

(NAPKIN HOLDER 3.NC)
(FANUC 10T CONTROL)
(PETER SMID - CNC PROGRAMMING HANDBOOK)

(1.5 DIA BRASS BAR - 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 F0.003
N25 Z0.105
N26 G00 X0.5 S700
N27 G01 Z0
N28 X1.0874
N29 G03 X1.45 Z-0.1812 K-0.1812
N30 G01 Z-0.35
N31 X1.65
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 X1.65 Z0.11 T0606 M08
N37 G01 X1.51 F0.008
N38 Z-0.15
N39 G03 X1.3694 Z-0.2927 I-0.18
N40 X1.3162 Z-0.4625 I-0.1097 K-0.0698
N41 Z-0.6625 I-0.0831 K-0.1
N42 X1.3694 Z-0.8323 I-0.0831 K-0.1
N43 X1.51 Z-0.975 I-0.1097 K-0.1427
N44 G01 Z-1.16
N45 X1.65

(FINISHING)

N46 G00 Z0.0688 S700
N47 G01 X1.45
N48 Z-0.15
N49 G03 X1.3324 Z-0.2836 I-0.1813
N50 G02 X1.324 Z-0.3056 I0.0127 K-0.0138
N51 G03 X1.2712 Z-0.4562 I-0.1183 K-0.0569
N52 G02 Z-0.4688 I0.0061 K-0.0063
N53 G03 Z-0.6563 I-0.0919 K-0.0937
N54 G02 Z-0.6687 I0.0061 K-0.0062
N55 G03 X1.324 Z-0.8194 I-0.0919 K-0.0938
N56 G02 X1.3324 Z-0.8414 I0.0169 K-0.0082
N57 G03 X1.45 Z-0.975 I-0.1225 K-0.1336
N58 G01 Z-1.1187
N59 X1.65 M09
N60 G00 X3.0 Z5.0 T0600 M05
N61 M01

(T04 - BORING BAR)

N62 G50 S2750 T0400
N63 G96 S400 M04
N64 G00 G41 X0.625 Z0.15 T0404 M08
N65 G71 P66 Q68 U-0.02 W0.002 D0400 F0.004
N66 G00 X1.24
N67 G01 X1.0 Z-0.02 F0.002
N68 Z-1.2 F0.004
N69 X0.6
N70 G70 P66 Q68 S500
N71 G00 G40 Z0.2 T0400 M09
N72 X4.0
N73 Z4.0 M05
N74 M01

(T05 - 0.125 PART-OFF TOOL)

N75 G97 S1500 M03 T0500
N76 G00 Z-1.265
N77 X1.65
N78 G01 X1.3 F0.003
N79 G00 X1.65
N80 Z-1.24
N81 G01 X1.3
N82 G00 X1.65
N83 Z-1.215
N84 G01 X1.4
N85 G00 X1.65
N86 Z-0.9
N87 G01 X1.45 F0.002
N88 Z-1.1
N89 G03 X1.15 Z-1.25 I-0.15
N90 G01 X0.5
N91 G00 X1.65
N92 X4.0 Z4.0 T0500 M09
N93 M30
%