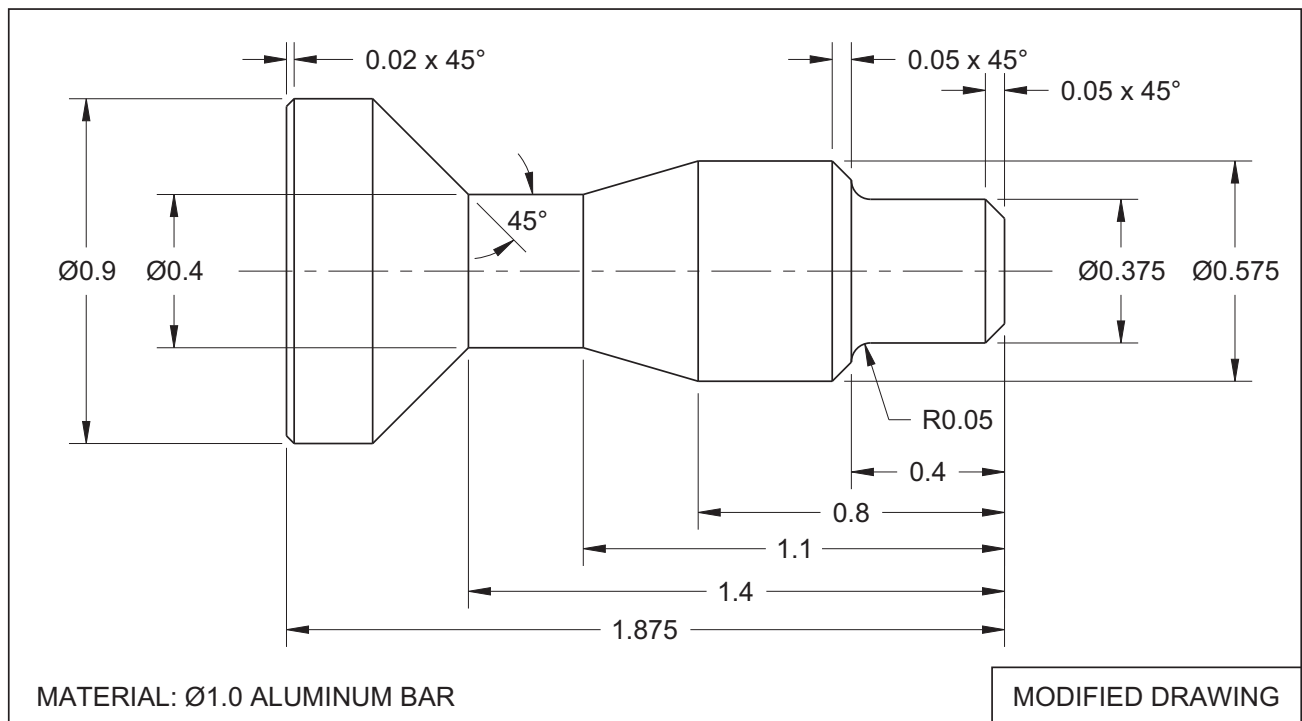
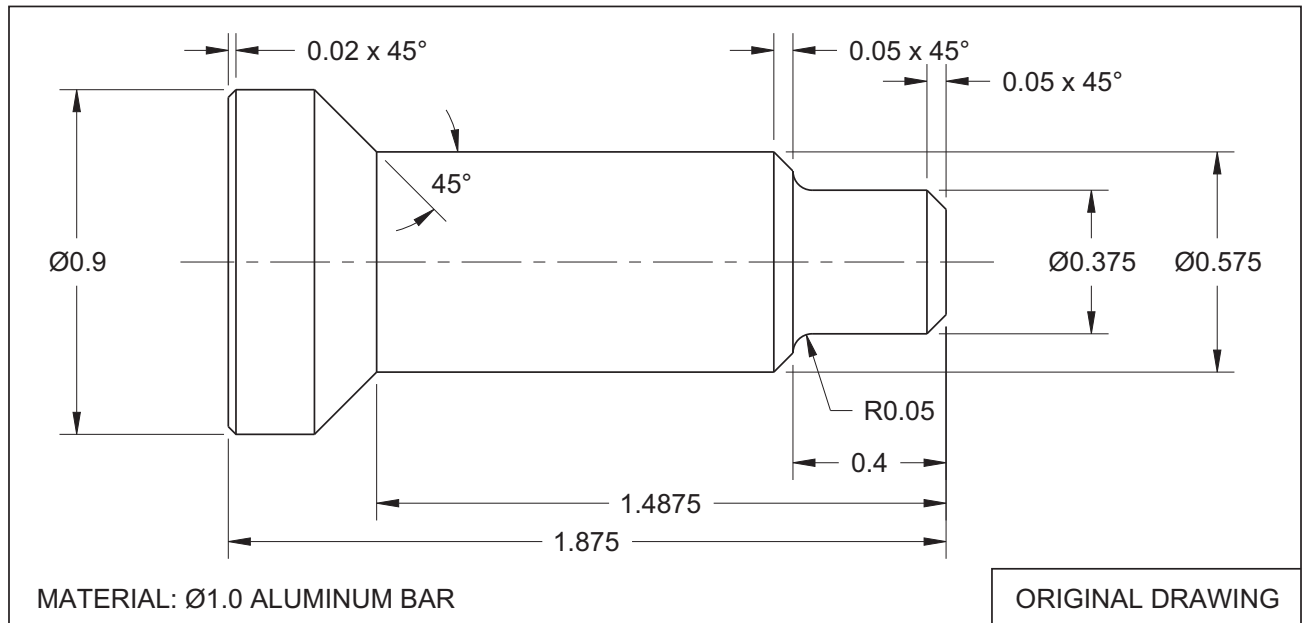


CNC programs often have to be changed for various reasons. In this project, an existing part program has to be modified to reflect an engineering change. The top illustration represents the *original* drawing, *before* the design change. The program provided in this project represents the toolpath for the *top illustration*.

➡ Objective: Modify the existing program (listed on the next page) to match the changes specified in the **lower** illustration.



➡ Original program listing - matches the upper illustration on the previous page:

(34-10 - PROGRAM CHANGE)  
(EXTEND BAR 2.75 INCHES FROM THE JAWS FACE)

(T03 - 55 DEG ROUGHING TOOL)  
N1 G20  
N2 G50 S2000 T0300  
N3 G96 S500 M03  
N4 G00 X1.2 Z0 T0303 M08  
N5 G01 X-0.07 F0.006  
N6 G00 Z0.1  
N7 G42 X1.05  
N8 G71 U0.06 R0.05  
N9 G71 P10 Q18 U0.05 W0.004 F0.01  
N10 G00 X0.075  
N11 G01 X0.375 Z-0.05 F0.002  
N12 Z-0.35 F0.005  
N13 G02 X0.475 Z-0.4 R0.05  
N14 G01 X0.575 Z-0.45  
N15 Z-1.4875  
N16 X0.9 Z-1.65  
N17 Z-2.03  
N18 U0.2 F0.02  
N19 G00 G40 X3.0 Z5.0 T0300  
N20 M01

(T01 - 35 OR 55 DEG FINISHING TOOL)  
N21 G50 S2000 T0100  
N22 G96 S600 M03  
N23 G00 G42 X1.2 Z0.1 T0101 M08  
N24 G70 P10 Q18  
N25 G00 G40 X3.0 Z5.0 T0100  
N26 M01

(T05 - 0.125 WIDE PART-OFF TOOL)  
N27 T0500  
N28 G97 S1800 M03  
N29 G00 Z-2.01 T0505 M08  
N30 X1.2  
N31 G01 X0.7 F0.001  
N32 G00 X1.0  
N33 W0.08  
N34 G01 U-0.14 W-0.07 F0.002  
N35 X-0.02  
N36 G00 X3.0  
N37 Z5.0 T0500 M09  
N38 M30  
%

<b>NOTE:</b> Not all three tools will be affected by the design change
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