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(CANDLE HOLDER 1.NC)
(PETER SMID - CNC PROGRAMMING HANDBOOK)
(FANUC 10T CONTROL - 1.5 DIA BRASS BAR)

(PROJECT BAR 3.5 INCHES FROM THE FRONT FACE OF JAWS)

(T08 - CENTER DRILL)
N1 G20 G40 G99
N2 T0800
N3 G00 X0 Z0.5 T0808 M08
N4 G97 S1400 M03
N5 G01 Z0.1 F0.02
N6 Z-0.25 F0.004
N7 G00 Z0.5 T0800 M09
N8 X5.0
N9 Z5.0
N10 M01

(T07 - 0.625 DIA DRILL)
N11 T0700
N12 G97 S800 M03
N13 G00 Z0.5 T0707 M08
N14 X0
N15 G01 Z0.1 F0.02
N16 Z-0.5 F0.005
N17 W0.01
N18 Z-1.15
N19 G00 Z0.5 T0700 M09
N20 X5.0 Z1.0
N21 M01

(T02 - 0.75 DIA END MILL)
N22 T0200
N23 G97 S800 M03
N24 G00 Z0.5 T0202 M08
N25 X0
N26 G01 Z0.1 F0.02
N27 Z-0.5 F0.0025
N28 W0.01
N29 Z-1.15
N30 G00 Z0.5 T0200 M09
N31 X5.0 Z1.0
N32 M01

(T03 - FACING AND TURNING TOOL)
N33 G50 S3000 T0300
N34 G96 S550 M03
N35 G00 X1.7 Z0 T0303 M08
N36 G01 X-0.07 F0.003
N37 G00 Z0.1
N38 X0.5
N39 G01 Z0 F0.001
N40 X1.257 F0.003
N41 G03 X1.439 Z-0.091 R0.091
N42 G01 Z-0.4
N43 X1.55 M09
N44 G00 X4.0 Z5.0 T0300 M05
N45 M01
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(T04 - BORING BAR)

N46 G50 S2500 T0400
N47 G96 S400 M04
N48 G00 G41 X0.75 Z0.15 T0404 M08
N49 G71 P50 Q55 U-0.02 W0.002 D0400 F0.004
N50 G00 X1.439
N51 G01 Z0 F0.005
N52 X1.2538
N53 G02 X0.9754 Z-0.1245 R0.1401
N54 G01 X0.7532 Z-1.125
N55 X0.55
N56 G70 P50 Q55
N57 G00 G40 Z0.2 T0400 M09
N58 X4.0
N59 Z4.0 M05
N60 M01

(T06 - STRAIGHT 35 DEG PROFILE TOOL)

N61 G50 S2250 T0600
N62 G96 S550 M03
(ROUGHING FRONT)
N63 G00 X1.65 Z0.055 T0606 M08
N64 G01 X1.59 Z.025 F0.003
N65 X1.478 F0.006
N66 Z-0.06
N67 G03 X1.473 Z-0.0793 R0.075
N68 G02 X1.47 Z-0.0849 R3.2805
N69 G01 Z-1.25
N70 X1.61
N71 G00 Z0.055
N72 X1.55
N73 G01 X1.49 Z0.025
N74 X1.478
N75 Z-0.06
N76 G03 X1.473 Z-0.0793 R0.075
N77 G02 X1.35 Z-0.359 R3.2804
N78 G01 Z-1.25
N79 X1.49
N80 G00 Z-0.2744
N81 X1.43
N82 G01 X1.37 Z-0.3044
N83 G02 X1.2522 Z-0.923 R3.2805
N84 X1.2738 Z-1.188 R3.2804
N85 G00 X1.625
(ROUGHING BACK)
N86 Z-1.1244
N87 G01 X1.43
N88 Z-2.2872
N89 G03 X1.489 Z-2.356 R0.095
N90 G01 Z-2.535
N91 X1.57
N92 G00 Z-1.1244
N93 X1.45
N94 G01 X1.31
N95 Z-2.2569
N96 X1.364 Z-2.2667
N97 G03 X1.45 Z-2.2984 R0.095
N98 G00 Z-1.1244
N99 X1.33

N100 G01 X1.2754
N101 Z-1.2094
N102 G03 X1.19 Z-1.3537 R0.265
N103 G01 Z-2.2351
N104 X1.33 Z-2.2606
N105 G00 Z-1.337
N106 X1.21
N107 G03 X1.07 Z-1.4189 R0.265
N108 G01 Z-2.2132
N109 X1.21 Z-2.2387
N110 G00 Z-1.4108
N111 X1.09
N112 G03 X0.9694 Z-1.4496 R0.265
N113 G01 X0.95 Z-1.4541
N114 Z-2.1914
N115 X1.09 Z-2.2169
N116 G00 Z-1.4495
N117 X0.97
N118 G03 X0.9694 Z-1.4496 R0.265
N119 G01 X0.83 Z-1.4821
N120 Z-2.1694
N121 G02 X0.8482 Z-2.1729 R0.235
N122 G01 X0.97 Z-2.195
N123 G00 Z-1.4774
N124 X0.85
N125 G01 X0.8104 Z-1.4867
N126 G02 X0.71 Z-1.5184 R0.235
N127 G01 Z-2.1334
N128 G02 X0.8482 Z-2.1729 R0.235
N129 G01 X0.85 Z-2.1732
N130 G00 Z-1.5106
N131 X0.73
N132 G02 X0.59 Z-1.5932 R0.235
N133 G01 Z-2.0585
N134 G02 X0.73 Z-2.1412 R0.235
N135 G00 Z-1.5755
N136 X0.61
N137 G02 X0.539 Z-1.6997 R0.235
N138 G01 Z-1.7214
N139 G02 X0.5564 Z-1.7445 R0.035
N140 G03 X0.589 Z-1.7875 R0.065
N141 G01 Z-1.8375
N142 G03 X0.5564 Z-1.8805 R0.065
N143 G02 X0.539 Z-1.9036 R0.035
N144 G01 Z-1.9521
N145 G02 X0.61 Z-2.0763 R0.235
N146 G00 X0.645
N147 Z-1.8375
N148 X0.589
N149 G01 Z-2.0576
N150 G02 X0.609 Z-2.0755 R0.235
N151 G00 X1.65
(FINISHING)
N152 Z0.025
N153 X1.639
N154 G01 X1.438 F0.004
N155 Z-0.06
N156 G03 X1.433 Z-0.0793 R0.075
N157 G02 X1.2338 Z-1.188 R3.2804
N158 G03 X1.2354 Z-1.2094 R0.265

N159 X0.9294 Z-1.4496 R0.265
N160 G01 X0.7704 Z-1.4867
N161 G02 X0.499 Z-1.6997 R0.235
N162 G01 Z-1.7214
N163 G02 X0.5164 Z-1.7445 R0.035
N164 G03 X0.549 Z-1.7875 R0.065
N165 G01 Z-1.8375
N166 G03 X0.5164 Z-1.8805 R0.065
N167 G02 X0.499 Z-1.9036 R0.035
N168 G01 Z-1.9521
N169 G02 X0.8082 Z-2.1729 R0.235
N170 G01 X1.324 Z-2.2667
N171 G03 X1.449 Z-2.356 R0.095
N172 G01 Z-2.535
N173 X1.65
N174 G00 G40 X5.0 Z5.0 T0600 M09
N175 M01

(T05 - 0.125 PART-OFF TOOL)

N176 T0500
N177 G97 S1800 M03
N178 G00 Z-2.635 T0505 M08
N179 X1.65
N180 G01 X1.2 F0.001
N181 G00 X1.55
N182 Z-2.545
N183 G01 X1.39 Z-2.625
N184 X-0.02
N185 G00 X4.0 M09
N186 Z5.0 T0500
N187 M30
%