

(PART REVERSAL.NC)
(CNC PROGRAMMING HANDBOOK - PETER SMID)
(NAKAMURA CNC LATHE WITH FANUC 10T CONTROL)

(T0101 - 55 DEGREE OD TOOL - FACE-CHFR-DIA)

N1 G20
N2 G50 S3500
N3 G52 X0 Z0 T0100
N4 G96 S650 M03
N5 G00 G41 X2.2 Z0 T0101 M08
N6 G01 X-0.06 F0.004
N7 Z0.1
N8 G00 G42 X1.69
N9 G01 X1.95 Z-0.03
N10 Z-0.75
N11 U0.2
N12 G00 G40 X6.0 Z6.0 T0100 M05
N13 M01

(T0808 - NO.4 CENTER DRILL)

N14 T0800
N15 G97 S1200 M03
N16 G00 X0 Z0.5 T0808 M08
N17 G01 Z0.1 F0.03
N18 Z-0.21 F0.003
N19 G00 Z0.5
N20 X6.0 Z4.0 T0800
N21 M01

(T0202 - 1/2 DRILL THROUGH)

N22 T0200
N23 G97 S1100 M03
N24 G00 X0 Z0.5 T0202 M08
N25 G01 Z0.1 F0.03
N26 Z-0.75 F0.005
N27 G00 Z0.1
N28 Z-0.73
N29 G01 Z-1.25
N30 G00 Z0.1 F0.004
N31 Z-1.23
N32 G01 Z-1.7 F0.003
N33 G00 Z0.5
N34 X4.0 Z2.0 T0200
N35 M01

(T0404 - 3/8 DIA BORING BAR - ROUGH INSIDE)

N36 G50 S2000
N37 T0400
N38 G96 S500 M04
N39 G00 G41 X0.4 Z0.1 T0404 M08
N40 G71 P41 Q46 U-0.02 W0.003 D0400 F0.006
N41 G00 X1.51
N42 G01 X1.25 Z-0.03 F0.003
N43 Z-0.375
N44 X0.66
N45 X0.549 Z-0.4305
N46 X0.349
N47 G70 P41 Q46 S550
N48 G00 G40 X6.0 Z3.0 T0400

N49 M00 (--- REVERSE PART ---)

(T0101 - 55 DEGREE OD TOOL)

N50 G50 S3500
N51 G52 X0 Z-0.02 T0100
N52 G96 S700 M03
N53 G00 G41 X2.2 Z0 T0101 M08
N54 G01 X0.3 F0.002
N55 Z0.1
N56 G00 G42 X2.0
N57 G71 P58 Q66 U0.035 W0.004 D0650 F0.01
N58 G00 X0.644
N59 G01 Z0 F0.003
N60 X1.144
N61 G03 X1.3426 Z-0.0833 K-0.1008
N62 G01 X1.5708 Z-0.7304
N63 G02 X1.7678 Z-0.813 I0.0985 K0.0174
N64 G01 X1.865
N65 X1.985 Z-0.873 F0.002
N66 U0.1 F0.01
N67 G70 P58 Q66 S750
N68 G00 G40 X6.0 Z4.0 T0100 M05
N69 G52 X0 Z0 M01

(T0404 - 3/8 DIA BORING BAR)

N70 G50 S2000
N71 G52 X0 Z-0.02 T0400
N72 G96 S500 M04
N73 G00 G41 X0.4 Z0.1 T0404 M08
N74 G71 P75 Q80 U-0.02 W0.003 D0500 F0.004
N75 G00 X1.644
N76 G01 Z0 F0.002
N77 X1.144
N78 G02 X0.9454 Z-0.0833 K-0.1008
N79 G01 X0.5824 Z-1.113
N80 X0.3824
N81 G70 P75 Q80 S600
N82 G00 G40 X6.0 Z2.0 T0400
N83 G52 X0 Z0 M05
N84 M30
%