

(NAPKIN HOLDER 2.NC)

(PETER SMID - CNC PROGRAMMING HANDBOOK)

(FANUC 10T CONTROL)

(1.5 DIA BRASS BAR)

(EXTEND BAR 2.5 INCHES FROM THE FACE OF JAWS)

(T08 - CENTER DRILL)

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N1 G20 G40 G99 T0800
N2 G97 S1400 M03
N3 G00 X0 Z0.5 T0808 M08
N4 G01 Z0.1 F0.02
N5 Z-0.22 F0.004
N6 G00 Z0.5 T0800 M09
N7 X5.0
N8 Z5.0
N9 M01
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(T07 - 0.625 DIA DRILL)

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N10 T0700
N11 G97 S850 M03
N12 G00 Z0.5 T0707 M08
N13 X0
N14 G01 Z0.1 F0.02
N15 Z-0.5 F0.005
N16 W0.01
N17 Z-1.3
N18 G00 Z0.5 T0700 M09
N19 X5.0 Z1.0
N20 M01
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(T03 - 55 OD TOOL - FACE AND RADIUS)

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N21 G50 S3250 T0300
N22 G96 S650 M03
N23 G00 X1.65 Z0.005 T0303 M08
N24 G01 X0.3 F0.003
N25 Z0.105
N26 G00 X0.5 S700
N27 G01 Z0
N28 X1.1374
N29 G03 X1.3074 Z-0.0849 K-0.0849
N30 G01 Z-0.1766
N31 X1.4736 Z-0.3205
N32 X1.7
N33 G00 G40 X3.0 Z5.0 T0300 M09
N34 M01
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(T06 - 35 DEG STRAIGHT TOOL)

(ROUGH PROFILE)

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N35 G50 S3000 T0600
N36 G96 S650 M03
N37 G00 X1.5074 Z0.1863 T0606 M08
N38 G01 X1.3574 F0.005
N39 Z-0.0537
N40 G03 X1.317 Z-0.1064 I-0.0787
N41 G02 X1.3048 Z-0.1511 I0.0297 K-0.0268
N42 G03 Z-0.9739 I-0.8184 K-0.4114
N43 G02 X1.317 Z-1.0186 I0.0358 K-0.0179
N44 G03 X1.3574 Z-1.0713 I-0.0585 K-0.0527
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N45 G01 Z-1.2113
N46 X1.6
(FINISHING)
N47 G00 Z0.1651 S700
N48 G01 X1.3074 F0.003
N49 Z-0.0537
N50 G03 X1.252 Z-0.1165 I-0.085
N51 G02 X1.244 Z-0.1389 I0.0126 K-0.0138
N52 G03 Z-0.9861 I-0.8193 K-0.4236
N53 G02 X1.252 Z-1.0085 I0.0166 K-0.0086
N54 G03 X1.3074 Z-1.0713 I-0.0573 K-0.0628
N55 G01 Z-1.1901
N56 X1.5074 M09
N57 G00 G40 X3.0 Z5.0 T0600 M05
N58 M01

(T04 - BORING BAR)
N59 G50 S2750 T0400
N60 G96 S400 M04
N61 G00 G41 X0.625 Z0.15 T0404 M08
N62 G71 P63 Q66 U-0.02 W0.002 D0400 F0.004
N63 G00 X1.24
N64 G01 X1.0 Z-0.02 F0.002
N65 Z-1.2 F0.004
N66 X0.6
N67 G70 P63 Q66 S500
N68 G00 G40 Z0.2 T0400 M09
N69 X4.0
N70 Z4.0 M05
N71 M01

(T05 - 0.125 PART-OFF TOOL)
N72 G97 S1500 M03 T0500
N73 G00 Z-1.265 T0505 M08
N74 X1.65
N75 G01 X1.25 F0.003
N76 G00 X1.5074
N77 Z-1.0713
N78 G01 X1.3074
N79 Z-1.1963
N80 G03 X1.2 Z-1.25 I-0.0537
N81 G01 X0 F0.0015
N82 G00 X1.6
N83 X5.0 Z5.0 T0500 M09
N84 M30
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