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(=== QUEEN ===)
(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
N5 M01

(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 Q30 U1.2 W0.1 D1500 F0.25
N13 G00 X11.0 Z4.0
N14 G01 Z2.0
N15 G02 X15.0 Z0 R2.0 F0.1
N16 G03 X16.0 Z-0.5 R0.5
N17 G01 Z-12.257
N18 G03 X14.243 Z-14.379 R3.0
N19 G01 X10.5 Z-16.25
N20 Z-32.0
N21 X11.985 Z-32.424
N22 G03 X14.0 Z-34.161 R2.0
N23 G01 Z-39.0
N24 G03 X20.0 Z-42.0 R3.0
N25 G01 Z-45.5
N26 X18.0 Z-48.5
N27 X20.0 Z-51.5
N28 X24.0 R-0.75
N29 Z-59.0
N30 U3.0
N31 G70 P13 Q30 S125
N32 G40 G00 Z4.0
N33 G28 U0 W0 T0300 M09
N34 M01

(11 MM CENTER CUTTING END MILL)
(ALIGN WITH CENTERLINE)
N35 T0400
N36 G97 S900 M03
N37 G00 Z10.0 T0404 M08
N38 X0
N39 G01 Z2.0 F0.5
N40 Z-7.0 F0.1
N41 G00 Z10.0
N42 G28 U0
N43 G28 W0 T0400 M09
N44 M01

(3.175 MM - 0.125 INCH - WIDE PART-OFF TOOL)
N45 T0500
N46 G97 S1700 M03
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N47 G00 X28.0 Z-58.425 T0505 M08
N48 G01 X18.0 F0.1
N49 G00 X26.0
N50 W1.75
N51 G01 U-3.0 W-1.5 F0.05
N52 X-0.5 F0.1
N53 G00 X28.0
N54 G28 U0 W0 T0500 M09
N55 M30
%