

⊘

o14001

(11.0000.0.000.000 1 36841)

(DATA Tue Jan 13 14:08:05 2015)

(PROGRAM PROGRAM\_1)

(MACHINE TIME = 4.03 MIN)

(CUTTING TIME = 3.48 MIN)

(-----TOOL LIST-----)

(NUMER 4 TIME: 1.53 MIN)

(NAME: D32R3.1\_001LV70LP10Z5 D=32.000 R=3.100)

(NUMER 5 TIME: 2.10 MIN)

(NAME: D16R3\_001LV65LP36Z4 D=16.000 R=3.000)

(-----END TOOL LIST-----)

N1 G17 G90 G54 G21 N2 T4 M6

N2 T4 M6

N3 (OPERATION PROGRAM\_1\_1)

N4 (TOOL D32R3.1\_001LV70LP10Z5)

N5 S448 M3

N6 G1 X182.321 Y-13.562 F9000.

N7 G43 Z100. H4 N8 Z2.3 F3000.

N9 Z-.7 F134.

N10 G3 X165. Y-3.562 1-17.321 J-10.

N11 G1 XO.O F269.

N12 G3 X-17.321 Y-13.562 10.0 J-20.

N13 G1 Z2.3 N14 Z10. F9000.

N15 X186. Y-.585 N16 Z2.3 F3000.

N17 Z-.7 F134.

N18 X182.321 Y5.788

N19 G3 X165. Y15.788 1-17.321 J-10.

N20 G1 XO.O F269.

N21 G3 X-17.321 Y5.788 10.0 J-20.

N22 G1 X-21. Y-.585

N23 Z2.3

N24 Z10. F9000.

N25 X186. Y18.765 N26 Z2.3 F3000.

N27 Z-.7 F134.

N28 X182.321 Y25.138

N29 G3 X165. Y35.138 1-17.321 J-10.

N30 G1 XO.O F269.

N31 G3 X-17.321 Y25.138 10.0 J-20.

N32 G1 X-21. Y18.765

N36 (TOOL D16R3\_001LV65LP36Z4)  
N37 G49 G53 ZO.O M5 N38 G17 G90 GO  
G21 N39 T5 M6  
N40 (OPERATION PROGRAM\_1\_2)  
N41 (TOOL D16R3\_\_001LV65LP36Z4)  
N42 S995 M3  
N43 G1 X175.392 Y-8.236 N44 G43 Z100.  
H5  
N45 Z-.5 F3000.  
N46 Z-1. F199.  
N47 G3 X165. Y-2.236 1-10.392 J-6.  
N48 G1 XO.O F398.  
N49 G3 X-10.392 Y-8.236 10.0 J-12.  
N50 G1 Z-.5  
N51 Z10. F9000.  
N52 X176. Y-1.789 N53 Z-.5 F3000.  
N54 Z-1. F199.  
N55 X175.392 Y-.736  
N56 G3 X165. Y5.264 1-10.392 J-6  
N57 G1 XO.O F398.  
N58 G3 X-10.392 Y-.736 10.0 J-12  
N59 G1 X-11. Y-1.789  
N60 Z-.5  
N61 Z10. F9000.  
N62 X176. Y5.711 N63 Z-.5 F3000.  
N64 Z-1. F199.  
N65 X175.392 Y6.764  
N66 G3 X165. Y12.764 1-10.392 J-6. N67 G1 XO.O F398.  
N68 G3 X-10.392 Y6.764 10.0 J-12.  
N69 G1 X-11. Y5.711  
N70 Z-.5  
N71 Z10. F9000.  
N72 X176. Y13.211 N73 Z-.5 F3000.  
N74 Z-1. F199.  
N75 X175.392 Y14.264  
N76 G3 X165. Y20.264 X-10.392 J-6.  
N77 G1 XO.O F398.  
N78 G3 X-10.392 Y14.264 10.0 J-12.  
N79 G1 X-11. Y13.211  
N80 Z-.5  
N81 Z10. F9000.

N86 G3 X165. Y27.764 1-10.392 J-6.  
N87 G1 XO.O F398.  
N88 G3 X-10.392 Y21.764 10.0 J-12.  
N89 G1 X-11. Y20.711  
N90 Z-.5  
N91 Z10. F9000.  
N92 X176. Y28.211 N93 Z-.5 F3000.  
N94 Z-1. F199.  
N95 X175.392 Y29.264  
N96 G3 X165. Y35.264 1-10.392 J-6.  
N97 G1 XO.O F398.  
N98 G3 X-10.392 Y29.264 10.0 J-12.  
N99 G1 X-11. Y28.211  
N100 Z-.5  
N101 Z10. F9000.  
N102 X176. Y35.711 N103 Z-.5 F3000.  
N104 Z-1. F199.  
N105 X175.392 Y36.764  
N106 G3 X165. Y42.764 1-10.392 J-6.  
N107 G1 XO.O F398.  
N108 G3 X-10.392 Y36.764 10.0 J-12.  
N109 G1 X-11. Y35.711  
N110 Z-.5  
N111 Z100. F9000.  
N112 G28 G91 ZO.  
N113 M30

‰