

(2 BOLT CIRCLES.NC)

(T01 - 3.0 DIA FACE MILL)

(T02 - 45 DEG CHAMFERING TOOL - 1.0 DIA AT S/C)

(T03 - 0.5 DIA SPOT DRILL - 90 DEGREES)

(X0Y0 - LOWER LEFT CORNER)

(Z0 - TOP FACE OF FINISHED WORKPIECE)

(4 X 3 X 1/2 PLATE - HORIZONTAL ORIENTATION)

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N1 G20
N2 G17 G40 G80 T01
N3 M06
N4 G90 G00 G54 X0.625 Y-1.75 S3500 M03 T02
N5 G43 Z1.0 H01 M08
N6 G01 Z0 F12.0
N7 Y4.625 F16.0
N8 G00 X3.375
N9 G01 Y-1.75
N10 G00 Z1.0 M09
N11 G28 Z1.0 M05
N12 X-2.0 Y10.0
N13 M01

N14 T02
N15 M06
N16 G90 G00 G54 X-0.75 Y-0.75 S3500 M03 T03
N17 G43 Z1.0 H02 M08
N18 G01 Z-0.15 F20.0
N19 G41 X0 D52 (D52 = 0.610 FOR 0.05 X 45DEG CHFR)
N20 Y3.0
N21 X4.0
N22 Y0
N23 X-0.75
N24 G00 G40 Y-0.75 M09
N25 Z1.0 M05
N26 G28 Z1.0
N27 X-2.0 Y10.0
N28 M01

N29 T03
N30 M06
(FIRST HOLE OF 1.50 BOLT CIRCLE)
N31 G90 G00 G54 X1.75 Y1.0 S3500 M03 T01
N32 G43 Z1.0 H03 M08
N33 G99 G81 R0.05 Z-0.075 F5.0
N34 X1.6495 Y1.375
N35 X1.375 Y1.6495
N36 X1.0 Y1.75
N37 X0.625 Y1.6495
N38 X0.3505 Y1.375
N39 X0.25 Y1.0
N40 X0.3505 Y0.625
N41 X0.625 Y0.3505
N42 X1.0 Y0.25
N43 X1.375 Y0.3505
N44 X1.6495 Y0.625
(FIRST HOLE OF 1.85 BOLT CIRCLE)
N45 X3.7965 Y1.9556
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N46 X3.6955 Y2.3021
N47 X3.4696 Y2.5836
N48 X3.1532 Y2.7572
N49 X2.7944 Y2.7965
N50 X2.4479 Y2.6955
N51 X2.1664 Y2.4696
N52 X1.9928 Y2.1532
N53 X1.9535 Y1.7944
N54 X2.0545 Y1.4479
N55 X2.2804 Y1.1664
N56 X2.5968 Y0.9928
N57 X2.9556 Y0.9535
N58 X3.3021 Y1.0545
N59 X3.5836 Y1.2804
N60 X3.7572 Y1.5968
N61 G80 Z1.0 M09
N62 G28 Z1.0 M05
N63 X-2.0 Y10.0
N64 M30
%