT Z-0.4)
N33 Z0.1
N34 G00 X0 Y-2.25
N35 Z0 (TOP OF WALL)
N36 G01 X0.575 Y-1.625 F50.0
N37 G03 X0 Y-1.05 R0.575 F20.0
N38 G01 X-0.875
N39 G02 X-1.55 Y-0.375 R0.675
N40 G01 Y0.375
N41 G02 X-0.875 Y1.05 R0.675
N42 G01 X0.875
N43 G02 X1.55 Y0.375 R0.675
N44 G01 Y-0.375
N45 G02 X0.875 Y-1.05 R0.675
N46 G01 X0
N47 G03 X-0.575 Y-1.625 R0.575
N48 G01 X0 Y-2.25
N49 G00 Z1.0 M09
N50 G28 Z1.0 M05
N51 M01

N52 T28 (T28 - NO 4 CENTER DRILL)
N53 M06

N54 G90 G54 G00 X-1.5 Y1.0 S1500 M03 T26
N55 G43 Z0.5 H28 M08
N56 G98 G82 R-0.15 Z-0.53 P200 F4.0 L0 (K0)
N57 M98 P7005
N58 G28 Z1.0 M05

N59 M01
N60 T26 (T26 - 1/4 DIA DRILL)
N61 M06
N62 G90 G54 G00 X-1.5 Y1.0 S1200 M03 T08
N63 G43 Z0.5 H26 M08
N64 G98 G73 R-0.15 Z-0.625 Q0.1 F6.0 L0 (K0)
N65 M98 P7005
N66 G28 Z1.0 M05
N67 X-2.0 Y8.0
N68 M30
%

O7001 (OUTSIDE CONTOUR - Z-0.325)

N101 G01 G41 X0.625 Y-1.7348
N102 G03 X0 Y-1.1098 R0.625
N103 X-1.3714 Y-1.3523 R3.9999
N104 G02 X-1.873 Y-1.039 R0.375
N105 Y1.039 R10.0
N106 X-1.3953 Y1.3601 R0.375
N107 G03 X1.3953 R5.0
N108 G02 X1.873 Y1.039 R0.375
N109 Y-1.039 R10.0
N110 X1.3714 Y-1.3523 R0.375
N111 G03 X0 Y-1.1098 R4.0
N112 X-0.625 Y-1.7348 R0.625
N113 G40 G01 X0 Y-2.25
N114 M99
%

O7002 (OUTSIDE WALL - Z-0.25)

N201 G41 X0.625 Y-1.625
N202 G03 X0 Y-1.0 R0.625
N203 G01 X-0.875
N204 G02 X-1.5 Y-0.375 R0.625
N205 G01 Y0.375
N206 G02 X-0.875 Y1.0 R0.625
N207 G01 X0.875
N208 G02 X1.5 Y0.375 R0.625
N209 G01 Y-0.375
N210 G02 X0.875 Y-1.0 R0.625
N211 G01 X0
N212 G03 X-0.625 Y-1.625 R0.625
N213 G40 G01 X0 Y-2.25
N214 M99
%

O7003 (INSIDE WALL - Z-0.3)

N301 G41 X-0.625 Y-0.275
N302 G03 X0 Y-0.9 R0.625
N303 G01 X0.875
N304 G03 X1.4 Y-0.375 R0.525
N305 G01 Y0.375
N306 G03 X0.875 Y0.9 R0.525
N307 G01 X-0.875

N308 G03 X-1.4 Y0.375 R0.525
N309 G01 Y-0.375
N310 G03 X-0.875 Y-0.9 R0.525
N311 G01 X0
N312 G03 X0.625 Y-0.275 R0.625
N313 G40 G01 X0 Y0
N314 M99
%

O7004 (CIRCULAR POCKET - Z-0.4)
N401 G41 X0.125 Y-0.625
N402 G03 X0.75 Y0 R0.625
N403 X-0.75 R0.75
N404 X0.75 R0.75
N405 X0.125 Y0.625 R0.625
N406 G40 G01 X0 Y0
N407 M99
%

O7005 (4 HOLES)
N501 X-1.5 Y1.0
N502 Y-1.0
N503 X1.5
N504 Y1.0
N505 G80 Z1.0 M09
N506 M99
%