

Not all holes machined with a particular tool start always at the same Z-plane level. The drawing below shows six holes, drilled and counterbored at different levels of the Z-plane. The main purpose of this exercise is to use the G98 and G99 commands and proper fixed cycles effectively.

For this exercise, use the following three tools:

- T01 - \varnothing 1.0 Spot drill
- T02 - \varnothing 0.5 Drill
- T03 - \varnothing 0.75 Short end mill or counterbore

Machine the holes in the order of *A-F* for T01 and T03 and in the order of *F-A* for T02.

