

Block	Description	Purpose
%	Start of program.	Start Program
O0001 (PROJECT1)	Program number (Program Name).	
(T1 0.25 END MILL)	Tool description for operator.	
N1 G17 G20 G40 G49 G80 G90	Safety block to ensure machine is in safe mode.	
N2 T1 M6	Load Tool #1.	Change Tool
N3 S9200 M3	Spindle Speed 9200 RPM, On CW.	
N4 G54	Use Fixture Offset #1.	
N5 M8	Coolant On.	
N6 G00 X-0.025 Y-0.275	Rapid above part.	Move To Position
N7 G43 Z1. H1	Rapid to safe plane, use Tool Length Offset #1.	
N8 Z0.1	Rapid to feed plane.	
N9 G01 Z-0.1 F18.	Line move to cutting depth at 18 IPM.	
N10 G41 Y0.1 D1 F36.	CDC Left, Lead in line, Dia. Offset #1, 36 IPM.	Machine Contour
N11 Y2.025	Line move.	
N12 X2.025	Line move.	
N13 Y-0.025	Line move.	
N14 X-0.025	Line move.	
N15 G40 X-0.4	Turn CDC off with lead-out move.	
N16 G00 Z1.	Rapid to safe plane.	
N17 M5	Spindle Off.	
N18 M9	Coolant Off.	Change Tool
(T2 0.25 DRILL)	Tool description for operator.	
N19 T2 M6	Load Tool #2.	
N20 S3820 M3	Spindle Speed 3820 RPM, On CW.	
N21 M8	Coolant On.	Move To Position
N22 X1. Y1.	Rapid above hole.	
N23 G43 Z1. H2	Rapid to safe plane, use Tool Length Offset 2.	
N24 Z0.25	Rapid to feed plane.	
N25 G98 G81 Z-0.325 R0.1 F12.	Drill hole (canned) cycle, Depth Z-.325, F12.	Drill Hole
N26 G80	Cancel drill cycle.	
N27 Z1.	Rapid to safe plane.	
N28 M5	Spindle Off.	End Program
N29 M9	Coolant Off.	
N30 G91 G28 Z0	Return to machine Home position in Z.	
N31 G91 G28 X0 Y0	Return to machine Home position in XY.	
N32 G90	Reset to absolute positioning mode (for safety).	
N33 M30	Reset program to beginning.	
%	End Program.	

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CNC Machining Handbook: Building, Programming, and Implementation Alan Overby,2010-10-06 A Practical Guide to CNC Machining Get a thorough explanation of the entire CNC process from start to finish including the various machines and their uses and the necessary software and tools CNC Machining Handbook describes the steps involved in building a CNC machine to custom specifications and successfully implementing it in a real world application Helpful photos and illustrations are featured throughout Whether you re a student hobbyist or business owner looking to move from a manual manufacturing process to the accuracy and repeatability of what CNC has to offer you ll benefit from the in depth information in this comprehensive resource CNC Machining Handbook covers Common types of home and shop based CNC controlled applications Linear motion guide systems Transmission systems Stepper and servo motors Controller hardware Cartesian coordinate system CAD computer aided drafting and CAM computer aided manufacturing software Overview of G code language Ready made CNC systems

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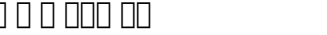
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