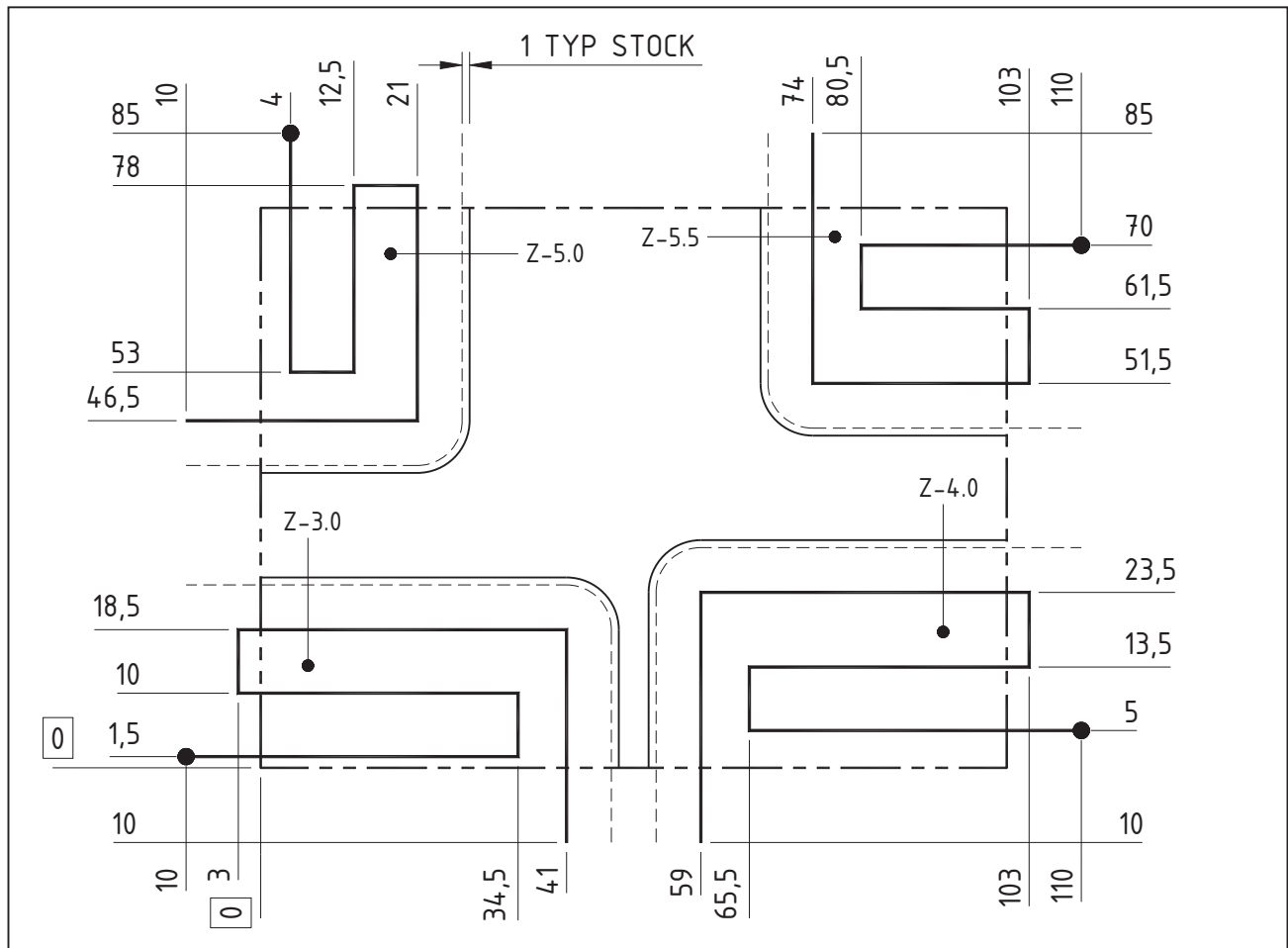


## Corners - Variable Depth

The four corners are roughed, finished and chamfered in the order of lower left, upper left, upper right, and lower right. The only difference between projects 33-08 and 33-09 is the depth. In this project, the depth of all four corners varies from 3 mm to 5.5 mm. The illustrations show roughing and finishing toolpaths with coordinates:



(33-09 - CORNERS - VARIABLE DEPTH)  
(T05 - 12 MM DIA END MILL = H05/D55)

N1 G21

N2 G17 G40 G80 T05

N3 M06

N4 G90 G54 G00 X-10.0 Y1.5 S850 M03 T19

(LOWER LEFT CORNER - ROUGH)

N5 G43 Z10.0 H05 M08

N6 Z-3.0

N7 G01 X34.5 F200.0

N8 Y10.0

N9 X-3.0

N10 Y18.5

N11 X41.0

N12 Y-10.0

N13 G00 Z10.0

(LOWER LEFT CORNER - FINISH)

N14 X40.0

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N15 Z-3.0
N16 G01 G41 D55 X48.0
N17 Y18.5
N18 G03 X41.0 Y25.5 I-7.0 J0
N19 G01 X-10.0
N20 G40 Y17.5
N21 G00 Z10.0
N22 X4.0 Y85.0 (UPPER LEFT CORNER - ROUGH)
N23 Z-5.0
N24 G01 Y53.0
N25 X12.5
N26 Y78.0
N27 X21.0
N28 Y46.5
N29 X-10.0
N30 G00 Z10.0
N31 Y47.5 (UPPER LEFT CORNER - FINISH)
N32 Z-5.0
N33 G01 G41 D55 Y39.5
N34 X21.0
N35 G03 X28.0 Y46.5 I0 J7.0
N36 G01 Y85.0
N37 G40 X20.0
N38 G00 Z10.0
N39 X110.0 Y70.0 (UPPER RIGHT CORNER - ROUGH)
N40 Z-5.5
N41 G01 X80.5
N42 Y61.5
N43 X103.0
N44 Y51.5
N45 X74.0
N46 Y85.0
N47 G00 Z10.0
N48 X75.0 (UPPER RIGHT CORNER - FINISH)
N49 Z-5.5
N50 G01 G41 D55 X67.0
N51 Y51.5
N52 G03 X74.0 Y44.5 I7.0 J0
N53 G01 X110.0
N54 G40 Y52.5
N55 G00 Z10.0
N56 Y5.0 (LOWER RIGHT CORNER - ROUGH)
N57 Z-4.0
N58 G01 X65.5
N59 Y13.5
N60 X103.0
N61 Y23.5
N62 X59.0
N63 Y-10.0
N64 G00 Z10.0
N65 X110.0 Y22.5 (LOWER RIGHT CORNER - FINISH)
N66 Z-4.0
N67 G01 G41 D55 Y30.5
N68 X59.0
N69 G03 X52.0 Y23.5 I0 J-7.0
N70 G01 Y-10.0
N71 G40 X60.0
N72 G00 Z10.0 M09
N73 G28 Z10.0 M05
N74 M01

(T19 - SMALL CHAMFERING TOOL = H19/D69)
(LEAVE THE Z-DEPTH AT Z-2.0 - ADJUST OFFSET)
N75 T19
N76 M06
N77 G90 G54 G00 X40.0 Y-10.0 S1200 M03 T05 (LOWER LEFT CORNER - CHAMFER)
N78 G43 Z10.0 H19 M08
N79 Z-2.0
N80 G01 G41 D69 X48.0
N81 Y18.5
N82 G03 X41.0 Y25.5 I-7.0 J0
N83 G01 X-10.0
N84 G40 Y17.5

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N85 G00 Z10.0
N86 X-10.0 Y47.5                                (UPPER LEFT CORNER - CHAMFER)
N87 Z-2.0
N88 G01 G41 D69 Y39.5
N89 X21.0
N90 G03 X28.0 Y46.5 I0 J7.0
N91 G01 Y85.0
N92 G40 X20.0
N93 G00 Z10.0
N94 X75.0 Y85.0                                (UPPER RIGHT CORNER - CHAMFER)
N95 Z-2.0
N96 G01 G41 D69 X67.0
N97 Y51.5
N98 G03 X74.0 Y44.5 I7.0 J0
N99 G01 X110.0
N100 G40 Y52.5
N101 G00 Z10.0
N102 X110.0 Y22.5                              (LOWER RIGHT CORNER - CHAMFER)
N103 Z-2.0
N104 G01 G41 D69 Y30.5
N105 X59.0
N106 G03 X52.0 Y23.5 I0 J-7.0
N107 G01 Y-10.0
N108 G40 X60.0
N109 G00 Z10.0 M09
N110 G28 Z10.0 M05
N111 G28 X60.0 Y-10.0
N112 M30
%
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