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O3
(G-SIMPLE, VERSION 2.05)
(USER : BVV)
(CREATED: TUE MAR 26 13:05:14 2013)
N5 G54 G90 G98 G21
N6 M00
(NEW TOOL: CD3.15)
N8 T1 M06 (CD3.15)
N9 S1722 M03
N10 G43 H1 M08
(CENTER DRILLING ID 2 [CD-ID 14])
N12 G00 X10. Y25.
N13 G00 Z25.
N14 G81 R1.5 Z-3. F130.
N15 G80
(CENTER DRILLING ID 3 [CD-ID 15])
N17 G00 X10. Y50.
N18 G00 Z25.
N19 G81 R1.5 Z-3. F130.
N20 G80
(CENTER DRILLING ID 8 [CD-ID 20])
N22 G00 X40. Y37.5
N23 G00 Z25.
N24 G81 R1.5 Z-3. F130.
N25 G80
(CENTER DRILLING ID 7 [CD-ID 19])
N27 G00 X72.5 Y55.
N28 G00 Z25.
N29 G81 R1.5 Z-3. F130.
N30 G80
(CENTER DRILLING ID 6 [CD-ID 18])
N32 G00 X72.5 Y20.
N33 G00 Z25.
N34 G81 R1.5 Z-3. F130.
N35 G80
(CENTER DRILLING ID 9 [CD-ID 21])
N37 G00 X105. Y37.5
N38 G00 Z25.
N39 G81 R1.5 Z-3. F130.
N40 G80
(CENTER DRILLING ID 5 [CD-ID 17])
N42 G00 X135. Y25.
N43 G00 Z25.
N44 G81 R1.5 Z-3. F130.
N45 G80
(CENTER DRILLING ID 4 [CD-ID 16])
N47 G00 X135. Y50.
N48 G00 Z25.

N49 G81 R1.5 Z-3. F130.
N50 G80
N51 G28 Z25.
N52 M00
(NEW TOOL: DHCO04)
N54 T2 M06 (DHCO04)
N55 S1470 M03
N56 G43 H2 M08
(DRILL ID 9)
N58 G00 X105. Y37.5
N59 S1470 M03
N60 G00 Z25.
N61 G83 R1.5 Z-14. Q6. F205.8
N62 G80
(DRILL CLEANING)
N64 G00 Z75.
N65 M05
N66 S2940 M04
N67 G04 P500
N68 M05
N69 S2940 M04
N70 G04 P500
N71 S1470 M03
(DRILL ID 8)
N73 G00 X40. Y37.5
N74 S1470 M03
N75 G00 Z25.
N76 G83 R1.5 Z-14. Q6. F205.8
N77 G80
(DRILL CLEANING)
N79 G00 Z75.
N80 M05
N81 S2940 M04
N82 G04 P500
N83 M05
N84 S2940 M04
N85 G04 P500
N86 S1470 M03
N87 G28 Z25.
N88 M00
(NEW TOOL: DHCO05)
N90 T3 M06 (DHCO05)
N91 S1530 M03
N92 G43 H3 M08
(DRILL ID 7)
N94 G00 X72.5 Y55.
N95 S1530 M03
N96 G00 Z25.
N97 G83 R1.5 Z-14. Q7.5 F245.

N98 G80
(DRILL CLEANING)
N100 G00 Z75.
N101 M05
N102 S3060 M04
N103 G04 P500
N104 M05
N105 S3060 M04
N106 G04 P500
N107 S1530 M03
(DRILL ID 6)
N109 G00 X72.5 Y20.
N110 S1530 M03
N111 G00 Z25.
N112 G83 R1.5 Z-14. Q7.5 F245.
N113 G80
(DRILL CLEANING)
N115 G00 Z75.
N116 M05
N117 S3060 M04
N118 G04 P500
N119 M05
N120 S3060 M04
N121 G04 P500
N122 S1530 M03
N123 G28 Z25.
N124 M00
(NEW TOOL: DHCO06)
N126 T4 M06 (DHCO06)
N127 S1170 M03
N128 G43 H4 M08
(DRILL ID 5)
N130 G00 X135. Y25.
N131 S1170 M03
N132 G00 Z25.
N133 G83 R1.5 Z-14. Q9. F199.
N134 G80
(DRILL CLEANING)
N136 G00 Z75.
N137 M05
N138 S2340 M04
N139 G04 P500
N140 M05
N141 S2340 M04
N142 G04 P500
N143 S1170 M03
(DRILL ID 4)
N145 G00 X135. Y50.
N146 S1170 M03

N147 G00 Z25.
N148 G83 R1.5 Z-14. Q9. F199.
N149 G80
(DRILL CLEANING)
N151 G00 Z75.
N152 M05
N153 S2340 M04
N154 G04 P500
N155 M05
N156 S2340 M04
N157 G04 P500
N158 S1170 M03
(DRILL ID 3)
N160 G00 X10. Y50.
N161 S1170 M03
N162 G00 Z25.
N163 G83 R1.5 Z-14. Q9. F199.
N164 G80
(DRILL CLEANING)
N166 G00 Z75.
N167 M05
N168 S2340 M04
N169 G04 P500
N170 M05
N171 S2340 M04
N172 G04 P500
N173 S1170 M03
(DRILL ID 2)
N175 G00 X10. Y25.
N176 S1170 M03
N177 G00 Z25.
N178 G83 R1.5 Z-14. Q9. F199.
N179 G80
(DRILL CLEANING)
N181 G00 Z75.
N182 M05
N183 S2340 M04
N184 G04 P500
N185 M05
N186 S2340 M04
N187 G04 P500
N188 S1170 M03
N189 G28 Z25.
N190 M00
(NEW TOOL: EM10R4)
N192 T5 M06 (EM10R4)
N193 S987 M03
N194 G43 H5 M08
(CYLINDRICAL POCKET ID 10)

N196 G00 X10. Y50.
 N197 S987 M03
 N198 G00 Z0.
 N199 G01 Z-0.857 F45.
 N200 G03 X9.7 Y50. I-0.15 J0. F188.
 N201 G03 X9.7 Y50. I0.3 J0. F188.
 N202 G03 X10. Y50. I0.15 J0. F188.
 N203 G01 Z-1.714 F45.
 N204 G03 X9.7 Y50. I-0.15 J0. F188.
 N205 G03 X9.7 Y50. I0.3 J0. F188.
 N206 G03 X10. Y50. I0.15 J0. F188.
 N207 G01 Z-2.571 F45.
 N208 G03 X9.7 Y50. I-0.15 J0. F188.
 N209 G03 X9.7 Y50. I0.3 J0. F188.
 N210 G03 X10. Y50. I0.15 J0. F188.
 N211 G01 Z-3.429 F45.
 N212 G03 X9.7 Y50. I-0.15 J0. F188.
 N213 G03 X9.7 Y50. I0.3 J0. F188.
 N214 G03 X10. Y50. I0.15 J0. F188.
 N215 G01 Z-4.286 F45.
 N216 G03 X9.7 Y50. I-0.15 J0. F188.
 N217 G03 X9.7 Y50. I0.3 J0. F188.
 N218 G03 X10. Y50. I0.15 J0. F188.
 N219 G01 Z-5.143 F45.
 N220 G03 X9.7 Y50. I-0.15 J0. F188.
 N221 G03 X9.7 Y50. I0.3 J0. F188.
 N222 G03 X10. Y50. I0.15 J0. F188.
 N223 G01 Z-6. F45.
 N224 G03 X9.7 Y50. I-0.15 J0. F188.
 N225 G03 X9.7 Y50. I0.3 J0. F188.
 N226 G03 X10. Y50. I0.15 J0. F188.
 N227 G00 Z25.
(CYLINDRICAL POCKET ID 11)
 N229 G00 X10. Y25.
 N230 S987 M03
 N231 G00 Z0.
 N232 G01 Z-0.857 F45.
 N233 G03 X9.7 Y25. I-0.15 J0. F188.
 N234 G03 X9.7 Y25. I0.3 J0. F188.
 N235 G03 X10. Y25. I0.15 J0. F188.
 N236 G01 Z-1.714 F45.
 N237 G03 X9.7 Y25. I-0.15 J0. F188.
 N238 G03 X9.7 Y25. I0.3 J0. F188.
 N239 G03 X10. Y25. I0.15 J0. F188.
 N240 G01 Z-2.571 F45.
 N241 G03 X9.7 Y25. I-0.15 J0. F188.
 N242 G03 X9.7 Y25. I0.3 J0. F188.

N243 G03 X10. Y25. I0.15 J0. F188.
 N244 G01 Z-3.429 F45.
 N245 G03 X9.7 Y25. I-0.15 J0. F188.
 N246 G03 X9.7 Y25. I0.3 J0. F188.
 N247 G03 X10. Y25. I0.15 J0. F188.
 N248 G01 Z-4.286 F45.
 N249 G03 X9.7 Y25. I-0.15 J0. F188.
 N250 G03 X9.7 Y25. I0.3 J0. F188.
 N251 G03 X10. Y25. I0.15 J0. F188.
 N252 G01 Z-5.143 F45.
 N253 G03 X9.7 Y25. I-0.15 J0. F188.
 N254 G03 X9.7 Y25. I0.3 J0. F188.
 N255 G03 X10. Y25. I0.15 J0. F188.
 N256 G01 Z-6. F45.
 N257 G03 X9.7 Y25. I-0.15 J0. F188.
 N258 G03 X9.7 Y25. I0.3 J0. F188.
 N259 G03 X10. Y25. I0.15 J0. F188.
 N260 G00 Z25.
(CYLINDRICAL POCKET ID 12)
 N262 G00 X135. Y25.
 N263 S987 M03
 N264 G00 Z0.
 N265 G01 Z-0.857 F45.
 N266 G03 X134.7 Y25. I-0.15 J0. F188.
 N267 G03 X134.7 Y25. I0.3 J0. F188.
 N268 G03 X135. Y25. I0.15 J0. F188.
 N269 G01 Z-1.714 F45.
 N270 G03 X134.7 Y25. I-0.15 J0. F188.
 N271 G03 X134.7 Y25. I0.3 J0. F188.
 N272 G03 X135. Y25. I0.15 J0. F188.
 N273 G01 Z-2.571 F45.
 N274 G03 X134.7 Y25. I-0.15 J0. F188.
 N275 G03 X134.7 Y25. I0.3 J0. F188.
 N276 G03 X135. Y25. I0.15 J0. F188.
 N277 G01 Z-3.429 F45.
 N278 G03 X134.7 Y25. I-0.15 J0. F188.
 N279 G03 X134.7 Y25. I0.3 J0. F188.
 N280 G03 X135. Y25. I0.15 J0. F188.
 N281 G01 Z-4.286 F45.
 N282 G03 X134.7 Y25. I-0.15 J0. F188.
 N283 G03 X134.7 Y25. I0.3 J0. F188.
 N284 G03 X135. Y25. I0.15 J0. F188.
 N285 G01 Z-5.143 F45.
 N286 G03 X134.7 Y25. I-0.15 J0. F188.
 N287 G03 X134.7 Y25. I0.3 J0. F188.
 N288 G03 X135. Y25. I0.15 J0. F188.
 N289 G01 Z-6. F45.

N290 G03 X134.7 Y25. I-0.15 J0. F188.
 N291 G03 X134.7 Y25. I0.3 J0. F188.
 N292 G03 X135. Y25. I0.15 J0. F188.
 N293 G00 Z25.
(CYLINDRICAL POCKET ID 13)
 N295 G00 X135. Y50.
 N296 S987 M03
 N297 G00 Z0.
 N298 G01 Z-0.857 F45.
 N299 G03 X134.7 Y50. I-0.15 J0. F188.
 N300 G03 X134.7 Y50. I0.3 J0. F188.
 N301 G03 X135. Y50. I0.15 J0. F188.
 N302 G01 Z-1.714 F45.
 N303 G03 X134.7 Y50. I-0.15 J0. F188.
 N304 G03 X134.7 Y50. I0.3 J0. F188.
 N305 G03 X135. Y50. I0.15 J0. F188.
 N306 G01 Z-2.571 F45.
 N307 G03 X134.7 Y50. I-0.15 J0. F188.
 N308 G03 X134.7 Y50. I0.3 J0. F188.
 N309 G03 X135. Y50. I0.15 J0. F188.
 N310 G01 Z-3.429 F45.
 N311 G03 X134.7 Y50. I-0.15 J0. F188.
 N312 G03 X134.7 Y50. I0.3 J0. F188.
 N313 G03 X135. Y50. I0.15 J0. F188.
 N314 G01 Z-4.286 F45.
 N315 G03 X134.7 Y50. I-0.15 J0. F188.
 N316 G03 X134.7 Y50. I0.3 J0. F188.
 N317 G03 X135. Y50. I0.15 J0. F188.
 N318 G01 Z-5.143 F45.
 N319 G03 X134.7 Y50. I-0.15 J0. F188.
 N320 G03 X134.7 Y50. I0.3 J0. F188.
 N321 G03 X135. Y50. I0.15 J0. F188.
 N322 G01 Z-6. F45.
 N323 G03 X134.7 Y50. I-0.15 J0. F188.
 N324 G03 X134.7 Y50. I0.3 J0. F188.
 N325 G03 X135. Y50. I0.15 J0. F188.
 N326 G00 Z25.
 N327 G28 Z25.
 N328 M00
(NEW TOOL: EM06FL4)
 N330 T6 M06 (EM06FL4)
 N331 S1114 M03
 N332 G43 H6 M08
(FINE MILL CYL.POCKET ID 10)
 N334 S1114 M03
 N335 G00 X10. Y50.
 N336 G00 Z1.5
 N337 G03 X7.5 Y50. Z-2.25 I-1.25 J0. F192.

N338 G03 X7.5 Y50. I2.5 J0. Z-6. F192.
N339 G03 X7.5 Y50. I2.5 J0. F192.
N340 G03 X10. Y50. I1.25 J0. F192.
N341 G00 Z25.
(FINE MILL CYL.POCKET ID 11)
N343 S1114 M03
N344 G00 X10. Y25.
N345 G00 Z1.5
N346 G03 X7.5 Y25. Z-2.25 I-1.25 J0. F192.
N347 G03 X7.5 Y25. I2.5 J0. Z-6. F192.
N348 G03 X7.5 Y25. I2.5 J0. F192.
N349 G03 X10. Y25. I1.25 J0. F192.
N350 G00 Z25.
(FINE MILL CYL.POCKET ID 12)
N352 S1114 M03
N353 G00 X135. Y25.
N354 G00 Z1.5
N355 G03 X132.5 Y25. Z-2.25 I-1.25 J0. F192.
N356 G03 X132.5 Y25. I2.5 J0. Z-6. F192.
N357 G03 X132.5 Y25. I2.5 J0. F192.
N358 G03 X135. Y25. I1.25 J0. F192.
N359 G00 Z25.
(FINE MILL CYL.POCKET ID 13)
N361 S1114 M03
N362 G00 X135. Y50.
N363 G00 Z1.5
N364 G03 X132.5 Y50. Z-2.25 I-1.25 J0. F192.
N365 G03 X132.5 Y50. I2.5 J0. Z-6. F192.
N366 G03 X132.5 Y50. I2.5 J0. F192.
N367 G03 X135. Y50. I1.25 J0. F192.
N368 G00 Z25.
N369 M09
N370 M30
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