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(=== PAWN ===)
(FANUC 10/11T/15T CYCLE METHOD)
(25 DIA MM ALUMINUM OR BRASS BAR)
(EXTEND 80-85 MM FROM JAWS FACE)

(PART STOPPER MOUNTED IN TURRET)
N1 G21 T0800
N2 G00 X20.0 Z0 T0808
N3 M00 (EXTEND BAR STOCK AGAINST STOPPER)
N4 G28 U0 W0 T0800
N5 M01

(35 DEGREE DIAMOND TOOL - LEFT HAND)
N6 T0300 G50 S2000
N7 G96 S100 M03
N8 G00 X28.0 Z0 T0303 M08
N9 G01 X-1.8 F0.1
N10 G00 Z4.0
N11 G42 X26.0
N12 G71 P13 Q25 U1.2 W0.1 D1500 F0.25
N13 G00 X-4.0 Z4.0
N14 G01 Z2.0
N15 G02 X0 Z0 R2.0 F0.1
N16 G03 X14.142 Z-10.0 R7.5
N17 G01 X10.0 Z-12.071
N18 Z-20.0
N19 X20.0 Z-25.0
N20 Z-26.5
N21 X18.0 Z-28.5
N22 X20.0 Z-30.5
N23 X24.0 R-0.75
N24 G01 Z-37.0
N25 U3.0
N26 G70 P13 Q25 S125
N27 G00 G40 Z4.0
N28 G28 U0 W0 T0300 M09
N29 M01

(3.175 MM - 0.125 INCH - WIDE PART-OFF TOOL)
N30 T0500
N31 G97 S1700 M03
N32 G00 X28.0 Z-36.425 T0505 M08
N33 G01 X18.0 F0.1
N34 G00 X26.0
N35 W1.75
N36 G01 U-3.0 W-1.5 F0.05
N37 X-0.5 F0.1
N38 G00 X28.0
N39 G28 U0 W0 T0500 M09
N40 M30
%
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