

Block	Description	Purpose
%	Start of program.	Start Program
00001 (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.	Move To Position
N5 M8	Coolant On.	
N6 G00 X-0.025 Y-0.275	Rapid above part.	
N7 G43Z1. 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.	Machine Contour
N10G41 Y0.1 D1 F36.	CDC Left, Lead in line, Dia. Offset #1, 36 IPM.	
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.	Change Tool
N17 M5	Spindle Off.	
N18 M9	Coolant Off.	
(T2 0.25 DRILL)	Tool description for operator.	
N19 T2 M6	Load Tool #2.	Move To Position
N20 S3820 M3	Spindle Speed 3820 RPM, On CW.	
N21 M8	Coolant On.	
N22X1. Y1.	Rapid above hole.	Drill Hole
N23 G43 Zz1. H2	Rapid to safe plane, use Tool Length Offset 2.	
N24 Z0.25	Rapid to feed plane.	End Program
N25 G98 G81 Z-0.325 R0.1 F12.	Drill hole (canned) cycle, Depth z- 325, F12.	
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 XOYO	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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Table of Contents M G Code Tsugami Machine

1. Understanding the eBook M G Code Tsugami Machine
 - The Rise of Digital Reading M G Code Tsugami Machine
 - Advantages of eBooks Over Traditional Books
2. Identifying M G Code Tsugami Machine
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an M G Code Tsugami Machine
 - User-Friendly Interface
4. Exploring eBook Recommendations from M G Code Tsugami Machine
 - Personalized Recommendations
 - M G Code Tsugami Machine User Reviews and Ratings
 - M G Code Tsugami Machine and Bestseller Lists
5. Accessing M G Code Tsugami Machine Free and Paid eBooks
 - M G Code Tsugami Machine Public Domain eBooks
 - M G Code Tsugami Machine eBook Subscription Services
 - M G Code Tsugami Machine Budget-Friendly Options
6. Navigating M G Code Tsugami Machine eBook Formats
 - ePub, PDF, MOBI, and More
 - M G Code Tsugami Machine Compatibility with Devices
 - M G Code Tsugami Machine Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of M G Code Tsugami Machine
 - Highlighting and Note-Taking M G Code Tsugami Machine
 - Interactive Elements M G Code Tsugami Machine
8. Staying Engaged with M G Code Tsugami Machine

- Joining Online Reading Communities
- Participating in Virtual Book Clubs
- Following Authors and Publishers M G Code Tsugami Machine
- 9. Balancing eBooks and Physical Books M G Code Tsugami Machine
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection M G Code Tsugami Machine
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine M G Code Tsugami Machine
 - Setting Reading Goals M G Code Tsugami Machine
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of M G Code Tsugami Machine
 - Fact-Checking eBook Content of M G Code Tsugami Machine
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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