

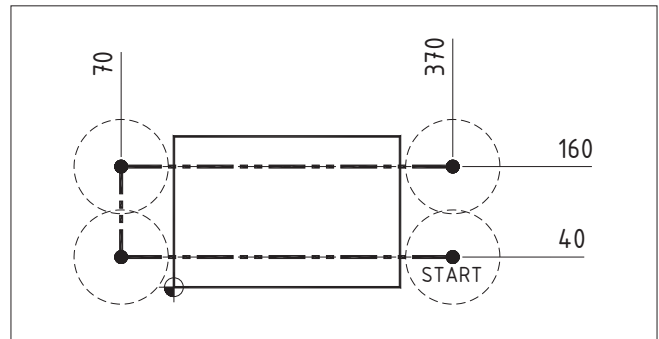
## Face Milling

The illustrations correspond to the program on their left, and are self-explanatory.

### 28-01-A

```

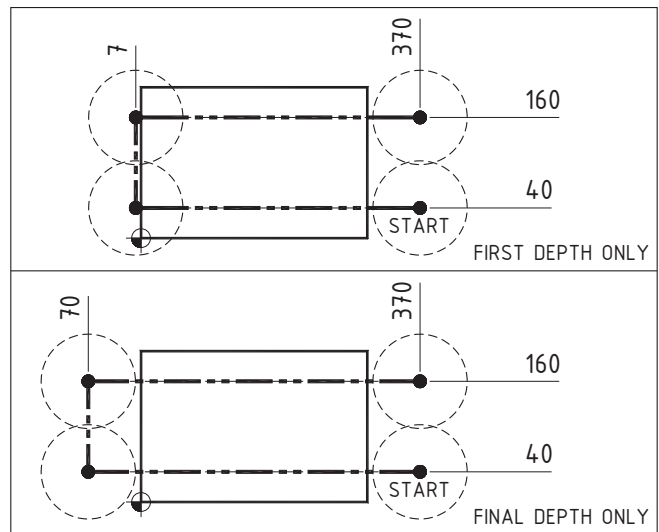
N1 G21
N2 G17 G40 G80
N3 G90 G54 G00 X370.0 Y40.0 S600 M03
N4 G43 Z10.0 H22 M08
N5 Z0
N6 G01 X-70.0 F200.0
N7 G00 Y160.0
N8 G01 X370.0
N9 G00 Z10.0 M09
N10 G28 Z10.0 M05
N11 M30
%
```



### 28-01-B

```

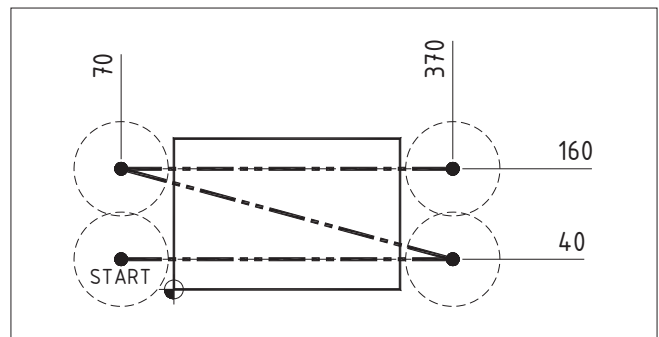
N1 G21
N2 G17 G40 G80
N3 G90 G54 G00 X370.0 Y40.0 S600 M03
N4 G43 Z10.0 H22 M08
N5 Z2.5
N6 G01 X-7.0 F200.0
N7 Y160.0
N8 X370.0
N9 G00 Y40.0
N10 Z0
N11 G01 X-70.0
N12 G00 Y160.0
N13 G01 X370.0
N14 G00 Z10.0 M09
N15 G28 Z10.0 M05
N16 M30
%
```



### 28-01-C

```

N1 G21
N2 G17 G40 G80
N3 G90 G54 G00 X-70.0 Y40.0 S600 M03
N4 G43 Z10.0 H22 M08
N5 Z0
N6 G01 X370.0 F200.0
N7 G00 Z10.0
N8 X-70.0 Y160.0
N9 Z0
N10 G01 X370.0
N11 G00 Z10.0 M09
N12 G28 Z10.0 M05
N13 M30
%
```



28-01-D

```

(28-01-D)
N1 G21
N2 G17 G40 G80
N3 G90 G54 G00 X40.0 Y-70.0 S600 M03
N4 G43 Z10.0 H22 M08
  (FIRST DEPTH AT Z5.0)
N5 Z5.0
N6 G01 Y270.0 F200.0
N7 G00 Z10.0
N8 X150.0 Y-70.0
N9 Z5.0
N10 G01 Y270.0
N11 G00 Z10.0
N12 X260.0 Y-70.0
N13 Z5.0
N14 G01 Y270.0
N15 G00 Z10.0
N16 X40.0 Y-70.0
  (SECOND DEPTH AT Z3.0)
N17 Z3.0
N18 G01 Y270.0
N19 G00 Z10.0
N20 X150.0 Y-70.0
N21 Z3.0
N22 G01 Y270.0
N23 G00 Z10.0
N24 X260.0 Y-70.0
N25 Z3.0
N26 G01 Y270.0
N27 G00 Z10.0
N28 X40.0 Y-70.0
  (THIRD DEPTH AT Z1.0)
N29 Z1.0
N30 G01 Y270.0
N31 G00 Z10.0
N32 X150.0 Y-70.0
N33 Z1.0
N34 G01 Y270.0
N35 G00 Z10.0
N36 X260.0 Y-70.0
N37 Z1.0
N38 G01 Y270.0
N39 G00 Z10.0
N40 X40.0 Y-70.0
  (FOURTH DEPTH - FINAL CUT AT Z0)
N41 Z0
N42 G01 Y270.0
N43 G00 Z10.0
N44 X150.0 Y-70.0
N45 Z0
N46 G01 Y270.0
N47 G00 Z10.0
N48 X260.0 Y-70.0
N49 Z0
N50 G01 Y270.0
N51 G00 Z10.0 M09
N52 G28 Z10.0 M05
N53 M30
%
```

