

(MATCHING PARTS - CAVITY - BOTTOM PART - PETER SMID)
(OPPOSITE PART IS MATCHING PARTS - CORE)

(D58 - ROUGHING | D57 - FINISHING - EXTERNAL | D75 - ROUGH INSIDE CONTOUR)
(D55 - FINISH INSIDE CONTOUR | D77 - FINISH INSIDE WALL - STRAIGHT)

N1 G20 (T08 - 1.0 DIA CENTER CUTTING END MILL - ROUGHING)

N2 G17 G40 G80 T08

N3 M06

N4 G90 G54 G00 X0 Y0 S2300 M03 T07

N5 G43 Z0.1 H08 M08

N6 G01 Z-0.21 F1.0

N7 M98 P7004 D58 S2700 F10.0

N8 G01 Z-0.42 S2300 F1.0

N9 M98 P7004 D58 S2700 F10.0

N10 G01 Z-0.32 S2300 F20.0

N11 M98 P7006 D58 S2700 F9.0

N12 G00 Z1.0 M09

N13 G28 Z1.0 M05

N14 X-2.0 Y8.0

N15 M01

N16 T07 (T07 - 0.75 DIA CENTER CUTTING END MILL - FINISHING)

N17 M06

N18 G90 G54 G00 X0 Y0 S4250 M03 T05

N19 G43 Z0.1 H07 M08

N20 G01 Z-0.325 F25.0

N21 M98 P7006 D77 F15.0

N22 G01 Z-0.425 F8.0

N23 M98 P7004 D57 F9.0

N24 G00 Z0.1

N25 G01 X0.6 Y-2.0 F20.0

N26 X0 Y-2.25

N27 Z0

N28 G03 X0 Y-1.4 R0.6

N29 G01 X-1.5 Y-1.5

N30 G02 X-2.0 Y-1.0 R0.5

N31 G01 Y1.0

N32 G02 X-1.5 Y1.5 R0.5

N33 G01 X0 Y1.4

N34 X1.5 Y1.5

N35 G02 X2.0 Y1.0 R0.5

N36 G01 Y-1.0

N37 G02 X1.5 Y-1.5 R0.5

N38 G01 X0 Y-1.4

N39 G03 X-0.6 Y-2.0 R0.6

N40 G01 X0 Y-2.25

N41 G00 Z1.0 M09

N42 G28 Z1.0 M05

N43 X-2.0 Y8.0

N44 M01

N45 T05 (T05 - 0.5 DIA END MILL - ROUGHING/FINISHING INSIDE CONTOUR)

N46 M06

N47 G90 G54 G00 X0 Y0 S5300 M03 T28

N48 G43 Z0.1 H05 M08

N49 G01 Z-0.07 F25.0

N50 M98 P7007 D75 F9.0

N51 G01 Z-0.075 F25.0

N52 M98 P7007 D55 F10.0
N53 G00 Z1.0 M09
N54 G28 Z1.0 M05
N55 X-2.0 Y8.0
N56 M01

N57 T28 (T28 - NO 4 CENTER DRILL)
N58 M06
N59 G90 G54 G00 X-1.5 Y1.0 S1500 M03 T26
N60 G43 Z0.5 H28 M08
N61 G98 G82 R0.025 Z-0.355 P200 F4.0 L0
N62 M98 P7005
N63 G28 Z1.0 M05
N64 X-2.0 Y8.0
N65 M01

N66 T26 (T26 - 1/4 DRILL)
N67 M06
N68 G90 G54 G00 X-1.5 Y1.0 S1200 M03 T08
N69 G43 Z0.5 H26 M08
N70 G98 G73 R0.025 Z-0.625 Q0.1 F6.0 L0
N71 M98 P7005
N72 G28 Z1.0 M05
N73 X-2.0 Y8.0
N74 M30
%

O7006 (INSIDE WALL AT Z-0.325)
N601 G41 X-0.625 Y-0.375
N602 G03 X0 Y-1.0 R0.625
N603 G01 X0.875
N604 G03 X1.5 Y-0.375 R0.625
N605 G01 Y0.375
N606 G03 X0.875 Y1.0 R0.625
N607 G01 X-0.875
N608 G03 X-1.5 Y0.375 R0.625
N609 G01 Y-0.375
N610 G03 X-0.875 Y-1.0 R0.625
N611 G01 X0
N612 G03 X0.625 Y-0.375 R0.625
N613 G40 G01 X0 Y0
N614 X-0.75
N615 X0.75
N616 X0
N617 M99
%

O7007 (INSIDE CONTOUR AT Z-0.075)
N701 G01 G41 X-0.625 Y-0.4848
N702 G03 X0 Y-1.1098 R0.625
N703 G02 X1.3714 Y-1.3523 R4.0
N704 G03 X1.873 Y-1.039 R0.375
N705 X1.3714 Y-1.3523 R-0.375
N706 X1.873 Y-1.039 R0.375
N707 Y1.039 R10.0
N708 X1.3953 Y1.3601 R0.375
N709 X1.873 Y1.039 R-0.375
N710 X1.3953 Y1.3601 R0.375
N711 G02 X-1.3953 R5.0
N712 G03 X-1.873 Y1.039 R0.375

N713 X-1.3953 Y1.3601 R-0.375
N714 X-1.873 Y1.039 R0.375
N715 Y-1.039 R10.0
N716 X-1.3714 Y-1.3523 R0.375
N717 X-1.873 Y-1.039 R-0.375
N718 X-1.3714 Y-1.3523 R0.375
N719 G02 X0 Y-1.1098 R4.0
N720 G03 X0.625 Y-0.4848 R0.625
N721 G01 G40 X0 Y0
N722 M99
%