

Class Work-5 2nd Side

Monday, June 27, 2016 2:32 PM

O0004

N5 T0101

N10 G96 S180 G95 F0.1 M3

N15 G0 X32 Z10 (8+2)

N20 **G74** **W0.5** **R0.5**
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 Facing Cycle Depth of cut in Z Retract Height

N25 **G74** **P30** **Q40**

N30 G1 X30 Z0.2 1st point

N35 X-1 2nd point

N40 Z9 (8+1) 3rd point

Q

N45 G0 X32 Z0

N50 G1 X-1

N55 G0 X30 Z1

N60 **G73** **U0.5** **R1**

N65 **G73** **P70** **Q85** **U0.5** **W0.1** **F0.15**

N70 G1 X0 Z0 G42

N75 G3 X28 Z-14 R14

N80 G1 Z-15

N85 X30 G40

Q

N90 **G72** **P70** **Q85** **S240** **F0.1**

N95 G0 X50 Z50

N100 M30

