

SAMPLE CODE 4X HORIZONTAL WITH SUB-PROGRAMS

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O0100
( LISTED AS HOUSING FINAL.NC )
( MATERIAL, USE X X BANDSAW)
( EDGE FIND AND MOVE OFFSET X,Y )
( - APR-20-10 TIME - 21:34)
(T1 | 3 IN FACE MILL TOOL 1 | H1 | D41 | D3.0000" |
| CONTOUR....)
(T27 | 3/4 FINISHER TOOL 27 | H27 | D67 | D0.7500" |
| CONTOUR....)
(T32 | 1/4 DIA 82 DEG SPOT DRILL TOOL 32 | H32 | D72 | D0.2500" |
| DRILL/CBORE)
(T16 | 23/64 TWIST DRILL TOOL 16 | H16 | D56 | D0.3594" |
| CHIP BREAK.)
(T11 | 3/8 END MILL TOOL 11 | H11 | D51 | D0.3750" |
| POCKET.....)
(T40 | 1/4 CHF TOOL 40 | H40 | D80 | D0.2500" |
| CONTOUR....)
(T17 | 3-3 MM TWIST DRILL TOOL17 | H17 | D57 | D0.1299" |
| CHIP BREAK.)
(T18 | M4 X 7 TAP TOOL 18 | H18 | D58 | D0.1574" |
| TAP.....)
(T37 | TAP DRILL 190-32 TOOL 37 | H37 | D77 | D0.1770" |
| CHIP BREAK.)
(T39 | 190-32 TAP TOOL 39 | H39 | D79 | D0.1900" |
| TAP.....)
(T2 | 1/2 IN END MILL TOOL 2 | H2 | D42 | D0.5000" |
| CONTOUR....)
(T19 | 1/8 IN END MILL TOOL 19 | H19 | D59 | D0.1250" |
| CONTOUR....)
(T34 | DRILL FOR 164-32 TAP TOOL 34 | H34 | D74 | D0.1640" |
| CHIP BREAK.)
(T15 | 164 -32 TAP TOOL 15 | H15 | D55 | D0.1640" |
| TAP.....)
(T36 | DRILL FOR 138-32 TAP TOOL 36 | H36 | D76 | D0.1380" |
| CHIP BREAK.)
(T13 | 138-32 TAP TOOL 13 | H13 | D53 | D0.1380" |
| TAP.....)
(T38 | 27/64 TWIST DRILL TOOL 38 | H38 | D78 | D0.4210" |
| CHIP BREAK.)
(T25 | 3/8 END MILL 1/32 RAD TOOL 25 | H25 | D65 | D0.3750" |
R0.0320 | CONTOUR....)

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(T22 | 1/4 END MILL TOOL 22 | H18 | D58 | D0.2500" |
| CONTOUR....)
(T5 | #1 82 DEG CENTER DRILL TOOL 5 | H5 | D45 | D0.2500" |
| DRILL/CBORE)
(T12 | DRILL FOR 112-40 TAP TOOL 12 | H12 | D52 | D0.1130" |
| CHIP BREAK.)
(T7 | 112-40 TAP TOOL 7 | H7 | D47 | D0.1120" |
| TAP.....)
N10 G0 G40 G49 G80 G90
N20 M60
N30 M81 (PAL1)
N40 T1
N50 M6
N60 M8 (3 IN FACE MILL TOOL 1 )
N70 G54.1 P25
N80 G0 G90 B0 X-1.1125 Y1.9675 S3500 M3
N90 G43 H1 Z1.
N100 G1 Z.5 F300.
N110 T27
N120 M98 P0101
N130 G91 G28 Z0. M9
N140 G91 G28 X0. Y0. M6
N150 M8 (3/4 FINISHER TOOL 27)
N160 G54.1 P25
N170 G0 G90 B0 X.6273 Y-4.2998 S7000 M3
N180 G43 H27 Z1.
N190 G1 Z.5 F300.
N200 T32
N210 M98 P0102
N220 G91 G28 Z0. M9
N230 G91 G28 X0. Y0. M6
N240 M8 (1/4 DIA 82 DEG SPOT DRILL TOOL 32 )
N250 G54.1 P25
N260 G0 G90 B0 X-4.025 Y-9.465 S10000 M3
N270 G43 H32 Z1.
N280 G1 Z.5 F300.
N290 T16
N300 M98 P0103
N310 G91 G28 Z0. M9
N320 G91 G28 X0. Y0. M6
N330 M8 (23/64 TWIST DRILL TOOL 16)
N340 G54.1 P25
N350 G0 G90 B0 X-1.0475 Y-1.9375 S8000 M3
N360 G43 H16 Z1.
N370 G1 Z.5 F300.
N380 T11
N390 M98 P0104
N400 G91 G28 Z0. M9
N410 G91 G28 X0. Y0. M6
N420 M8 (3/8 END MILL TOOL 11)
N430 G54.1 P25
N440 G0 G90 B0 X-2.3582 Y-6.2421 S8000 M3
N450 G43 H11 Z1.
N460 G1 Z.5 F300.

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N470 T40
N480 M98 P0105
N490 G91 G28 Z0. M9
N500 G91 G28 X0. Y0. M6
N510 M8 (1/4 CHF TOOL 40)
N520 G54.1 P25
N530 G0 G90 B0 X-1.9339 Y-4.6271 S10000 M3
N540 G43 H40 Z1.
N550 G1 Z.5 F300.
N560 T17
N570 M98 P0106
N580 G91 G28 Z0. M9
N590 G91 G28 X0. Y0. M6
N600 M8 (3-3 MM TWIST DRILL TOOL17)
N610 G54.1 P25
N620 G0 G90 B0 X-4.025 Y-.2 S10000 M3
N630 G43 H17 Z1.
N640 G1 Z.5 F300.
N650 T18
N660 M98 P0107
N670 G91 G28 Z0. M9
N680 G91 G28 X0. Y0. M6
N690 M8 (M4 X 7 TAP TOOL 18)
N700 G54.1 P25
N710 G0 G90 B0 X-4.025 Y-.2 S500 M3
N720 G43 H18 Z1.
N730 G1 Z.5 F300.
N740 T32
N750 M98 P0108
N760 G91 G28 Z0. M9
N770 G91 G28 X0. Y0. M6
N780 M8 (1/4 DIA 82 DEG SPOT DRILL TOOL 32)
N790 G54.1 P27
N800 G0 G90 B0 X1.08 Y-7.5475 S10000 M3
N810 G43 H32 Z1.
N820 G1 Z.5 F300.
N830 T37
N840 M98 P0109
N850 G91 G28 Z0. M9
N860 G91 G28 X0. Y0. M6
N870 M8 (TAP DRILL 190-32 TOOL 37)
N880 G54.1 P27
N890 G0 G90 B0 X1.08 Y-1.9375 S10000 M3
N900 G43 H37 Z1.
N910 G1 Z.5 F300.
N920 T39
N930 M98 P0110
N940 G91 G28 Z0. M9
N950 G91 G28 X0. Y0. M6
N960 M8 (190-32 TAP TOOL 39)
N970 G54.1 P27
N980 G0 G90 B0 X1.08 Y-7.5475 S500 M3
N990 G43 H39 Z1.
N1000 G1 Z.5 F300.

N1010 T32
N1020 M98 P0111
N1030 G91 G28 Z0. M9
N1040 G91 G28 X0. Y0. M6
N1050 M8 (1/4 DIA 82 DEG SPOT DRILL TOOL 32)
N1060 G54.1 P26
N1070 G0 G90 B0 X-1.08 Y-2.8175 S10000 M3
N1080 G43 H32 Z1.
N1090 G1 Z.5 F300.
N1100 T37
N1110 M98 P0112
N1120 G91 G28 Z0. M9
N1130 G91 G28 X0. Y0. M6
N1140 M8 (TAP DRILL 190-32 TOOL 37)
N1150 G54.1 P26
N1160 G0 G90 B0 X-1.08 Y-2.8175 S10000 M3
N1170 G43 H37 Z1.
N1180 G1 Z.5 F300.
N1190 T39
N1200 M98 P0113
N1210 G91 G28 Z0. M9
N1220 G91 G28 X0. Y0. M6
N1230 M8 (190-32 TAP TOOL 39)
N1240 G54.1 P26
N1250 G0 G90 B0 X-1.08 Y-7.5475 S500 M3
N1260 G43 H39 Z1.
N1270 G1 Z.5 F300.
N1280 T27
N1290 M98 P0114
N1300 G91 G28 Z0. M9
N1310 G91 G28 X0. Y0. M6
N1320 M8 (3/4 FINISHER TOOL 27)
N1320M8 (3/4 FINISHER TOOL 27)
N1330G54.1P28
N1340G0G90B0X-.75Y0.S7000M3
N1350G43H27Z1.
N1360G1Z.5F300.
N1370T2
N1380M98P0115
N1390G91G28Z0.M9
N1400G91G28X0.Y0.M6
N1410 M8 (1/2 IN END MILL TOOL 2)
N1420 G54.1 P28
N1430 G0 G90 B0 X8.846 Y.425 S8000 M3
N1440 G43 H2 Z1.
N1450 G1 Z.5 F300.
N1460 T19
N1470 M98 P0116
N1480 G91 G28 Z0. M9
N1490 G91 G28 X0. Y0. M6
N1500 M8 (1/8 IN END MILL TOOL 19)
N1510 G54.1 P28
N1520 G0 G90 B0 X-.1025 Y-2.785 S10000 M3
N1530 G43 H19 Z1.

N1540 G1 Z.5 F300.
N1550 T32
N1560 M98 P0117
N1570 G91 G28 Z0. M9
N1580 G91 G28 X0. Y0. M6
N1590 M8 (1/4 DIA 82 DEG SPOT DRILL TOOL 32)
N1600 G54.1 P28
N1610 G0 G90 B0 X9.485 Y-2.1075 S10000 M3
N1620 G43 H32 Z1.
N1630 G1 Z.5 F300.
N1640 T34
N1650 M98 P0118
N1660 G91 G28 Z0. M9
N1670 G91 G28 X0. Y0. M6
N1680 M8 (DRILL FOR 164-32 TAP TOOL 34)
N1690 G54.1 P28
N1700 G0 G90 B0 X.55 Y-4.045 S10000 M3
N1710 G43 H34 Z1.
N1720 G1 Z.5 F300.
N1730 T15
N1740 M98 P0119
N1750 G91 G28 Z0. M9
N1760 G91 G28 X0. Y0. M6
N1770 M8 (164 -32 TAP TOOL 15)
N1780 G54.1 P28
N1790 G0 G90 B0 X9.485 Y-2.1075 S500 M3
N1800 G43 H15 Z1.
N1810 G1 Z.5 F300.
N1820 T36
N1830 M98 P0120
N1840 G91 G28 Z0. M9
N1850 G91 G28 X0. Y0. M6
N1860 M8 (DRILL FOR 138-32 TAP TOOL 36)
N1870 G54.1 P28
N1880 G0 G90 B0 X1.9375 Y-3.1775 S10000 M3
N1890 G43 H36 Z1.
N1900 G1 Z.5 F300.
N1910 T13
N1920 M98 P0121
N1930 G91 G28 Z0. M9
N1940 G91 G28 X0. Y0. M6
N1950 M8 (138-32 TAP TOOL 13)
N1960 G54.1 P28
N1970 G0 G90 B0 X8.6175 Y-2.1075 S500 M3
N1980 G43 H13 Z1.
N1990 G1 Z.5 F300.
N2000 T38
N2010 M98 P0122
N2020 G91 G28 Z0. M9
N2030 G91 G28 X0. Y0. M6
N2040 M8 (27/64 TWIST DRILL TOOL 38)
N2050 G54.1 P28
N2060 G0 G90 B0 X9.08 Y-2.1075 S6500 M3
N2070 G43 H38 Z1.

N2080 G1 Z.5 F300.
N2090 T25
N2100 M98 P0123
N2110 G91 G28 Z0. M9
N2120 G91 G28 X0. Y0. M6
N2130 M8 (3/8 END MILL 1/32 RAD TOOL 25)
N2140 G54.1 P28
N2150 G0 G90 B0 X3.28 Y-1.0475 S8000 M3
N2160 G43 H25 Z1.
N2170 G1 Z.5 F300.
N2180 T22
N2190 M98 P0124
N2200 G91 G28 Z0. M9
N2210 G91 G28 X0. Y0. M6
N2220 M8 (1/4 END MILL TOOL 22)
N2230 G54.1 P28
N2240 G0 G90 B0 X-.008 Y-4.485 S10000 M3
N2250 G43 H18 Z1.
N2260 G1 Z.5 F300.
N2270 T40
N2280 M98 P0125
N2290 G91 G28 Z0. M9
N2300 G91 G28 X0. Y0. M6
N2310 M8 (1/4 - 45 DEG CHF TOOL 40)
N2320 G54.1 P28
N2330 G0 G90 B0 X-.29 Y-.7115 S13000 M3
N2340 G43 H40 Z1.
N2350 G1 Z.5 F300.
N2360 T32
N2370 M98 P0126
N2380 G91 G28 Z0. M9
N2390 G91 G28 X0. Y0. M6
N2400 M8 (1/4 DIA 82 DEG SPOT DRILL TOOL 32)
N2410 G54.1 P30
N2420 G0 G90 B0 X.295 Y-2.1075 S10000 M3
N2430 G43 H32 Z1.
N2440 G1 Z.5 F300.
N2450 T37
N2460 M98 P0127
N2470 G91 G28 Z0. M9
N2480 G91 G28 X0. Y0. M6
N2490 M8 (TAP DRILL 190-32 TOOL 37)
N2500 G54.1 P30
N2510 G0 G90 B0 X.295 Y-2.1075 S10000 M3
N2520 G43 H37 Z1.
N2530 G1 Z.5 F300.
N2540 T39
N2550 M98 P0128
N2560 G91 G28 Z0. M9
N2570 G91 G28 X0. Y0. M6
N2580 M8 (190-32 TAP TOOL 39)
N2590 G54.1 P30
N2600 G0 G90 B0 X.295 Y-2.1075 S500 M3
N2610 G43 H39 Z1.

N2620 G1 Z.5 F300.
N2630 T5
N2640 M98 P0129
N2650 G91 G28 Z0. M9
N2660 G91 G28 X0. Y0. M6
N2670 M8 (#1 82 DEG CENTER DRILL TOOL 5)
N2680 G54.1 P29
N2690 G0 G90 B0 X-.31 Y-.175 S10000 M3
N2700 G43 H5 Z1.
N2710 G1 Z.5 F300.
N2720 T12
N2730 M98 P0130
N2740 G91 G28 Z0. M9
N2750 G91 G28 X0. Y0. M6
N2760 M8 (DRILL FOR 112-40 TAP TOOL 12)
N2770 G54.1 P29
N2780 G0 G90 B0 X-.31 Y-.175 S10000 M3
N2790 G43 H12 Z1.
N2800 G1 Z.5 F300.
N2810 T7
N2820 M98 P0131
N2830 G91 G28 Z0. M9
N2840 G91 G28 X0. Y0. M6
N2850 M8 (112-40 TAP TOOL 7)
N2860 G54.1 P29
N2870 G0 G90 B0 X-.31 Y-4.05 S500 M3
N2880 G43 H7 Z1.
N2890 G1 Z.5 F300.
N2900 T1
N2910 M98 P0132
N2920 G91 G28 Z0. M9
N2930 G91 G28 X0. Y0. M6
N2940 G90
N2950 M60
N2960 M82 (PAL2)
N2970 M30

O0101
(3 IN FACE MILL TOOL 1 - CONTOUR)
N10 G0 G90 B0 X-1.1125 Y1.9675
N20 Z.5 M10
N30 Z.1
N40 G1 Z0. F100.
N50 Y.1675 F45.
N60 Y-9.8325
N70 Y-11.6325
N80 G0 Z.5
N90 X-3.1125
N100 Z.1
N110 G1 Z0. F100.
N120 Y-9.8325 F45.
N130 Y.1675
N140 Y1.9675
N150 G0 Z.5

N160 G0 Z8. M11
N170 M99

O0102

(3/4 FINISHER TOOL 27 - CONTOUR)

N10 G0 G90 B0 X.6273 Y-4.2998
N20 Z.5 M10
N30 Z.1
N40 G1 Z-.3463 F100.
N50 G41 D67 X.4323 Y-4.6375 F45.
N60 G3 X.38 Y-4.8325 I.3377 J-.195
N70 G1 Y-9.665
N80 G2 X0. Y-10.045 I-.38 J0.
N90 G1 X-4.225
N100 G2 X-4.605 Y-9.665 I0. J.38
N110 G1 Y0.
N120 G2 X-4.225 Y.38 I.38 J0.
N130 G1 X0.
N140 G2 X.38 Y0. I0. J-.38
N150 G1 Y-4.8325
N160 Y-4.8525
N170 G3 X.3936 Y-4.9295 I.225 J0.
N180 G40 G1 X.4192 Y-4.9999
N190 G0 Z.5
N200 X.6273 Y-4.2998
N210 Z.1
N220 G1 Z-.6925 F100.
N230 G41 D67 X.4323 Y-4.6375 F45.
N240 G3 X.38 Y-4.8325 I.3377 J-.195
N250 G1 Y-9.665
N260 G2 X0. Y-10.045 I-.38 J0.
N270 G1 X-4.225
N280 G2 X-4.605 Y-9.665 I0. J.38
N290 G1 Y0.
N300 G2 X-4.225 Y.38 I.38 J0.
N310 G1 X0.
N320 G2 X.38 Y0. I0. J-.38
N330 G1 Y-4.8325
N340 Y-4.8525
N350 G3 X.3936 Y-4.9295 I.225 J0.
N360 G40 G1 X.4192 Y-4.9999
N370 G0 Z.5
N380 X.6273 Y-4.2998
N390 Z.1
N400 G1 Z-1.0388 F100.
N410 G41 D67 X.4323 Y-4.6375 F45.
N420 G3 X.38 Y-4.8325 I.3377 J-.195
N430 G1 Y-9.665
N440 G2 X0. Y-10.045 I-.38 J0.
N450 G1 X-4.225
N460 G2 X-4.605 Y-9.665 I0. J.38
N470 G1 Y0.
N480 G2 X-4.225 Y.38 I.38 J0.
N490 G1 X0.

N500 G2 X.38 Y0. I0. J-.38
 N510 G1 Y-4.8325
 N520 Y-4.8525
 N530 G3 X.3936 Y-4.9295 I.225 J0.
 N540 G40 G1 X.4192 Y-4.9999
 N550 G0 Z.5
 N560 X.6273 Y-4.2998
 N570 Z.1
 N580 G1 Z-1.385 F100.
 N590 G41 D67 X.4323 Y-4.6375 F45.
 N600 G3 X.38 Y-4.8325 I.3377 J-.195
 N610 G1 Y-9.665
 N620 G2 X0. Y-10.045 I-.38 J0.
 N630 G1 X-4.225
 N640 G2 X-4.605 Y-9.665 I0. J.38
 N650 G1 Y0.
 N660 G2 X-4.225 Y.38 I.38 J0.
 N670 G1 X0.
 N680 G2 X.38 Y0. I0. J-.38
 N690 G1 Y-4.8325
 N700 Y-4.8525
 N710 G3 X.3936 Y-4.9295 I.225 J0.
 N720 G40 G1 X.4192 Y-4.9999
 N730 G0 Z.5
 N740 X.6223 Y-4.2998
 N750 Z.1
 N760 G1 Z-1.385 F100.
 N770 G41 D67 X.4273 Y-4.6375 F45.
 N780 G3 X.375 Y-4.8325 I.3377 J-.195
 N790 G1 Y-9.665
 N800 G2 X0. Y-10.04 I-.375 J0.
 N810 G1 X-4.225
 N820 G2 X-4.6 Y-9.665 I0. J.375
 N830 G1 Y0.
 N840 G2 X-4.225 Y.375 I.375 J0.
 N850 G1 X0.
 N860 G2 X.375 Y0. I0. J-.375
 N870 G1 Y-4.8325
 N880 Y-4.8525
 N890 G3 X.3886 Y-4.9295 I.225 J0.
 N900 G40 G1 X.4142 Y-4.9999
 N910 G0 Z.5
 N920 G0 Z8. M11
 N930 M99

 O0103
 (1/4 DIA 82 DEG SPOT DRILL TOOL 32 - DRILL/CBORE)
 N10 G0 G90 B0 X-4.025 Y-9.465
 N20 Z.5 M10
 N30 G98 G82 Z-.085 R.1 P150 F20.
 N40 X-.2
 N50 Y-4.8325
 N60 X-4.025
 N70 Y-.2

N80 X-.2
N90 G80
N100 G98 G82 X-1.0475 Y-1.9375 Z-.109 R.1 P150 F20.
N110 Y-3.7075
N120 X-3.1775 Y-2.8175
N130 Y-5.1375
N140 X-1.0475 Y-5.5375
N150 Y-7.5475
N160 X-2.1175 Y-8.6175
N170 X-3.1775 Y-7.5475
N180 G80
N190 G0 Z8. M11
N200 M99

O0104
(23/64 TWIST DRILL TOOL 16 - CHIP BREAK)
N10 G0 G90 B0 X-1.0475 Y-1.9375
N20 Z.5 M10
N30 G98 G73 Z-.67 R.1 Q.1 F20.
N40 Y-3.7075
N50 X-3.1775 Y-2.8175
N60 Y-5.1375
N70 X-1.0475 Y-5.5375
N80 Y-7.5475
N90 X-2.1175 Y-8.6175
N100 X-3.1775 Y-7.5475
N110 G80
N120 G0 Z8. M11
N130 M99

O0105
(3/8 END MILL TOOL 11 - POCKET)
N10 G0 G90 B0 X-2.3582 Y-6.2421
N20 Z.5 M10
N30 Z.1
N40 G1 X-2.1775 Z.0905 F25.
N50 X-2.5326 Z.0719
N60 X-2.1775 Z.0533
N70 X-2.5326 Z.0347
N80 X-2.1775 Z.0161
N90 X-2.5326 Z-.0025
N100 X-2.1775 Z-.0211
N110 X-2.5326 Z-.0397
N120 X-2.1775 Z-.0583
N130 X-2.5326 Z-.077
N140 X-2.1775 Z-.0956
N150 X-2.5326 Z-.1142
N160 X-2.1775 Z-.1328
N170 X-2.5326 Z-.1514
N180 X-2.1775 Z-.17
N190 X-2.3025 Y-6.2767 F45.
N200 G2 X-2.438 Y-6.3425 I-.4125 J.6767
N210 X-2.3025 Y-6.4083 I-.277 J-.7425
N220 G1 Y-6.2767

N230 X-2.3026 Y-6.2766
N240 X-2.2941 Y-6.2615
N250 X-2.2734 Y-6.2226
N260 X-2.2544 Y-6.1848
N270 X-2.237 Y-6.1479
N280 X-2.2212 Y-6.1118
N290 X-2.2067 Y-6.0764
N300 X-2.1935 Y-6.0418
N310 X-2.1815 Y-6.0078
N320 X-2.1707 Y-5.9744
N330 X-2.1609 Y-5.9414
N340 X-2.1521 Y-5.909
N350 X-2.1443 Y-5.877
N360 X-2.1375 Y-5.8453
N370 X-2.1315 Y-5.8139
N380 X-2.1264 Y-5.7829
N390 X-2.1221 Y-5.752
N400 X-2.1186 Y-5.7214
N410 X-2.1159 Y-5.6909
N420 X-2.114 Y-5.6605
N430 X-2.1129 Y-5.6303
N440 X-2.1125 Y-5.6
N450 Y-4.675
N460 X-2.1129 Y-4.6434
N470 X-2.1142 Y-4.6117
N480 X-2.1162 Y-4.58
N490 X-2.1192 Y-4.5481
N500 X-2.123 Y-4.516
N510 X-2.1277 Y-4.4837
N520 X-2.1333 Y-4.4512
N530 X-2.1398 Y-4.4183
N540 X-2.1474 Y-4.3851
N550 X-2.156 Y-4.3514
N560 X-2.1656 Y-4.3173
N570 X-2.1764 Y-4.2826
N580 X-2.1884 Y-4.2473
N590 X-2.2017 Y-4.2114
N600 X-2.2164 Y-4.1747
N610 X-2.2325 Y-4.1372
N620 X-2.2502 Y-4.0988
N630 X-2.2697 Y-4.0595
N640 X-2.291 Y-4.0191
N650 X-2.3026 Y-3.9984
N660 X-2.3025 Y-3.9983
N670 Y-3.9567
N680 G2 X-2.3388 Y-3.9775 I-.4125 J.6767
N690 X-2.3025 Y-3.9983 I-.3762 J-.6975
N700 G1 X-2.3026 Y-3.9984
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N720 X-2.291 Y-3.9359
N730 X-2.2697 Y-3.8955
N740 X-2.2502 Y-3.8562
N750 X-2.2325 Y-3.8178
N760 X-2.2164 Y-3.7803

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N780 X-2.1884 Y-3.7077
N790 X-2.1764 Y-3.6724
N800 X-2.1656 Y-3.6377
N810 X-2.156 Y-3.6036
N820 X-2.1474 Y-3.5699
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N840 X-2.1333 Y-3.5038
N850 X-2.1277 Y-3.4713
N860 X-2.123 Y-3.439
N870 X-2.1192 Y-3.4069
N880 X-2.1162 Y-3.375
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N900 X-2.1129 Y-3.3116
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N920 Y-2.355
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N940 X-2.1138 Y-2.2987
N950 X-2.1155 Y-2.2704
N960 X-2.1178 Y-2.2421
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N980 X-2.1245 Y-2.185
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N1100 X-2.233 Y-1.8161
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N1140 X-2.3045 Y-1.6747
N1150 X-2.3264 Y-1.6371
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N1230 Y-1.225
N1240 X-2.715
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N1260 G1 X-2.6513 Y-1.1772
N1270 X-2.6734 Y-1.1469
N1280 X-2.6967 Y-1.1151
N1290 X-2.7013 Y-1.115
N1300 X-2.7058

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N1360 Y-1.3375
N1370 X-2.715
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N1430 Y-.6675
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N1520 Y-4.1075
N1530 X-2.715
N1540 G2 X-2.1475 Y-4.675 I0. J-.5675
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N1560 G2 X-2.715 Y-6.1675 I-.5675 J0.
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N1580 Y-6.5175
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N1680 G3 X-.575 Y-.4425 I-.1825 J0.
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N1820 X-2.1775 Z-.1539
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N1840 X-2.1775 Z-.1911

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N1870 X-2.5326 Z-.247
N1880 X-2.1775 Z-.2656
N1890 X-2.5326 Z-.2842
N1900 X-2.1775 Z-.3028
N1910 X-2.5326 Z-.3214
N1920 X-2.1775 Z-.34
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N1950 X-2.3025 Y-6.4083 I-.277 J-.7425
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N1990 X-2.2734 Y-6.2226
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N2090 X-2.1443 Y-5.877
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N2110 X-2.1315 Y-5.8139
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N2190 Y-4.675
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N2290 X-2.156 Y-4.3514
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N2340 X-2.2164 Y-4.1747
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N2360 X-2.2502 Y-4.0988
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N2380 X-2.291 Y-4.0191

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N3980 X-2.123 Y-4.516
N3990 X-2.1277 Y-4.4837
N4000 X-2.1333 Y-4.4512

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N4780 X-2.7058
N4790 X-2.715
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N8560 G2 X-2.1475 Y-7.085 I0. J-.5675
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N8640 G3 X-.575 Y-.4425 I-.1825 J0.
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N8680 G3 X-3.65 Y-1.7875 I.1825 J0.
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N9640 G3 X-3.32 Y-8.5775 I-.1825 J0.
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N9870 Y-8.8025
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N9890 Y-8.5775
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N9970 G3 X-3.32 Y-8.5775 I-.1825 J0.
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N120 X-3.2375 Z-.6014
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N140 X-3.2375 Z-.6407
N150 X-3.6125 Z-.6603
N160 X-3.2375 Z-.68
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N190 Y-8.9975
N200 X-3.3625
N210 Y-8.8025
N220 X-3.32 Y-8.76
N230 Y-8.5775
N240 X-3.65
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N760 G40 G3 X-3.32 Y-8.5725 I-.1875 J0.
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N810 X-.4925 Z.0658
N820 X-.8675 Z.0462
N830 X-.4925 Z.0265
N840 X-.8675 Z.0069
N850 X-.4925 Z-.0128
N860 X-.8675 Z-.0324
N870 X-.4925 Z-.0521
N880 X-.8675 Z-.0717
N890 X-.4925 Z-.0914
N900 X-.8675 Z-.111
N910 X-.4925 Z-.1307
N920 X-.8675 Z-.1503
N930 X-.4925 Z-.17
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N960 Y-8.9975
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N980 Y-8.8025
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N1000 X-.3925
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N1030 G3 X-1.0875 Y-8.76 I0. J-.1825

N1040 G1 Y-9.04
N1050 G3 X-.905 Y-9.2225 I.1825 J0.
N1060 G1 X-.575
N1070 G3 X-.3925 Y-9.04 I0. J.1825
N1080 G1 Y-8.76
N1090 G0 Z.5
N1100 X-.5906 Y-8.8259
N1110 Z.1
N1120 G1 Z-.07 F25.
N1130 X-.8675 Z-.0845
N1140 X-.4925 Z-.1042
N1150 X-.8675 Z-.1238
N1160 X-.4925 Z-.1435
N1170 X-.8675 Z-.1631
N1180 X-.4925 Z-.1828
N1190 X-.8675 Z-.2024
N1200 X-.4925 Z-.2221
N1210 X-.8675 Z-.2417
N1220 X-.4925 Z-.2614
N1230 X-.8675 Z-.281
N1240 X-.4925 Z-.3007
N1250 X-.8675 Z-.3203
N1260 X-.4925 Z-.34
N1270 X-.6175 Y-8.8025 F45.
N1280 X-.8625
N1290 Y-8.9975
N1300 X-.6175
N1310 Y-8.8025
N1320 X-.575 Y-8.76
N1330 X-.3925
N1340 G3 X-.575 Y-8.5775 I-.1825 J0.
N1350 G1 X-.905
N1360 G3 X-1.0875 Y-8.76 I0. J-.1825
N1370 G1 Y-9.04
N1380 G3 X-.905 Y-9.2225 I.1825 J0.
N1390 G1 X-.575
N1400 G3 X-.3925 Y-9.04 I0. J.1825
N1410 G1 Y-8.76
N1420 G0 Z.5
N1430 X-.5906 Y-8.8259
N1440 Z.1
N1450 G1 Z-.24 F25.
N1460 X-.8675 Z-.2545
N1470 X-.4925 Z-.2742
N1480 X-.8675 Z-.2938
N1490 X-.4925 Z-.3135
N1500 X-.8675 Z-.3331
N1510 X-.4925 Z-.3528
N1520 X-.8675 Z-.3724
N1530 X-.4925 Z-.3921
N1540 X-.8675 Z-.4117
N1550 X-.4925 Z-.4314
N1560 X-.8675 Z-.451
N1570 X-.4925 Z-.4707

N1580 X-.8675 Z-.4903
N1590 X-.4925 Z-.51
N1600 X-.6175 Y-8.8025 F45.
N1610 X-.8625
N1620 Y-8.9975
N1630 X-.6175
N1640 Y-8.8025
N1650 X-.575 Y-8.76
N1660 X-.3925
N1670 G3 X-.575 Y-8.5775 I-.1825 J0.
N1680 G1 X-.905
N1690 G3 X-1.0875 Y-8.76 I0. J-.1825
N1700 G1 Y-9.04
N1710 G3 X-.905 Y-9.2225 I.1825 J0.
N1720 G1 X-.575
N1730 G3 X-.3925 Y-9.04 I0. J.1825
N1740 G1 Y-8.76
N1750 G0 Z.5
N1760 X-.5906 Y-8.8259
N1770 Z.1
N1780 G1 Z-.41 F25.
N1790 X-.8675 Z-.4245
N1800 X-.4925 Z-.4442
N1810 X-.8675 Z-.4638
N1820 X-.4925 Z-.4835
N1830 X-.8675 Z-.5031
N1840 X-.4925 Z-.5228
N1850 X-.8675 Z-.5424
N1860 X-.4925 Z-.5621
N1870 X-.8675 Z-.5817
N1880 X-.4925 Z-.6014
N1890 X-.8675 Z-.621
N1900 X-.4925 Z-.6407
N1910 X-.8675 Z-.6603
N1920 X-.4925 Z-.68
N1930 X-.6175 Y-8.8025 F45.
N1940 X-.8625
N1950 Y-8.9975
N1960 X-.6175
N1970 Y-8.8025
N1980 X-.575 Y-8.76
N1990 X-.3925
N2000 G3 X-.575 Y-8.5775 I-.1825 J0.
N2010 G1 X-.905
N2020 G3 X-1.0875 Y-8.76 I0. J-.1825
N2030 G1 Y-9.04
N2040 G3 X-.905 Y-9.2225 I.1825 J0.
N2050 G1 X-.575
N2060 G3 X-.3925 Y-9.04 I0. J.1825
N2070 G1 Y-8.76
N2080 G0 Z.5
N2090 X-.5906 Y-8.8259
N2100 Z.1
N2110 G1 Z-.58 F25.

N2120 X-.8675 Z-.5945
N2130 X-.4925 Z-.6142
N2140 X-.8675 Z-.6338
N2150 X-.4925 Z-.6535
N2160 X-.8675 Z-.6731
N2170 X-.4925 Z-.6928
N2180 X-.8675 Z-.7124
N2190 X-.4925 Z-.7321
N2200 X-.8675 Z-.7517
N2210 X-.4925 Z-.7714
N2220 X-.8675 Z-.791
N2230 X-.4925 Z-.8107
N2240 X-.8675 Z-.8303
N2250 X-.4925 Z-.85
N2260 X-.6175 Y-8.8025 F45.
N2270 X-.8625
N2280 Y-8.9975
N2290 X-.6175
N2300 Y-8.8025
N2310 X-.575 Y-8.76
N2320 X-.3925
N2330 G3 X-.575 Y-8.5775 I-.1825 J0.
N2340 G1 X-.905
N2350 G3 X-1.0875 Y-8.76 I0. J-.1825
N2360 G1 Y-9.04
N2370 G3 X-.905 Y-9.2225 I.1825 J0.
N2380 G1 X-.575
N2390 G3 X-.3925 Y-9.04 I0. J.1825
N2400 G1 Y-8.76
N2410 G0 Z.5
N2420 X-.575 Y-8.5725
N2430 Z.1
N2440 G1 Z-.85 F25.
N2450 G41 D51 X-.905 F45.
N2460 G3 X-1.0925 Y-8.76 I0. J-.1875
N2470 G1 Y-9.04
N2480 G3 X-.905 Y-9.2275 I.1875 J0.
N2490 G1 X-.575
N2500 G3 X-.3875 Y-9.04 I0. J.1875
N2510 G1 Y-8.76
N2520 G40 G3 X-.575 Y-8.5725 I-.1875 J0.
N2530 G0 Z.5
N2540 X-1.0475 Y-1.9375
N2550 S6500
N2560 G98 G82 Z-.675 R.1 P150 F36.
N2570 X-3.1775 Y-2.8175
N2580 X-1.0475 Y-3.7075
N2590 X-3.1775 Y-5.1375
N2600 X-1.0475 Y-5.5375
N2610 Y-7.5475
N2620 X-3.1775
N2630 X-2.1175 Y-8.6175
N2640 G80
N2650 G0 Z8. M11

N2660 M99

O0106

(1/4 CHF TOOL 40 - CONTOUR)

N10 G0 G90 B0 X-1.9339 Y-4.6271

N20 Z.5 M10

N30 Z.1

N40 G1 Z-.015 F100.

N50 G41 D80 X-1.9089 Y-4.5838 F120.

N60 G3 X-1.8955 Y-4.5338 I-.0866 J.05

N70 G1 Y-1.475

N80 G2 X-1.51 Y-1.0895 I.3855 J0.

N90 G1 X-.575

N100 G3 X-.2105 Y-.725 I0. J.3645

N110 G1 Y-.625

N120 G3 X-.575 Y-.2605 I-.3645 J0.

N130 G1 X-3.65

N140 G3 X-4.0145 Y-.625 I0. J-.3645

N150 G1 Y-1.605

N160 G3 X-3.65 Y-1.9695 I.3645 J0.

N170 G1 X-2.715

N180 G2 X-2.3295 Y-2.355 I0. J-.3855

N190 G1 Y-3.28

N200 G2 X-2.715 Y-3.6655 I-.3855 J0.

N210 G1 X-3.8375

N220 G3 X-4.0145 Y-3.8425 I0. J-.177

N230 G1 Y-4.1125

N240 G3 X-3.8375 Y-4.2895 I.177 J0.

N250 G1 X-2.715

N260 G2 X-2.3295 Y-4.675 I0. J-.3855

N270 G1 Y-5.6

N280 G2 X-2.715 Y-5.9855 I-.3855 J0.

N290 G1 X-3.8375

N300 G3 X-4.0145 Y-6.1625 I0. J-.177

N310 G1 Y-6.5225

N320 G3 X-3.8375 Y-6.6995 I.177 J0.

N330 G1 X-2.715

N340 G2 X-2.3295 Y-7.085 I0. J-.3855

N350 G1 Y-7.5925

N360 G3 X-2.1525 Y-7.7695 I.177 J0.

N370 G1 X-2.0725

N380 G3 X-1.8955 Y-7.5925 I0. J.177

N390 G1 Y-4.5338

N400 Y-4.5138

N410 G3 X-1.9089 Y-4.4638 I-.1 J0.

N420 G40 G1 X-1.9214 Y-4.4421

N430 G0 Z.5

N440 X-2.9939 Y-8.9933

N450 Z.1

N460 G1 Z-.015 F100.

N470 G41 D80 X-2.9689 Y-8.95 F120.

N480 G3 X-2.9555 Y-8.9 I-.0866 J.05

N490 G1 Y-8.76

N500 G3 X-3.32 Y-8.3955 I-.3645 J0.

N510 G1 X-3.65
N520 G3 X-4.0145 Y-8.76 I0. J-.3645
N530 G1 Y-9.04
N540 G3 X-3.65 Y-9.4045 I.3645 J0.
N550 G1 X-3.32
N560 G3 X-2.9555 Y-9.04 I0. J.3645
N570 G1 Y-8.9
N580 Y-8.88
N590 G3 X-2.9689 Y-8.83 I-.1 J0.
N600 G40 G1 X-2.9814 Y-8.8084
N610 G0 Z.5
N620 X-.2489 Y-8.9933
N630 Z.1
N640 G1 Z-.015 F100.
N650 G41 D80 X-.2239 Y-8.95 F120.
N660 G3 X-.2105 Y-8.9 I-.0866 J.05
N670 G1 Y-8.76
N680 G3 X-.575 Y-8.3955 I-.3645 J0.
N690 G1 X-.905
N700 G3 X-1.2695 Y-8.76 I0. J-.3645
N710 G1 Y-9.04
N720 G3 X-.905 Y-9.4045 I.3645 J0.
N730 G1 X-.575
N740 G3 X-.2105 Y-9.04 I0. J.3645
N750 G1 Y-8.9
N760 Y-8.88
N770 G3 X-.2239 Y-8.83 I-.1 J0.
N780 G40 G1 X-.2364 Y-8.8084
N790 G0 Z.5
N800 X-3.2309 Y-2.8469
N810 Z.1
N820 G1 Z-.015 F100.
N830 G41 D80 X-3.248 Y-2.8939 F120.
N840 G3 X-3.1775 Y-2.9945 I.0705 J-.0256
N850 Y-2.6405 I0. J.177
N860 Y-2.9945 I0. J-.177
N870 X-3.1575 Y-2.9934 I0. J.177
N880 X-3.1326 Y-2.986 I-.0085 J.0745
N890 G40 G1 X-3.1102 Y-2.9748
N900 G0 Z.5
N910 X-1.1009 Y-1.9669
N920 Z.1
N930 G1 Z-.015 F100.
N940 G41 D80 X-1.118 Y-2.0139 F120.
N950 G3 X-1.0475 Y-2.1145 I.0705 J-.0256
N960 Y-1.7605 I0. J.177
N970 Y-2.1145 I0. J-.177
N980 X-1.0275 Y-2.1134 I0. J.177
N990 X-1.0026 Y-2.106 I-.0085 J.0745
N1000 G40 G1 X-.9802 Y-2.0948
N1010 G0 Z.5
N1020 X-1.1009 Y-3.7369
N1030 Z.1
N1040 G1 Z-.015 F100.

N1050 G41 D80 X-1.118 Y-3.7839 F120.
N1060 G3 X-1.0475 Y-3.8845 I.0705 J-.0256
N1070 Y-3.5305 I0. J.177
N1080 Y-3.8845 I0. J-.177
N1090 X-1.0275 Y-3.8834 I0. J.177
N1100 X-1.0026 Y-3.876 I-.0085 J.0745
N1110 G40 G1 X-.9802 Y-3.8648
N1120 G0 Z.5
N1130 X-1.1009 Y-5.5669
N1140 Z.1
N1150 G1 Z-.015 F100.
N1160 G41 D80 X-1.118 Y-5.6139 F120.
N1170 G3 X-1.0475 Y-5.7145 I.0705 J-.0256
N1180 Y-5.3605 I0. J.177
N1190 Y-5.7145 I0. J-.177
N1200 X-1.0275 Y-5.7134 I0. J.177
N1210 X-1.0026 Y-5.706 I-.0085 J.0745
N1220 G40 G1 X-.9802 Y-5.6948
N1230 G0 Z.5
N1240 X-3.2309 Y-5.1669
N1250 Z.1
N1260 G1 Z-.015 F100.
N1270 G41 D80 X-3.248 Y-5.2139 F120.
N1280 G3 X-3.1775 Y-5.3145 I.0705 J-.0256
N1290 Y-4.9605 I0. J.177
N1300 Y-5.3145 I0. J-.177
N1310 X-3.1575 Y-5.3134 I0. J.177
N1320 X-3.1326 Y-5.306 I-.0085 J.0745
N1330 G40 G1 X-3.1102 Y-5.2948
N1340 G0 Z.5
N1350 X-3.2309 Y-7.5769
N1360 Z.1
N1370 G1 Z-.015 F100.
N1380 G41 D80 X-3.248 Y-7.6239 F120.
N1390 G3 X-3.1775 Y-7.7245 I.0705 J-.0256
N1400 Y-7.3705 I0. J.177
N1410 Y-7.7245 I0. J-.177
N1420 X-3.1575 Y-7.7234 I0. J.177
N1430 X-3.1326 Y-7.716 I-.0085 J.0745
N1440 G40 G1 X-3.1102 Y-7.7048
N1450 G0 Z.5
N1460 X-1.1009 Y-7.5769
N1470 Z.1
N1480 G1 Z-.015 F100.
N1490 G41 D80 X-1.118 Y-7.6239 F120.
N1500 G3 X-1.0475 Y-7.7245 I.0705 J-.0256
N1510 Y-7.3705 I0. J.177
N1520 Y-7.7245 I0. J-.177
N1530 X-1.0275 Y-7.7234 I0. J.177
N1540 X-1.0026 Y-7.716 I-.0085 J.0745
N1550 G40 G1 X-.9802 Y-7.7048
N1560 G0 Z.5
N1570 X-2.1709 Y-8.6469
N1580 Z.1

N1590 G1 Z-.015 F100.
N1600 G41 D80 X-2.188 Y-8.6939 F120.
N1610 G3 X-2.1175 Y-8.7945 I.0705 J-.0256
N1620 Y-8.4405 I0. J.177
N1630 Y-8.7945 I0. J-.177
N1640 X-2.0975 Y-8.7934 I0. J.177
N1650 X-2.0726 Y-8.786 I-.0085 J.0745
N1660 G40 G1 X-2.0502 Y-8.7748
N1670 G0 Z.5
N1680 X.0929 Y-4.6549
N1690 Z.1
N1700 G1 Z-.027 F100.
N1710 G41 D80 X.0279 Y-4.7675 F120.
N1720 G3 X.0105 Y-4.8325 I.1126 J-.065
N1730 G1 Y-9.665
N1740 G2 X0. Y-9.6755 I-.0105 J0.
N1750 G1 X-4.225
N1760 G2 X-4.2355 Y-9.665 I0. J.0105
N1770 G1 Y0.
N1780 G2 X-4.225 Y.0105 I.0105 J0.
N1790 G1 X0.
N1800 G2 X.0105 Y0. I0. J-.0105
N1810 G1 Y-4.8325
N1820 Y-4.8525
N1830 G3 X.015 Y-4.8782 I.075 J0.
N1840 G40 G1 X.0236 Y-4.9016
N1850 G0 Z.5
N1860 G0 Z8. M11
N1870 M99

O0107
(3-3 MM TWIST DRILL TOOL17 - CHIP BREAK)
N10 G0 G90 B0 X-4.025 Y-.2
N20 Z.5 M10
N30 G98 G73 Z-.469 R.1 Q.05 F20.
N40 X-.2
N50 Y-4.8325
N60 X-4.025
N70 Y-9.465
N80 X-.2
N90 G80
N100 G0 Z8. M11
N110 M99

O0108
(M4 X 7 TAP TOOL 18 - TAP)
N10 G0 G90 B0 X-4.025 Y-.2
N20 Z.5 M10
N30 G98 G84.2 Z-.365 R.1 F13.75 S500
N40 X-.2
N50 Y-4.8325
N60 X-4.025
N70 Y-9.465
N80 X-.2

N90 G80
N100 G0 Z8. M11
N110 M99

O0109
(1/4 DIA 82 DEG SPOT DRILL TOOL 32 - DRILL/CBORE)
N10 G0 G90 B0 X1.08 Y-7.5475
N20 Z.5 M10
N30 G98 G82 Z-.109 R.1 P150 F20.
N40 Y-5.5375
N50 Y-3.7075
N60 Y-1.9375
N70 G80
N80 G0 Z8. M11
N90 M99

O0110
(TAP DRILL 190-32 TOOL 37 - CHIP BREAK)
N10 G0 G90 B0 X1.08 Y-1.9375
N20 Z.5 M10
N30 G98 G73 Z-.5682 R.1 Q.05 F20.
N40 Y-3.7075
N50 Y-5.5375
N60 Y-7.5475
N70 G80
N80 G0 Z8. M11
N90 M99

O0111
(190-32 TAP TOOL 39 - TAP)
N10 G0 G90 B0 X1.08 Y-7.5475
N20 Z.5 M10
N30 G98 G84.2 Z-.465 R.1 F15.63 S500
N40 Y-5.5375
N50 Y-3.7075
N60 Y-1.9375
N70 G80
N80 G0 Z8. M11
N90 M99

O0112
(1/4 DIA 82 DEG SPOT DRILL TOOL 32 - DRILL/CBORE)
N10 G0 G90 B0 X-1.08 Y-2.8175
N20 Z.5 M10
N30 G98 G82 Z-.109 R.1 P150 F20.
N40 Y-5.1375
N50 Y-7.5475
N60 G80
N70 G0 Z8. M11
N80 M99

O0113
(TAP DRILL 190-32 TOOL 37 - PECK DRILL)
N10 G0 G90 B0 X-1.08 Y-2.8175

N20 Z.5 M10
N30 G98 G83 Z-.5682 R.1 Q.05 F20.
N40 Y-5.1375
N50 Y-7.5475
N60 G80
N70 G0 Z8. M11
N80 M99

O0114
(190-32 TAP TOOL 39 - TAP)
N10 G0 G90 B0 X-1.08 Y-7.5475
N20 Z.5 M10
N30 G98 G84.2 Z-.48 R.1 F15.63 S500
N40 Y-5.1375
N50 Y-2.8175
N60 G80
N70 G0 Z8. M11
N80 M99

O0115
(3/4 FINISHER TOOL 27 - CONTOUR)
N10G0G90B0X-.75Y0.
N20Z.5M10
N30Z.22
N40G1Z.06F100.
N50X0.F80.
N60X9.852
N70Y-.625
N80X-.187
N90Y-1.225
N100X9.852
N110Y-1.825
N120X-.187
N130Y-2.425
N140X9.852
N150Y-3.025
N160X-.187
N170Y-3.625
N180X9.852
N190Y-4.225
N200X0.
N210X-.45
N220G0Z.5
N230X-.75
N240Z.22
N250G1Z.01F100.
N260X0.F80.
N270X9.852
N280Y-3.625
N290X-.187
N300Y-3.025
N310X9.852
N320Y-2.425
N330X-.187

N340Y-1.825
N350X9.852
N360Y-1.225
N370X-.187
N380Y-.625
N390X9.852
N400Y0.
N410X0.
N420X-.45
N430G0Z.5
N440X-.75
N450Z.22
N460G1Z0.F100.
N470X0.F80.
N480X9.852
N490Y-.625
N500X-.187
N510Y-1.225
N520X9.852
N530Y-1.825
N540X-.187
N550Y-2.425
N560X9.852
N570Y-3.025
N580X-.187
N590Y-3.625
N600X9.852
N610Y-4.225
N620X0.
N630X-.45
N640G0Z.5
N650G0Z8.M11
N660M99

O0116
(1/2 IN END MILL TOOL 2 - CONTOUR)
N10 G0 G90 B0 X8.846 Y.425
N20 Z.5 M10
N30 Z.1
N40 G1 Z-.015 F100.
N50 G41 D42 Y.325 F45.
N60 G3 X9.096 Y.075 I.25 J0.
N70 G2 X9.796 Y-.625 I0. J-.7
N80 G3 X10.046 Y-.875 I.25 J0.
N90 G40 G1 X10.146
N100 G0 Z.5
N110 Y-3.35
N120 Z.1
N130 G1 Z-.015 F100.
N140 G41 D42 X10.046 F45.
N150 G3 X9.796 Y-3.6 I0. J-.25
N160 G2 X9.096 Y-4.3 I-.7 J0.
N170 G3 X8.846 Y-4.55 I0. J-.25
N180 G40 G1 Y-4.65

N190 G0 Z.5
N200 X-.4 Y-.023
N210 Z.1
N220 G1 Z-.015 F100.
N230 G41 D42 X0. F45.
N240 X8.796
N250 G2 X9.698 Y-.925 I0. J-.902
N260 G1 Y-1.4886
N270 G3 X9.7012 Y-1.5017 I.028 J0.
N280 G2 Y-2.7133 I-1.1457 J-.6058
N290 G3 X9.698 Y-2.7264 I.0248 J-.0131
N300 G1 Y-3.3
N310 G2 X8.796 Y-4.202 I-.902 J0.
N320 G1 X0.
N330 G40 X-.4
N340 G0 Z.5
N350 X-.375 Y-2.1125
N360 Z.1
N370 G1 Z-.015 F100.
N380 X7.495 Y-2.1137 F45.
N390 G0 Z.5
N400 X-.79 Y-.4655
N410 Z.1
N420 G1 Z-.015 F100.
N430 G41 D42 X.21 F45.
N440 X2.0049
N450 G2 X3.6301 I.8126 J-.582
N460 G1 X4.3249
N470 G2 X5.9501 I.8126 J-.582
N480 G1 X6.7349
N490 G2 X8.3601 I.8126 J-.582
N500 G1 X8.885
N510 G2 X9.1995 Y-.78 I0. J-.3145
N520 G1 Y-1.2949
N530 G2 Y-2.9201 I-.582 J-.8126
N540 G1 Y-3.435
N550 G2 X8.885 Y-3.7495 I-.3145 J0.
N560 G1 X8.3671
N570 G2 X6.7349 Y-3.7595 I-.8196 J.572
N580 G1 X6.3501
N590 G2 X4.7249 I-.8126 J.582
N600 G1 X4.5201
N610 G2 X2.8949 I-.8126 J.582
N620 G1 X2.7501
N630 G2 X1.1249 I-.8126 J.582
N640 G1 X.21
N650 G40 X-.79
N660 G0 Z.5
N670 Y-2.5955
N680 Z.1
N690 G1 Z-.015 F100.
N700 G41 D42 X.21 F45.
N710 X1.1249
N720 G2 X2.7501 I.8126 J-.582

N730 G1 X2.8949
N740 G2 X4.5201 I.8126 J-.582
N750 G1 X4.7249
N760 G2 X6.3501 I.8126 J-.582
N770 G1 X6.7349
N780 G2 X7.6207 Y-2.1807 I.8126 J-.582
N790 X7.62 Y-2.0444 I.9968 J.0732
N800 X6.7349 Y-1.6295 I-.0725 J.9969
N810 G1 X5.9501
N820 G2 X4.3249 I-.8126 J.582
N830 G1 X3.6301
N840 G2 X2.0049 I-.8126 J.582
N850 G1 X.21
N860 G40 X-.79
N870 G0 Z.5
N880 G0 Z8. M11
N890 M99

O0117
(1/8 IN END MILL TOOL 19 - CONTOUR)
N10 G0 G90 B0 X-.1025 Y-2.785
N20 Z.5 M10
N30 Z.1
N40 G1 Z-.015 F100.
N50 G41 D59 X.21 F32.
N60 X1.2289
N70 G2 X2.6461 I.7086 J-.3925
N80 G1 X2.9989
N90 G2 X4.4161 I.7086 J-.3925
N100 G1 X4.8289
N110 G2 X6.2461 I.7086 J-.3925
N120 G1 X6.8389
N130 G2 X7.878 Y-2.438 I.7086 J-.3925
N140 X7.8726 Y-1.7894 I.7395 J.3305
N150 X6.8389 Y-1.44 I-.3251 J.7419
N160 G1 X5.8461
N170 G2 X4.4289 I-.7086 J.3925
N180 G1 X3.5261
N190 G2 X2.1089 I-.7086 J.3925
N200 G1 X.21
N210 G40 X-.1025
N220 G0 Z.5
N230 Y-.655
N240 Z.1
N250 G1 Z-.015 F100.
N260 G41 D59 X.21 F32.
N270 X2.1089
N280 G2 X3.5261 I.7086 J-.3925
N290 G1 X4.4289
N300 G2 X5.8461 I.7086 J-.3925
N310 G1 X6.8389
N320 G2 X8.2561 I.7086 J-.3925
N330 G1 X8.885
N340 G2 X9.01 Y-.78 I0. J-.125

N350 G1 Y-1.3989
N360 G2 Y-2.8161 I-.3925 J-.7086
N370 G1 Y-3.435
N380 G2 X8.885 Y-3.56 I-.125 J0.
N390 G1 X8.2615
N400 G2 X6.8389 Y-3.57 I-.714 J.3825
N410 G1 X6.2461
N420 G2 X4.8289 I-.7086 J.3925
N430 G1 X4.4161
N440 G2 X2.9989 I-.7086 J.3925
N450 G1 X2.6461
N460 G2 X1.2289 I-.7086 J.3925
N470 G1 X.21
N480 G40 X-.1025
N490 G0 Z.5
N500 G0 Z8. M11
N510 M99

O0118
(1/4 DIA 82 DEG SPOT DRILL TOOL 32 - DRILL/CBORE)
N10 G0 G90 B0 X9.485 Y-2.1075
N20 Z.5 M10
N30 G98 G82 Z-.098 R.1 P150 F20.
N40 X9.08
N50 X9.0685 Y-.5965
N60 Y-1.3396
N70 Y-2.8854
N80 Y-3.6285
N90 X8.6175 Y-2.1075
N100 X8.3254 Y-.5965
N110 Y-3.6285
N120 X8.01 Y-3.1775
N130 Y-1.0475
N140 X7.5475 Y-.18
N150 Y-1.0475
N160 Y-1.915
N170 Y-2.31
N180 Y-3.1775
N190 Y-4.045
N200 X6.7696 Y-3.6285
N210 Y-2.7265
N220 Y-1.4985
N230 Y-.5965
N240 X6.3154 Y-2.7265
N250 Y-3.6285
N260 X6. Y-3.1775
N270 X5.9154 Y-1.4985
N280 Y-.5965
N290 X5.6 Y-1.0475
N300 X5.5375 Y-2.31
N310 Y-3.1775
N320 Y-4.045
N330 X5.1375 Y-1.915
N340 Y-1.0475

N350 Y-.18
N360 X4.6225 Y-2.7265
N370 Y-3.6285
N380 X4.3596 Y-1.4985
N390 Y-.5965
N400 X4.17 Y-3.1775
N410 X3.7075 Y-2.31
N420 Y-3.1775
N430 Y-4.045
N440 X3.5954 Y-1.4985
N450 Y-.5965
N460 X3.28 Y-1.0475
N470 X2.8225 Y-2.7265
N480 Y-3.6285
N490 X2.8175 Y-1.915
N500 Y-1.0475
N510 Y-.18
N520 X2.4 Y-3.1775
N530 X2.0396 Y-1.4985
N540 Y-.5965
N550 X1.9375 Y-2.31
N560 Y-3.1775
N570 Y-4.045
N580 X1.2948 Y-1.4985
N590 Y-.5965
N600 X1.1596 Y-2.7265
N610 Y-3.6285
N620 X.55 Y-4.045
N630 Y-3.6285
N640 Y-2.7265
N650 Y-1.4985
N660 Y-.5965
N670 Y-.18
N680 G80
N690 G0 Z8. M11
N700 M99

O0119
(DRILL FOR 164-32 TAP TOOL 34 - CHIP BREAK)
N10 G0 G90 B0 X.55 Y-4.045
N20 Z.5 M10
N30 G98 G73 Z-.4493 R.1 Q.05 F20.
N40 Y-3.6285
N50 Y-2.7265
N60 Y-1.4985
N70 Y-.5965
N80 Y-.18
N90 X1.1596 Y-3.6285
N100 Y-2.7265
N110 X1.2948 Y-1.4985
N120 Y-.5965
N130 X1.9375 Y-4.045
N140 Y-2.31
N150 X2.0396 Y-1.4985

N160 Y-.5965
N170 X2.8175 Y-1.915
N180 Y-.18
N190 X2.8225 Y-3.6285
N200 Y-2.7265
N210 X3.5954 Y-1.4985
N220 Y-.5965
N230 X3.7075 Y-4.045
N240 Y-2.31
N250 X4.3596 Y-1.4985
N260 Y-.5965
N270 X4.6225 Y-3.6285
N280 Y-2.7265
N290 X5.1375 Y-1.915
N300 Y-.18
N310 X5.5375 Y-4.045
N320 Y-2.31
N330 X5.9154 Y-1.4985
N340 Y-.5965
N350 X6.3154 Y-3.6285
N360 Y-2.7265
N370 X6.7696 Y-3.6285
N380 Y-2.7265
N390 Y-1.4985
N400 Y-.5965
N410 X7.5475 Y-4.045
N420 Y-2.31
N430 Y-1.915
N440 Y-.18
N450 X8.3254 Y-3.6285
N460 Y-.5965
N470 X9.0685 Y-3.6285
N480 Y-2.8854
N490 Y-1.3396
N500 Y-.5965
N510 X9.485 Y-2.1075
N520 G80
N530 G0 Z8. M11
N540 M99

O0120
(164 -32 TAP TOOL 15 - TAP)
N10 G0 G90 B0 X9.485 Y-2.1075
N20 Z.5 M10
N30 G98 G84.2 Z-.35 R.1 F15.63 S500
N40 X9.0685 Y-.5965
N50 Y-1.3396
N60 Y-2.8854
N70 Y-3.6285
N80 X8.3254 Y-.5965
N90 Y-3.6285
N100 X7.5475 Y-.18
N110 Y-1.915
N120 Y-2.31

N130 Y-4.045
N140 X6.7696 Y-.5965
N150 Y-1.4985
N160 Y-2.7265
N170 Y-3.6285
N180 X6.3154 Y-2.7265
N190 Y-3.6285
N200 X5.9154 Y-.5965
N210 Y-1.4985
N220 X5.5375 Y-2.31
N230 Y-4.045
N240 X5.1375 Y-.18
N250 Y-1.915
N260 X4.6225 Y-2.7265
N270 Y-3.6285
N280 X4.3596 Y-.5965
N290 Y-1.4985
N300 X3.7075 Y-2.31
N310 Y-4.045
N320 X3.5954 Y-.5965
N330 Y-1.4985
N340 X2.8225 Y-2.7265
N350 Y-3.6285
N360 X2.8175 Y-.18
N370 Y-1.915
N380 X2.0396 Y-.5965
N390 Y-1.4985
N400 X1.9375 Y-2.31
N410 Y-4.045
N420 X1.2948 Y-.5965
N430 Y-1.4985
N440 X1.1596 Y-2.7265
N450 Y-3.6285
N460 X.55 Y-.18
N470 Y-.5965
N480 Y-1.4985
N490 Y-2.7265
N500 Y-3.6285
N510 Y-4.045
N520 G80
N530 G0 Z8. M11
N540 M99

O0121
(DRILL FOR 138-32 TAP TOOL 36 - CHIP BREAK)
N10 G0 G90 B0 X1.9375 Y-3.1775
N20 Z.5 M10
N30 G98 G73 Z-.8115 R.1 Q.05 F20.
N40 X2.8175 Y-1.0475
N50 X3.7075 Y-3.1775
N60 X5.1375 Y-1.0475
N70 X5.5375 Y-3.1775
N80 X7.5475
N90 Y-1.0475

N100 X8.6175 Y-2.1075
N110 G80
N120 G0 Z8. M11
N130 M99

O0122
(138-32 TAP TOOL 13 - TAP)
N10 G0 G90 B0 X8.6175 Y-2.1075
N20 Z.5 M10
N30 G98 G84.2 Z-.32 R.1 F15.63 S500
N40 X7.5475 Y-1.0475
N50 Y-3.1775
N60 X5.5375
N70 X5.1375 Y-1.0475
N80 X3.7075 Y-3.1775
N90 X2.8175 Y-1.0475
N100 X1.9375 Y-3.1775
N110 G80
N120 G0 Z8. M11
N130 M99

O0123
(27/64 TWIST DRILL TOOL 38 - CHIP BREAK)
N10 G0 G90 B0 X9.08 Y-2.1075
N20 Z.5 M10
N30 G98 G73 Z-1.27 R.1 Q.1 F20.
N40 X8.01 Y-1.0475
N50 Y-3.1775
N60 X6.
N70 X5.6 Y-1.0475
N80 X4.17 Y-3.1775
N90 X3.28 Y-1.0475
N100 X2.4 Y-3.1775
N110 G80
N120 G0 Z8. M11
N130 M99

O0124
(3/8 END MILL 1/32 RAD TOOL 25 - CONTOUR)
N10 G0 G90 B0 X3.28 Y-1.0475
N20 Z.5 M10
N30 Z.1
N40 G1 Z-.1814 F100.
N50 G3 X2.355 I-.4625 J0. F45.
N60 X3.28 I.4625 J0.
N70 G1 Z-.3629 F100.
N80 G3 X2.355 I-.4625 J0. F45.
N90 X3.28 I.4625 J0.
N100 G1 Z-.5443 F100.
N110 G3 X2.355 I-.4625 J0. F45.
N120 X3.28 I.4625 J0.
N130 G1 Z-.7257 F100.
N140 G3 X2.355 I-.4625 J0. F45.
N150 X3.28 I.4625 J0.

N160 G1 Z-.9071 F100.
N170 G3 X2.355 I-.4625 J0. F45.
N180 X3.28 I.4625 J0.
N190 G1 Z-1.0886 F100.
N200 G3 X2.355 I-.4625 J0. F45.
N210 X3.28 I.4625 J0.
N220 G1 Z-1.27 F100.
N230 G3 X2.355 I-.4625 J0. F45.
N240 X3.28 I.4625 J0.
N250 G1 Z-1.275 F20.
N260 G3 X2.355 I-.4625 J0. F45.
N270 X3.28 I.4625 J0.
N280 G0 Z.5
N290 X3.2618 Y-.8417
N300 Z.1
N310 G1 Z-.4233 F100.
N320 G41 D65 X3.2572 Y-.8159 F45.
N330 G3 X3.2505 Y-.7975 I-.0554 J-.0097
N340 X2.3845 Y-1.2975 I-.433 J-.25
N350 X3.2505 Y-.7975 I.433 J.25
N360 X3.2375 Y-.7762 I-.433 J-.25
N370 X3.2242 Y-.7619 I-.0473 J-.0305
N380 G40 G1 X3.2033 Y-.746
N390 G0 Z.5
N400 X3.2618 Y-.8417
N410 Z.1
N420 G1 Z-.8467 F100.
N430 G41 D65 X3.2572 Y-.8159 F45.
N440 G3 X3.2505 Y-.7975 I-.0554 J-.0097
N450 X2.3845 Y-1.2975 I-.433 J-.25
N460 X3.2505 Y-.7975 I.433 J.25
N470 X3.2375 Y-.7762 I-.433 J-.25
N480 X3.2242 Y-.7619 I-.0473 J-.0305
N490 G40 G1 X3.2033 Y-.746
N500 G0 Z.5
N510 X3.2618 Y-.8417
N520 Z.1
N530 G1 Z-1.27 F100.
N540 G41 D65 X3.2572 Y-.8159 F45.
N550 G3 X3.2505 Y-.7975 I-.0554 J-.0097
N560 X2.3845 Y-1.2975 I-.433 J-.25
N570 X3.2505 Y-.7975 I.433 J.25
N580 X3.2375 Y-.7762 I-.433 J-.25
N590 X3.2242 Y-.7619 I-.0473 J-.0305
N600 G40 G1 X3.2033 Y-.746
N610 G0 Z.5
N620 X3.2618 Y-.8417
N630 Z.1
N640 G1 Z-1.275 F20.
N650 G41 D65 X3.2572 Y-.8159 F45.
N660 G3 X3.2505 Y-.7975 I-.0554 J-.0097
N670 X2.3845 Y-1.2975 I-.433 J-.25
N680 X3.2505 Y-.7975 I.433 J.25
N690 X3.2375 Y-.7762 I-.433 J-.25

N700 X3.2242 Y-.7619 I-.0473 J-.0305
N710 G40 G1 X3.2033 Y-.746
N720 G0 Z.5
N730 X3.2742 Y-.9845
N740 Z.1
N750 G1 Z-.4233 F100.
N760 G41 D65 X3.2527 Y-1.0152 F45.
N770 G3 X3.2425 Y-1.0475 I.0461 J-.0323
N780 G2 X2.3925 I-.425 J0.
N790 X3.2425 I.425 J0.
N800 X3.2418 Y-1.0725 I-.425 J0.
N810 G3 X3.25 Y-1.1053 I.0561 J-.0033
N820 G40 G1 X3.2697 Y-1.1372
N830 G0 Z.5
N840 X3.2742 Y-.9845
N850 Z.1
N860 G1 Z-.8467 F100.
N870 G41 D65 X3.2527 Y-1.0152 F45.
N880 G3 X3.2425 Y-1.0475 I.0461 J-.0323
N890 G2 X2.3925 I-.425 J0.
N900 X3.2425 I.425 J0.
N910 X3.2418 Y-1.0725 I-.425 J0.
N920 G3 X3.25 Y-1.1053 I.0561 J-.0033
N930 G40 G1 X3.2697 Y-1.1372
N940 G0 Z.5
N950 X3.2742 Y-.9845
N960 Z.1
N970 G1 Z-1.27 F100.
N980 G41 D65 X3.2527 Y-1.0152 F45.
N990 G3 X3.2425 Y-1.0475 I.0461 J-.0323
N1000 G2 X2.3925 I-.425 J0.
N1010 X3.2425 I.425 J0.
N1020 X3.2418 Y-1.0725 I-.425 J0.
N1030 G3 X3.25 Y-1.1053 I.0561 J-.0033
N1040 G40 G1 X3.2697 Y-1.1372
N1050 G0 Z.5
N1060 X3.2742 Y-.9845
N1070 Z.1
N1080 G1 Z-1.275 F20.
N1090 G41 D65 X3.2527 Y-1.0152 F45.
N1100 G3 X3.2425 Y-1.0475 I.0461 J-.0323
N1110 G2 X2.3925 I-.425 J0.
N1120 X3.2425 I.425 J0.
N1130 X3.2418 Y-1.0725 I-.425 J0.
N1140 G3 X3.25 Y-1.1053 I.0561 J-.0033
N1150 G40 G1 X3.2697 Y-1.1372
N1160 G0 Z.5
N1170 X2.4 Y-3.1775
N1180 Z.1
N1190 G1 Z-.1814 F100.
N1200 G3 X1.475 I-.4625 J0. F45.
N1210 X2.4 I.4625 J0.
N1220 G1 Z-.3629 F100.
N1230 G3 X1.475 I-.4625 J0. F45.

N1240 X2.4 I.4625 J0.
N1250 G1 Z-.5443 F100.
N1260 G3 X1.475 I-.4625 J0. F45.
N1270 X2.4 I.4625 J0.
N1280 G1 Z-.7257 F100.
N1290 G3 X1.475 I-.4625 J0. F45.
N1300 X2.4 I.4625 J0.
N1310 G1 Z-.9071 F100.
N1320 G3 X1.475 I-.4625 J0. F45.
N1330 X2.4 I.4625 J0.
N1340 G1 Z-1.0886 F100.
N1350 G3 X1.475 I-.4625 J0. F45.
N1360 X2.4 I.4625 J0.
N1370 G1 Z-1.27 F100.
N1380 G3 X1.475 I-.4625 J0. F45.
N1390 X2.4 I.4625 J0.
N1400 G1 Z-1.275 F20.
N1410 G3 X1.475 I-.4625 J0. F45.
N1420 X2.4 I.4625 J0.
N1430 G0 Z.5
N1440 X2.3818 Y-2.9717
N1450 Z.1
N1460 G1 Z-.4233 F100.
N1470 G41 D65 X2.3772 Y-2.9459 F45.
N1480 G3 X2.3705 Y-2.9275 I-.0554 J-.0097
N1490 X1.5045 Y-3.4275 I-.433 J-.25
N1500 X2.3705 Y-2.9275 I.433 J.25
N1510 X2.3575 Y-2.9062 I-.433 J-.25
N1520 X2.3442 Y-2.8919 I-.0473 J-.0305
N1530 G40 G1 X2.3233 Y-2.876
N1540 G0 Z.5
N1550 X2.3818 Y-2.9717
N1560 Z.1
N1570 G1 Z-.8467 F100.
N1580 G41 D65 X2.3772 Y-2.9459 F45.
N1590 G3 X2.3705 Y-2.9275 I-.0554 J-.0097
N1600 X1.5045 Y-3.4275 I-.433 J-.25
N1610 X2.3705 Y-2.9275 I.433 J.25
N1620 X2.3575 Y-2.9062 I-.433 J-.25
N1630 X2.3442 Y-2.8919 I-.0473 J-.0305
N1640 G40 G1 X2.3233 Y-2.876
N1650 G0 Z.5
N1660 X2.3818 Y-2.9717
N1670 Z.1
N1680 G1 Z-1.27 F100.
N1690 G41 D65 X2.3772 Y-2.9459 F45.
N1700 G3 X2.3705 Y-2.9275 I-.0554 J-.0097
N1710 X1.5045 Y-3.4275 I-.433 J-.25
N1720 X2.3705 Y-2.9275 I.433 J.25
N1730 X2.3575 Y-2.9062 I-.433 J-.25
N1740 X2.3442 Y-2.8919 I-.0473 J-.0305
N1750 G40 G1 X2.3233 Y-2.876
N1760 G0 Z.5
N1770 X2.3818 Y-2.9717

N1780 Z.1
N1790 G1 Z-1.275 F20.
N1800 G41 D65 X2.3772 Y-2.9459 F45.
N1810 G3 X2.3705 Y-2.9275 I-.0554 J-.0097
N1820 X1.5045 Y-3.4275 I-.433 J-.25
N1830 X2.3705 Y-2.9275 I.433 J.25
N1840 X2.3575 Y-2.9062 I-.433 J-.25
N1850 X2.3442 Y-2.8919 I-.0473 J-.0305
N1860 G40 G1 X2.3233 Y-2.876
N1870 G0 Z.5
N1880 X2.3942 Y-3.1145
N1890 Z.1
N1900 G1 Z-.4233 F100.
N1910 G41 D65 X2.3727 Y-3.1452 F45.
N1920 G3 X2.3625 Y-3.1775 I.0461 J-.0323
N1930 G2 X1.5125 I-.425 J0.
N1940 X2.3625 I.425 J0.
N1950 X2.3618 Y-3.2025 I-.425 J0.
N1960 G3 X2.37 Y-3.2353 I.0561 J-.0033
N1970 G40 G1 X2.3897 Y-3.2672
N1980 G0 Z.5
N1990 X2.3942 Y-3.1145
N2000 Z.1
N2010 G1 Z-.8467 F100.
N2020 G41 D65 X2.3727 Y-3.1452 F45.
N2030 G3 X2.3625 Y-3.1775 I.0461 J-.0323
N2040 G2 X1.5125 I-.425 J0.
N2050 X2.3625 I.425 J0.
N2060 X2.3618 Y-3.2025 I-.425 J0.
N2070 G3 X2.37 Y-3.2353 I.0561 J-.0033
N2080 G40 G1 X2.3897 Y-3.2672
N2090 G0 Z.5
N2100 X2.3942 Y-3.1145
N2110 Z.1
N2120 G1 Z-1.27 F100.
N2130 G41 D65 X2.3727 Y-3.1452 F45.
N2140 G3 X2.3625 Y-3.1775 I.0461 J-.0323
N2150 G2 X1.5125 I-.425 J0.
N2160 X2.3625 I.425 J0.
N2170 X2.3618 Y-3.2025 I-.425 J0.
N2180 G3 X2.37 Y-3.2353 I.0561 J-.0033
N2190 G40 G1 X2.3897 Y-3.2672
N2200 G0 Z.5
N2210 X2.3942 Y-3.1145
N2220 Z.1
N2230 G1 Z-1.275 F20.
N2240 G41 D65 X2.3727 Y-3.1452 F45.
N2250 G3 X2.3625 Y-3.1775 I.0461 J-.0323
N2260 G2 X1.5125 I-.425 J0.
N2270 X2.3625 I.425 J0.
N2280 X2.3618 Y-3.2025 I-.425 J0.
N2290 G3 X2.37 Y-3.2353 I.0561 J-.0033
N2300 G40 G1 X2.3897 Y-3.2672
N2310 G0 Z.5

N2320 X4.17 Y-3.1775
N2330 Z.1
N2340 G1 Z-.1814 F100.
N2350 G3 X3.245 I-.4625 J0. F45.
N2360 X4.17 I.4625 J0.
N2370 G1 Z-.3629 F100.
N2380 G3 X3.245 I-.4625 J0. F45.
N2390 X4.17 I.4625 J0.
N2400 G1 Z-.5443 F100.
N2410 G3 X3.245 I-.4625 J0. F45.
N2420 X4.17 I.4625 J0.
N2430 G1 Z-.7257 F100.
N2440 G3 X3.245 I-.4625 J0. F45.
N2450 X4.17 I.4625 J0.
N2460 G1 Z-.9071 F100.
N2470 G3 X3.245 I-.4625 J0. F45.
N2480 X4.17 I.4625 J0.
N2490 G1 Z-1.0886 F100.
N2500 G3 X3.245 I-.4625 J0. F45.
N2510 X4.17 I.4625 J0.
N2520 G1 Z-1.27 F100.
N2530 G3 X3.245 I-.4625 J0. F45.
N2540 X4.17 I.4625 J0.
N2550 G1 Z-1.275 F20.
N2560 G3 X3.245 I-.4625 J0. F45.
N2570 X4.17 I.4625 J0.
N2580 G0 Z.5
N2590 X4.1518 Y-2.9717
N2600 Z.1
N2610 G1 Z-.4233 F100.
N2620 G41 D65 X4.1472 Y-2.9459 F45.
N2630 G3 X4.1405 Y-2.9275 I-.0554 J-.0097
N2640 X3.2745 Y-3.4275 I-.433 J-.25
N2650 X4.1405 Y-2.9275 I.433 J.25
N2660 X4.1275 Y-2.9062 I-.433 J-.25
N2670 X4.1142 Y-2.8919 I-.0473 J-.0305
N2680 G40 G1 X4.0933 Y-2.876
N2690 G0 Z.5
N2700 X4.1518 Y-2.9717
N2710 Z.1
N2720 G1 Z-.8467 F100.
N2730 G41 D65 X4.1472 Y-2.9459 F45.
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N2760 X4.1405 Y-2.9275 I.433 J.25
N2770 X4.1275 Y-2.9062 I-.433 J-.25
N2780 X4.1142 Y-2.8919 I-.0473 J-.0305
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N2830 G1 Z-1.27 F100.
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N2890 X4.1142 Y-2.8919 I-.0473 J-.0305
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N2910 G0 Z.5
N2920 X4.1518 Y-2.9717
N2930 Z.1
N2940 G1 Z-1.275 F20.
N2950 G41 D65 X4.1472 Y-2.9459 F45.
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N2970 X3.2745 Y-3.4275 I-.433 J-.25
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N3010 G40 G1 X4.0933 Y-2.876
N3020 G0 Z.5
N3030 X4.1642 Y-3.1145
N3040 Z.1
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N3060 G41 D65 X4.1427 Y-3.1452 F45.
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N3090 X4.1325 I.425 J0.
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N3130 G0 Z.5
N3140 X4.1642 Y-3.1145
N3150 Z.1
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N3210 X4.1318 Y-3.2025 I-.425 J0.
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N3240 G0 Z.5
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N3260 Z.1
N3270 G1 Z-1.27 F100.
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N3470 X6. Y-3.1775
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N3520 G1 Z-.3629 F100.
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N3820 X5.9442 Y-2.8919 I-.0473 J-.0305
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N3840 G0 Z.5
N3850 X5.9818 Y-2.9717
N3860 Z.1
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N3910 X5.9705 Y-2.9275 I.433 J.25
N3920 X5.9575 Y-2.9062 I-.433 J-.25
N3930 X5.9442 Y-2.8919 I-.0473 J-.0305

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N4030 X5.9575 Y-2.9062 I-.433 J-.25
N4040 X5.9442 Y-2.8919 I-.0473 J-.0305
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N4070 X5.9818 Y-2.9717
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N4090 G1 Z-1.275 F20.
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N4130 X5.9705 Y-2.9275 I.433 J.25
N4140 X5.9575 Y-2.9062 I-.433 J-.25
N4150 X5.9442 Y-2.8919 I-.0473 J-.0305
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N4240 X5.9625 I.425 J0.
N4250 X5.9618 Y-3.2025 I-.425 J0.
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N4270 G40 G1 X5.9897 Y-3.2672
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N4330 G3 X5.9625 Y-3.1775 I.046 J-.0323
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N4350 X5.9625 I.425 J0.
N4360 X5.9618 Y-3.2025 I-.425 J0.
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N4380 G40 G1 X5.9897 Y-3.2672
N4390 G0 Z.5
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N4410 Z.1
N4420 G1 Z-1.27 F100.
N4430 G41 D65 X5.9727 Y-3.1452 F45.
N4440 G3 X5.9625 Y-3.1775 I.046 J-.0323
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N4460 X5.9625 I.425 J0.
N4470 X5.9618 Y-3.2025 I-.425 J0.

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N4510 X5.9942 Y-3.1145
N4520 Z.1
N4530 G1 Z-1.275 F20.
N4540 G41 D65 X5.9727 Y-3.1452 F45.
N4550 G3 X5.9625 Y-3.1775 I.046 J-.0323
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N4570 X5.9625 I.425 J0.
N4580 X5.9618 Y-3.2025 I-.425 J0.
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N4620 X5.6 Y-1.0475
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N4670 G1 Z-.3629 F100.
N4680 G3 X4.675 I-.4625 J0. F45.
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N4720 X5.6 I.4625 J0.
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N4850 G1 Z-1.275 F20.
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N4990 G0 Z.5
N5000 X5.5818 Y-.8417
N5010 Z.1

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N5080 X5.5442 Y-.7619 I-.0473 J-.0305
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N5450 Z.1
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N5510 X5.5618 Y-1.0725 I-.425 J0.
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N5540 G0 Z.5
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N5620 X5.5618 Y-1.0725 I-.425 J0.
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N6380 Z.1
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N6420 X7.1145 Y-3.4275 I-.433 J-.25
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N6600 Z.1
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N6690 G0 Z.5
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N6710 Z.1
N6720 G1 Z-1.27 F100.
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N6770 X7.9718 Y-3.2025 I-.425 J0.
N6780 G3 X7.98 Y-3.2353 I.0561 J-.0033
N6790 G40 G1 X7.9997 Y-3.2672
N6800 G0 Z.5
N6810 X8.0042 Y-3.1145
N6820 Z.1
N6830 G1 Z-1.275 F20.
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N6870 X7.9725 I.425 J0.
N6880 X7.9718 Y-3.2025 I-.425 J0.
N6890 G3 X7.98 Y-3.2353 I.0561 J-.0033
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N6920 X9.08 Y-2.1075
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N6960 X9.08 I.4625 J0.
N6970 G1 Z-.3629 F100.
N6980 G3 X8.155 I-.4625 J0. F45.
N6990 X9.08 I.4625 J0.
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N7010 G3 X8.155 I-.4625 J0. F45.
N7020 X9.08 I.4625 J0.
N7030 G1 Z-.7257 F100.
N7040 G3 X8.155 I-.4625 J0. F45.
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N7060 G1 Z-.9071 F100.
N7070 G3 X8.155 I-.4625 J0. F45.
N7080 X9.08 I.4625 J0.
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N7110 X9.08 I.4625 J0.
N7120 G1 Z-1.27 F100.
N7130 G3 X8.155 I-.4625 J0. F45.
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N7160 G3 X8.155 I-.4625 J0. F45.
N7170 X9.08 I.4625 J0.

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N7200 Z.1
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N7230 G3 X9.0505 Y-1.8575 I-.0554 J-.0097
N7240 X8.1845 Y-2.3575 I-.433 J-.25
N7250 X9.0505 Y-1.8575 I.433 J.25
N7260 X9.0375 Y-1.8362 I-.433 J-.25
N7270 X9.0242 Y-1.8219 I-.0473 J-.0305
N7280 G40 G1 X9.0033 Y-1.806
N7290 G0 Z.5
N7300 X9.0618 Y-1.9017
N7310 Z.1
N7320 G1 Z-.8467 F100.
N7330 G41 D65 X9.0572 Y-1.8759 F45.
N7340 G3 X9.0505 Y-1.8575 I-.0554 J-.0097
N7350 X8.1845 Y-2.3575 I-.433 J-.25
N7360 X9.0505 Y-1.8575 I.433 J.25
N7370 X9.0375 Y-1.8362 I-.433 J-.25
N7380 X9.0242 Y-1.8219 I-.0473 J-.0305
N7390 G40 G1 X9.0033 Y-1.806
N7400 G0 Z.5
N7410 X9.0618 Y-1.9017
N7420 Z.1
N7430 G1 Z-1.27 F100.
N7440 G41 D65 X9.0572 Y-1.8759 F45.
N7450 G3 X9.0505 Y-1.8575 I-.0554 J-.0097
N7460 X8.1845 Y-2.3575 I-.433 J-.25
N7470 X9.0505 Y-1.8575 I.433 J.25
N7480 X9.0375 Y-1.8362 I-.433 J-.25
N7490 X9.0242 Y-1.8219 I-.0473 J-.0305
N7500 G40 G1 X9.0033 Y-1.806
N7510 G0 Z.5
N7520 X9.0618 Y-1.9017
N7530 Z.1
N7540 G1 Z-1.275 F20.
N7550 G41 D65 X9.0572 Y-1.8759 F45.
N7560 G3 X9.0505 Y-1.8575 I-.0554 J-.0097
N7570 X8.1845 Y-2.3575 I-.433 J-.25
N7580 X9.0505 Y-1.8575 I.433 J.25
N7590 X9.0375 Y-1.8362 I-.433 J-.25
N7600 X9.0242 Y-1.8219 I-.0473 J-.0305
N7610 G40 G1 X9.0033 Y-1.806
N7620 G0 Z.5
N7630 X9.0742 Y-2.0445
N7640 Z.1
N7650 G1 Z-.4233 F100.
N7660 G41 D65 X9.0527 Y-2.0752 F45.
N7670 G3 X9.0425 Y-2.1075 I.0461 J-.0323
N7680 G2 X8.1925 I-.425 J0.
N7690 X9.0425 I.425 J0.
N7700 X9.0418 Y-2.1325 I-.425 J0.
N7710 G3 X9.05 Y-2.1653 I.0561 J-.0033

N7720 G40 G1 X9.0697 Y-2.1972
N7730 G0 Z.5
N7740 X9.0742 Y-2.0445
N7750 Z.1
N7760 G1 Z-.8467 F100.
N7770 G41 D65 X9.0527 Y-2.0752 F45.
N7780 G3 X9.0425 Y-2.1075 I.0461 J-.0323
N7790 G2 X8.1925 I-.425 J0.
N7800 X9.0425 I.425 J0.
N7810 X9.0418 Y-2.1325 I-.425 J0.
N7820 G3 X9.05 Y-2.1653 I.0561 J-.0033
N7830 G40 G1 X9.0697 Y-2.1972
N7840 G0 Z.5
N7850 X9.0742 Y-2.0445
N7860 Z.1
N7870 G1 Z-1.27 F100.
N7880 G41 D65 X9.0527 Y-2.0752 F45.
N7890 G3 X9.0425 Y-2.1075 I.0461 J-.0323
N7900 G2 X8.1925 I-.425 J0.
N7910 X9.0425 I.425 J0.
N7920 X9.0418 Y-2.1325 I-.425 J0.
N7930 G3 X9.05 Y-2.1653 I.0561 J-.0033
N7940 G40 G1 X9.0697 Y-2.1972
N7950 G0 Z.5
N7960 X9.0742 Y-2.0445
N7970 Z.1
N7980 G1 Z-1.275 F20.
N7990 G41 D65 X9.0527 Y-2.0752 F45.
N8000 G3 X9.0425 Y-2.1075 I.0461 J-.0323
N8010 G2 X8.1925 I-.425 J0.
N8020 X9.0425 I.425 J0.
N8030 X9.0418 Y-2.1325 I-.425 J0.
N8040 G3 X9.05 Y-2.1653 I.0561 J-.0033
N8050 G40 G1 X9.0697 Y-2.1972
N8060 G0 Z.5
N8070 X8.01 Y-1.0475
N8080 Z.1
N8090 G1 Z-.1814 F100.
N8100 G3 X7.085 I-.4625 J0. F45.
N8110 X8.01 I.4625 J0.
N8120 G1 Z-.3629 F100.
N8130 G3 X7.085 I-.4625 J0. F45.
N8140 X8.01 I.4625 J0.
N8150 G1 Z-.5443 F100.
N8160 G3 X7.085 I-.4625 J0. F45.
N8170 X8.01 I.4625 J0.
N8180 G1 Z-.7257 F100.
N8190 G3 X7.085 I-.4625 J0. F45.
N8200 X8.01 I.4625 J0.
N8210 G1 Z-.9071 F100.
N8220 G3 X7.085 I-.4625 J0. F45.
N8230 X8.01 I.4625 J0.
N8240 G1 Z-1.0886 F100.
N8250 G3 X7.085 I-.4625 J0. F45.

N8260 X8.01 I.4625 J0.
N8270 G1 Z-1.27 F100.
N8280 G3 X7.085 I-.4625 J0. F45.
N8290 X8.01 I.4625 J0.
N8300 G1 Z-1.275 F20.
N8310 G3 X7.085 I-.4625 J0. F45.
N8320 X8.01 I.4625 J0.
N8330 G0 Z.5
N8340 X7.9918 Y-.8417
N8350 Z.1
N8360 G1 Z-.4233 F100.
N8370 G41 D65 X7.9872 Y-.8159 F45.
N8380 G3 X7.9805 Y-.7975 I-.0554 J-.0097
N8390 X7.1145 Y-1.2975 I-.433 J-.25
N8400 X7.9805 Y-.7975 I.433 J.25
N8410 X7.9675 Y-.7762 I-.433 J-.25
N8420 X7.9542 Y-.7619 I-.0473 J-.0305
N8430 G40 G1 X7.9333 Y-.746
N8440 G0 Z.5
N8450 X7.9918 Y-.8417
N8460 Z.1
N8470 G1 Z-.8467 F100.
N8480 G41 D65 X7.9872 Y-.8159 F45.
N8490 G3 X7.9805 Y-.7975 I-.0554 J-.0097
N8500 X7.1145 Y-1.2975 I-.433 J-.25
N8510 X7.9805 Y-.7975 I.433 J.25
N8520 X7.9675 Y-.7762 I-.433 J-.25
N8530 X7.9542 Y-.7619 I-.0473 J-.0305
N8540 G40 G1 X7.9333 Y-.746
N8550 G0 Z.5
N8560 X7.9918 Y-.8417
N8570 Z.1
N8580 G1 Z-1.27 F100.
N8590 G41 D65 X7.9872 Y-.8159 F45.
N8600 G3 X7.9805 Y-.7975 I-.0554 J-.0097
N8610 X7.1145 Y-1.2975 I-.433 J-.25
N8620 X7.9805 Y-.7975 I.433 J.25
N8630 X7.9675 Y-.7762 I-.433 J-.25
N8640 X7.9542 Y-.7619 I-.0473 J-.0305
N8650 G40 G1 X7.9333 Y-.746
N8660 G0 Z.5
N8670 X7.9918 Y-.8417
N8680 Z.1
N8690 G1 Z-1.275 F20.
N8700 G41 D65 X7.9872 Y-.8159 F45.
N8710 G3 X7.9805 Y-.7975 I-.0554 J-.0097
N8720 X7.1145 Y-1.2975 I-.433 J-.25
N8730 X7.9805 Y-.7975 I.433 J.25
N8740 X7.9675 Y-.7762 I-.433 J-.25
N8750 X7.9542 Y-.7619 I-.0473 J-.0305
N8760 G40 G1 X7.9333 Y-.746
N8770 G0 Z.5
N8780 X8.0042 Y-.9845
N8790 Z.1

N8800 G1 Z-.4233 F100.
N8810 G41 D65 X7.9827 Y-1.0152 F45.
N8820 G3 X7.9725 Y-1.0475 I.0461 J-.0323
N8830 G2 X7.1225 I-.425 J0.
N8840 X7.9725 I.425 J0.
N8850 X7.9718 Y-1.0725 I-.425 J0.
N8860 G3 X7.98 Y-1.1053 I.0561 J-.0033
N8870 G40 G1 X7.9997 Y-1.1372
N8880 G0 Z.5
N8890 X8.0042 Y-.9845
N8900 Z.1
N8910 G1 Z-.8467 F100.
N8920 G41 D65 X7.9827 Y-1.0152 F45.
N8930 G3 X7.9725 Y-1.0475 I.0461 J-.0323
N8940 G2 X7.1225 I-.425 J0.
N8950 X7.9725 I.425 J0.
N8960 X7.9718 Y-1.0725 I-.425 J0.
N8970 G3 X7.98 Y-1.1053 I.0561 J-.0033
N8980 G40 G1 X7.9997 Y-1.1372
N8990 G0 Z.5
N9000 X8.0042 Y-.9845
N9010 Z.1
N9020 G1 Z-1.27 F100.
N9030 G41 D65 X7.9827 Y-1.0152 F45.
N9040 G3 X7.9725 Y-1.0475 I.0461 J-.0323
N9050 G2 X7.1225 I-.425 J0.
N9060 X7.9725 I.425 J0.
N9070 X7.9718 Y-1.0725 I-.425 J0.
N9080 G3 X7.98 Y-1.1053 I.0561 J-.0033
N9090 G40 G1 X7.9997 Y-1.1372
N9100 G0 Z.5
N9110 X8.0042 Y-.9845
N9120 Z.1
N9130 G1 Z-1.275 F20.
N9140 G41 D65 X7.9827 Y-1.0152 F45.
N9150 G3 X7.9725 Y-1.0475 I.0461 J-.0323
N9160 G2 X7.1225 I-.425 J0.
N9170 X7.9725 I.425 J0.
N9180 X7.9718 Y-1.0725 I-.425 J0.
N9190 G3 X7.98 Y-1.1053 I.0561 J-.0033
N9200 G40 G1 X7.9997 Y-1.1372
N9210 G0 Z.5
N9220 G0 Z8. M11
N9230 M99

O0125
(1/4 END MILL TOOL 22 - CONTOUR)
N10 G0 G90 B0 X-.008 Y-4.485
N20 Z.5 M10
N30 Z.1
N40 G1 Z-.105 F100.
N50 G41 D58 Y-4.235 F44.
N60 Y-2.6525
N70 X-.108

N80 G40 X-.358
N90 G0 Z.5
N100 X-.008 Y-4.485
N110 Z.1
N120 G1 Z-.21 F100.
N130 G41 D58 Y-4.235 F44.
N140 Y-2.6525
N150 X-.108
N160 G40 X-.358
N170 G0 Z.5
N180 X-.008 Y-4.485
N190 Z.1
N200 G1 Z-.315 F100.
N210 G41 D58 Y-4.235 F44.
N220 Y-2.6525
N230 X-.108
N240 G40 X-.358
N250 G0 Z.5
N260 X-.008 Y-4.485
N270 Z.1
N280 G1 Z-.42 F100.
N290 G41 D58 Y-4.235 F44.
N300 Y-2.6525
N310 X-.108
N320 G40 X-.358
N330 G0 Z.5
N340 Y-1.5725
N350 Z.1
N360 G1 Z-.105 F100.
N370 G41 D58 X-.108 F44.
N380 X-.008
N390 Y.01
N400 G40 Y.26
N410 G0 Z.5
N420 X-.358 Y-1.5725
N430 Z.1
N440 G1 Z-.21 F100.
N450 G41 D58 X-.108 F44.
N460 X-.008
N470 Y.01
N480 G40 Y.26
N490 G0 Z.5
N500 X-.358 Y-1.5725
N510 Z.1
N520 G1 Z-.315 F100.
N530 G41 D58 X-.108 F44.
N540 X-.008
N550 Y.01
N560 G40 Y.26
N570 G0 Z.5
N580 X-.358 Y-1.5725
N590 Z.1
N600 G1 Z-.42 F100.
N610 G41 D58 X-.108 F44.

N620 X-.008
N630 Y.01
N640 G40 Y.26
N650 G0 Z.5
N660 X.002 Y-4.475
N670 Z.1
N680 G1 Z-.42 F100.
N690 G41 D58 Y-4.225 F44.
N700 Y-2.6425
N710 X-.098
N720 G40 X-.348
N730 G0 Z.5
N740 Y-1.5825
N750 Z.1
N760 G1 Z-.42 F100.
N770 G41 D58 X-.098 F44.
N780 X.002
N790 Y0.
N800 G40 Y.25
N810 G0 Z.5
N820 X.075 Y-4.485
N830 Z.1
N840 G1 Z-.105 F100.
N850 G41 D58 Y-4.235 F44.
N860 Y-2.6525
N870 X-.01
N880 X-.072
N890 G40 X-.322
N900 G0 Z.5
N910 X.075 Y-4.485
N920 Z.1
N930 G1 Z-.21 F100.
N940 G41 D58 Y-4.235 F44.
N950 Y-2.6525
N960 X-.01
N970 X-.072
N980 G40 X-.322
N990 G0 Z.5
N1000 Y-1.5725
N1010 Z.1
N1020 G1 Z-.105 F100.
N1030 G41 D58 X-.072 F44.
N1040 X-.01
N1050 X.075
N1060 Y.01
N1070 G40 Y.26
N1080 G0 Z.5
N1090 X-.322 Y-1.5725
N1100 Z.1
N1110 G1 Z-.21 F100.
N1120 G41 D58 X-.072 F44.
N1130 X-.01
N1140 X.075
N1150 Y.01

N1160 G40 Y.26
N1170 G0 Z.5
N1180 X.085 Y-4.475
N1190 Z.1
N1200 G1 Z-.21 F100.
N1210 G41 D58 Y-4.225 F44.
N1220 Y-2.6425
N1230 X0.
N1240 X-.062
N1250 G40 X-.312
N1260 G0 Z.5
N1270 Y-1.5825
N1280 Z.1
N1290 G1 Z-.21 F100.
N1300 G41 D58 X-.062 F44.
N1310 X0.
N1320 X.085
N1330 Y0.
N1340 G40 Y.25
N1350 G0 Z.5
N1360 G0 Z8. M11
N1370 M99

O0126
(1/4 - 45 DEG CHF TOOL 40 - CONTOUR)
N10 G0 G90 B0 X-.29 Y-.7115
N20 Z.5 M10
N30 Z.1
N40 G1 Z-.01 F100.
N50 G41 D80 X.21 F120.
N60 X2.1089
N70 G3 X2.1584 Y-.6824 I0. J.0565
N80 G2 X3.4766 I.6591 J-.3651
N90 G3 X3.5261 Y-.7115 I.0495 J.0274
N100 G1 X4.4289
N110 G3 X4.4784 Y-.6824 I0. J.0565
N120 G2 X5.7966 I.6591 J-.3651
N130 G3 X5.8461 Y-.7115 I.0495 J.0274
N140 G1 X6.8389
N150 G3 X6.8884 Y-.6824 I0. J.0565
N160 G2 X8.2066 I.6591 J-.3651
N170 G3 X8.2561 Y-.7115 I.0495 J.0274
N180 G1 X8.885
N190 G2 X8.9535 Y-.78 I0. J-.0685
N200 G1 Y-1.3989
N210 G3 X8.9826 Y-1.4484 I.0565 J0.
N220 G2 Y-2.7666 I-.3651 J-.6591
N230 G3 X8.9535 Y-2.8161 I.0274 J-.0495
N240 G1 Y-3.435
N250 G2 X8.885 Y-3.5035 I-.0685 J0.
N260 G1 X8.2615
N270 G3 X8.2117 Y-3.5333 I0. J-.0565
N280 G2 X6.8884 Y-3.5426 I-.6642 J.3558
N290 G3 X6.8389 Y-3.5135 I-.0495 J-.0274

N300 G1 X6.2461
N310 G3 X6.1966 Y-3.5426 I0. J-.0565
N320 G2 X4.8784 I-.6591 J.3651
N330 G3 X4.8289 Y-3.5135 I-.0495 J-.0274
N340 G1 X4.4161
N350 G3 X4.3666 Y-3.5426 I0. J-.0565
N360 G2 X3.0484 I-.6591 J.3651
N370 G3 X2.9989 Y-3.5135 I-.0495 J-.0274
N380 G1 X2.6461
N390 G3 X2.5966 Y-3.5426 I0. J-.0565
N400 G2 X1.2784 I-.6591 J.3651
N410 G3 X1.2289 Y-3.5135 I-.0495 J-.0274
N420 G1 X.21
N430 G40 X-.29
N440 G0 Z.5
N450 Y-2.8415
N460 Z.1
N470 G1 Z-.01 F100.
N480 G41 D80 X.21 F120.
N490 X1.2289
N500 G3 X1.2784 Y-2.8124 I0. J.0565
N510 G2 X2.5966 I.6591 J-.3651
N520 G3 X2.6461 Y-2.8415 I.0495 J.0274
N530 G1 X2.9989
N540 G3 X3.0484 Y-2.8124 I0. J.0565
N550 G2 X4.3666 I.6591 J-.3651
N560 G3 X4.4161 Y-2.8415 I.0495 J.0274
N570 G1 X4.8289
N580 G3 X4.8784 Y-2.8124 I0. J.0565
N590 G2 X6.1966 I.6591 J-.3651
N600 G3 X6.2461 Y-2.8415 I.0495 J.0274
N610 G1 X6.8389
N620 G3 X6.8884 Y-2.8124 I0. J.0565
N630 G2 X7.8549 Y-2.4896 I.6591 J-.3651
N640 G3 X7.9296 Y-2.4149 I.0231 J.0516
N650 G2 X7.9245 Y-1.8116 I.6879 J.3074
N660 G3 X7.8499 Y-1.7377 I-.0519 J.0222
N670 G2 X6.8884 Y-1.4126 I-.3024 J.6902
N680 G3 X6.8389 Y-1.3835 I-.0495 J-.0274
N690 G1 X5.8461
N700 G3 X5.7966 Y-1.4126 I0. J-.0565
N710 G2 X4.4784 I-.6591 J.3651
N720 G3 X4.4289 Y-1.3835 I-.0495 J-.0274
N730 G1 X3.5261
N740 G3 X3.4766 Y-1.4126 I0. J-.0565
N750 G2 X2.1584 I-.6591 J.3651
N760 G3 X2.1089 Y-1.3835 I-.0495 J-.0274
N770 G1 X.21
N780 G40 X-.29
N790 G0 Z.5
N800 X3.4152 Y-.7362
N810 Z.1
N820 G1 Z-.01 F100.
N830 G41 D80 X3.4122 Y-.719 F120.

N840 G3 X3.4077 Y-.7067 I-.037 J-.0065
N850 X2.2273 Y-1.3883 I-.5902 J-.3408
N860 X3.4077 Y-.7067 I.5902 J.3408
N870 X3.3948 Y-.6853 I-.5902 J-.3408
N880 X3.3861 Y-.6757 I-.0318 J-.02
N890 G40 G1 X3.3723 Y-.6649
N900 G0 Z.5
N910 X3.0692 Y-1.0182
N920 Z.1
N930 G1 Z-.01 F100.
N940 G41 D80 X3.0633 Y-1.0347 F120.
N950 G3 X3.061 Y-1.0475 I.0352 J-.0128
N960 G2 X2.574 I-.2435 J0.
N970 X3.061 I.2435 J0.
N980 X3.0597 Y-1.0725 I-.2435 J0.
N990 G3 X3.0607 Y-1.0854 I.0373 J-.0038
N1000 G40 G1 X3.0649 Y-1.1024
N1010 G0 Z.5
N1020 X5.7352 Y-.7362
N1030 Z.1
N1040 G1 Z-.01 F100.
N1050 G41 D80 X5.7322 Y-.719 F120.
N1060 G3 X5.7277 Y-.7067 I-.037 J-.0065
N1070 X4.5473 Y-1.3883 I-.5902 J-.3408
N1080 X5.7277 Y-.7067 I.5902 J.3408
N1090 X5.7148 Y-.6853 I-.5902 J-.3408
N1100 X5.7061 Y-.6757 I-.0318 J-.02
N1110 G40 G1 X5.6923 Y-.6649
N1120 G0 Z.5
N1130 X5.3892 Y-1.0182
N1140 Z.1
N1150 G1 Z-.01 F100.
N1160 G41 D80 X5.3833 Y-1.0347 F120.
N1170 G3 X5.381 Y-1.0475 I.0352 J-.0128
N1180 G2 X4.894 I-.2435 J0.
N1190 X5.381 I.2435 J0.
N1200 X5.3797 Y-1.0725 I-.2435 J0.
N1210 G3 X5.3807 Y-1.0854 I.0373 J-.0038
N1220 G40 G1 X5.3849 Y-1.1024
N1230 G0 Z.5
N1240 X8.1452 Y-.7362
N1250 Z.1
N1260 G1 Z-.01 F100.
N1270 G41 D80 X8.1422 Y-.719 F120.
N1280 G3 X8.1377 Y-.7067 I-.037 J-.0065
N1290 X6.9573 Y-1.3883 I-.5902 J-.3408
N1300 X8.1377 Y-.7067 I.5902 J.3408
N1310 X8.1248 Y-.6853 I-.5902 J-.3408
N1320 X8.1161 Y-.6757 I-.0318 J-.02
N1330 G40 G1 X8.1023 Y-.6649
N1340 G0 Z.5
N1350 X7.7992 Y-1.0182
N1360 Z.1
N1370 G1 Z-.01 F100.

N1380 G41 D80 X7.7933 Y-1.0347 F120.
N1390 G3 X7.791 Y-1.0475 I.0352 J-.0128
N1400 G2 X7.304 I-.2435 J0.
N1410 X7.791 I.2435 J0.
N1420 X7.7897 Y-1.0725 I-.2435 J0.
N1430 G3 X7.7907 Y-1.0854 I.0373 J-.0038
N1440 G40 G1 X7.7949 Y-1.1024
N1450 G0 Z.5
N1460 X9.2152 Y-1.7962
N1470 Z.1
N1480 G1 Z-.01 F100.
N1490 G41 D80 X9.2122 Y-1.779 F120.
N1500 G3 X9.2077 Y-1.7668 I-.037 J-.0065
N1510 X8.0273 Y-2.4482 I-.5902 J-.3407
N1520 X9.2077 Y-1.7668 I.5902 J.3407
N1530 X9.1948 Y-1.7453 I-.5902 J-.3407
N1540 X9.1861 Y-1.7357 I-.0318 J-.02
N1550 G40 G1 X9.1723 Y-1.7249
N1560 G0 Z.5
N1570 X8.8692 Y-2.0782
N1580 Z.1
N1590 G1 Z-.01 F100.
N1600 G41 D80 X8.8633 Y-2.0947 F120.
N1610 G3 X8.861 Y-2.1075 I.0352 J-.0128
N1620 G2 X8.374 I-.2435 J0.
N1630 X8.861 I.2435 J0.
N1640 X8.8597 Y-2.1325 I-.2435 J0.
N1650 G3 X8.8607 Y-2.1454 I.0373 J-.0038
N1660 G40 G1 X8.8649 Y-2.1624
N1670 G0 Z.5
N1680 X8.1452 Y-2.8662
N1690 Z.1
N1700 G1 Z-.01 F100.
N1710 G41 D80 X8.1422 Y-2.849 F120.
N1720 G3 X8.1377 Y-2.8367 I-.037 J-.0065
N1730 X6.9573 Y-3.5183 I-.5902 J-.3408
N1740 X8.1377 Y-2.8367 I.5902 J.3408
N1750 X8.1248 Y-2.8153 I-.5902 J-.3408
N1760 X8.1161 Y-2.8057 I-.0318 J-.02
N1770 G40 G1 X8.1023 Y-2.7949
N1780 G0 Z.5
N1790 X7.7992 Y-3.1482
N1800 Z.1
N1810 G1 Z-.01 F100.
N1820 G41 D80 X7.7933 Y-3.1647 F120.
N1830 G3 X7.791 Y-3.1775 I.0352 J-.0128
N1840 G2 X7.304 I-.2435 J0.
N1850 X7.791 I.2435 J0.
N1860 X7.7897 Y-3.2025 I-.2435 J0.
N1870 G3 X7.7907 Y-3.2154 I.0373 J-.0038
N1880 G40 G1 X7.7949 Y-3.2324
N1890 G0 Z.5
N1900 X6.1352 Y-2.8662
N1910 Z.1

N1920 G1 Z-.01 F100.
N1930 G41 D80 X6.1322 Y-2.849 F120.
N1940 G3 X6.1277 Y-2.8367 I-.037 J-.0065
N1950 X4.9473 Y-3.5183 I-.5902 J-.3408
N1960 X6.1277 Y-2.8367 I.5902 J.3408
N1970 X6.1148 Y-2.8153 I-.5902 J-.3408
N1980 X6.1061 Y-2.8057 I-.0318 J-.02
N1990 G40 G1 X6.0923 Y-2.7949
N2000 G0 Z.5
N2010 X5.7892 Y-3.1482
N2020 Z.1
N2030 G1 Z-.01 F100.
N2040 G41 D80 X5.7833 Y-3.1647 F120.
N2050 G3 X5.781 Y-3.1775 I.0352 J-.0128
N2060 G2 X5.294 I-.2435 J0.
N2070 X5.781 I.2435 J0.
N2080 X5.7797 Y-3.2025 I-.2435 J0.
N2090 G3 X5.7807 Y-3.2154 I.0373 J-.0038
N2100 G40 G1 X5.7849 Y-3.2324
N2110 G0 Z.5
N2120 X4.3052 Y-2.8662
N2130 Z.1
N2140 G1 Z-.01 F100.
N2150 G41 D80 X4.3022 Y-2.849 F120.
N2160 G3 X4.2977 Y-2.8367 I-.037 J-.0065
N2170 X3.1173 Y-3.5183 I-.5902 J-.3408
N2180 X4.2977 Y-2.8367 I.5902 J.3408
N2190 X4.2848 Y-2.8153 I-.5902 J-.3408
N2200 X4.2761 Y-2.8057 I-.0318 J-.02
N2210 G40 G1 X4.2623 Y-2.7949
N2220 G0 Z.5
N2230 X3.9592 Y-3.1482
N2240 Z.1
N2250 G1 Z-.01 F100.
N2260 G41 D80 X3.9533 Y-3.1647 F120.
N2270 G3 X3.951 Y-3.1775 I.0352 J-.0128
N2280 G2 X3.464 I-.2435 J0.
N2290 X3.951 I.2435 J0.
N2300 X3.9497 Y-3.2025 I-.2435 J0.
N2310 G3 X3.9507 Y-3.2154 I.0373 J-.0038
N2320 G40 G1 X3.9549 Y-3.2324
N2330 G0 Z.5
N2340 X2.5352 Y-2.8662
N2350 Z.1
N2360 G1 Z-.01 F100.
N2370 G41 D80 X2.5322 Y-2.849 F120.
N2380 G3 X2.5277 Y-2.8367 I-.037 J-.0065
N2390 X1.3473 Y-3.5183 I-.5902 J-.3408
N2400 X2.5277 Y-2.8367 I.5902 J.3408
N2410 X2.5148 Y-2.8153 I-.5902 J-.3408
N2420 X2.5061 Y-2.8057 I-.0318 J-.02
N2430 G40 G1 X2.4923 Y-2.7949
N2440 G0 Z.5
N2450 X2.1892 Y-3.1482

N2460 Z.1
N2470 G1 Z-.01 F100.
N2480 G41 D80 X2.1833 Y-3.1647 F120.
N2490 G3 X2.181 Y-3.1775 I.0352 J-.0128
N2500 G2 X1.694 I-.2435 J0.
N2510 X2.181 I.2435 J0.
N2520 X2.1797 Y-3.2025 I-.2435 J0.
N2530 G3 X2.1807 Y-3.2154 I.0373 J-.0038
N2540 G40 G1 X2.1849 Y-3.2324
N2550 G0 Z.5
N2560 X-.29 Y.011
N2570 Z.1
N2580 G1 Z-.03 F100.
N2590 G41 D80 X.21 F120.
N2600 X9.665
N2610 G2 X9.676 Y0. I0. J-.011
N2620 G1 Y-4.225
N2630 G2 X9.665 Y-4.236 I-.011 J0.
N2640 G1 X.21
N2650 G40 X.085
N2660 G0 Z.5
N2670 G0 Z8. M11
N2680 M99

O0127
(1/4 DIA 82 DEG SPOT DRILL TOOL 32 - DRILL/CBORE)
N10 G0 G90 B0 X.295 Y-2.1075
N20 Z.5 M10
N30 G98 G82 Z-.109 R.1 P150 F20.
N40 G80
N50 G0 Z8. M11
N60 M99

O0128
(TAP DRILL 190-32 TOOL 37 - CHIP BREAK)
N10 G0 G90 B0 X.295 Y-2.1075
N20 Z.5 M10
N30 G98 G73 Z-.5332 R.1 Q.05 F20.
N40 G80
N50 G0 Z8. M11
N60 M99

O0129
(190-32 TAP TOOL 39 - TAP)
N10 G0 G90 B0 X.295 Y-2.1075
N20 Z.5 M10
N30 G98 G84.2 Z-.45 R.1 F15.63 S500
N40 G80
N50 G0 Z8. M11
N60 M99

O0130
(#1 82 DEG CENTER DRILL TOOL 5 - DRILL/CBORE)
N10 G0 G90 B0 X-.31 Y-.175

N20 Z.5 M10
N30 G98 G82 Z-.23 R.1 P150 F20.
N40 Y-.7863
N50 Y-1.3975
N60 Y-2.8275
N70 Y-3.4388
N80 Y-4.05
N90 G80
N100 G0 Z8. M11
N110 M99

O0131
(DRILL FOR 112-40 TAP TOOL 12 - CHIP BREAK)
N10 G0 G90 B0 X-.31 Y-.175
N20 Z.5 M10
N30 G98 G73 Z-.5339 R.1 Q.05 F20.
N40 Y-.7863
N50 Y-1.3975
N60 Y-2.8275
N70 Y-3.4388
N80 Y-4.05
N90 G80
N100 G0 Z8. M11
N110 M99

O0132
(112-40 TAP TOOL 7 - TAP)
N10 G0 G90 B0 X-.31 Y-4.05
N20 Z.5 M10
N30 G98 G84.2 Z-.375 R.1 F12.5 S500
N40 Y-3.4388
N50 Y-2.8275
N60 Y-1.3975
N70 Y-.7863
N80 Y-.175
N90 G80
N100 G0 Z8. M11
N110 M99

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