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(=== KNIGHT ===)
(FANUC 10/11T/15T CYCLE METHOD)
(25 DIA MM ALUMINUM OR BRASS BAR)
(EXTEND 80-85 MM FROM JAWS FACE)

(PART STOPPER MOUNTED IN TURRET)
N1 G21 T0800
N2 G00 X20.0 Z0 T0808
N3 M00 (EXTEND BAR STOCK AGAINST STOPPER )
N4 G28 U0 W0 T0800
N5 M01
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(35 DEGREE DIAMOND TOOL - LEFT HAND)
N6 T0300 G50 S2000
N7 G96 S100 M03
N8 G00 X28.0 Z0 T0303 M08
N9 G01 X-1.8 F0.1
N10 G00 Z4.0
N11 G42 X26.0
N12 G71 P13 Q28 U1.2 W0.1 D1500 F0.25
N13 G00 X-4.0
N14 G01 Z2.0 F0.1
N15 G02 X0 Z0 R2.0
N16 G03 X2.497 Z-1.186 R1.25
N17 G02 X4.225 Z-2.468 R1.5
N18 G03 X9.459 Z-5.378 R5.0
N19 G01 X14.0 Z-12.0
N20 X21.0 R-0.5
N21 Z-19.0
N22 X20.0 Z-33.0
N23 Z-38.0
N24 X18.0 Z-40.0
N25 X20.0 Z-42.0
N26 X24.0 R-0.75
N27 Z-49.0
N28 U3.0
N29 G70 P13 Q28 S125
N30 G00 G40 Z4.0
N31 G28 U0 W0 T0300 M09
N32 M01
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(35 DEGREE DIAMOND TOOL - RIGHT HAND)
N33 T0600 G50 S2000
N34 G96 S100 M03
N35 G00 G41 X22.0 Z-36.0 T0606 M08
N36 G71 P37 Q43 U1.2 W-0.1 D1500 F0.25
N37 G00 X21.0 Z-36.0
N38 G01 X10.0 Z-25.0 F0.1
N39 Z-17.0
N40 X20.0
N41 G02 X21.0 Z-16.5 R0.5
N42 G03 U4.0 W2.0 R2.0
N43 G01 X26.0
N44 G70 P37 Q43 S125
N45 G00 G40 X28.0
N46 G28 U0 W0 T0600 M09
N47 M01
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(3.175 MM - 0.125 INCH - WIDE PART-OFF TOOL)

N48 T0500

N49 G97 S1700 M03

N50 G00 X28.0 Z-48.425 T0505 M08

N51 G01 X18.0 F0.1

N52 G00 X26.0

N53 W1.75

N54 G01 U-3.0 W-1.5 F0.05

N55 X-0.5 F0.1

N56 G00 X28.0

N57 G28 U0 W0 T0500 M09

N58 M30

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