

O0001(Drill Spot Tap M10)

G94(FEED IN MM/MIN)

T02 M06 (8MM CARBIDE DRILL)

G90 G0 G54 X0 Y0 S3500 M3
G43 H02 Z3.

G81 G98 Z-15. R1. F700.
X40.
Y20.
X0
G80

G0 G53 Z0

T01 M06 (12MM DIA X 90 POINT SPOT DRILL)

G90 G0 G54 X0 Y0 S1500 M3
G43 H01 Z3.
G81 G98 Z-6. R1. F200.
X40.
Y20.
X0
G80

G0 G53 Z0

T03 M06 (M10 X 1.5 TAP)

G90 G0 G54 X0 Y0 S500 M3
G43 H03 Z3.

G95 (FEED PER REV)
M29 S500

G84 G98 Z-12. R1. F1.5
X40.
Y20.
X0
G80

G0 G53 Z0
G53 Y0

G94

M30
%

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