

This metric programming project is an exercise in using polar coordinates. If the CNC unit supports this option, programming polar coordinates on arcs (bolt circles, for example), simplifies the programming process. Follow these instruction for the program development:

1. Use $\varnothing 7$ mm short drill to machine the bolt circle in G90 mode, using polar coordinate mode.
2. Start at 0° , and continue in the counterclockwise direction.

Note the part zero is the lower left corner of the square, not the center of the bolt hole circle !

