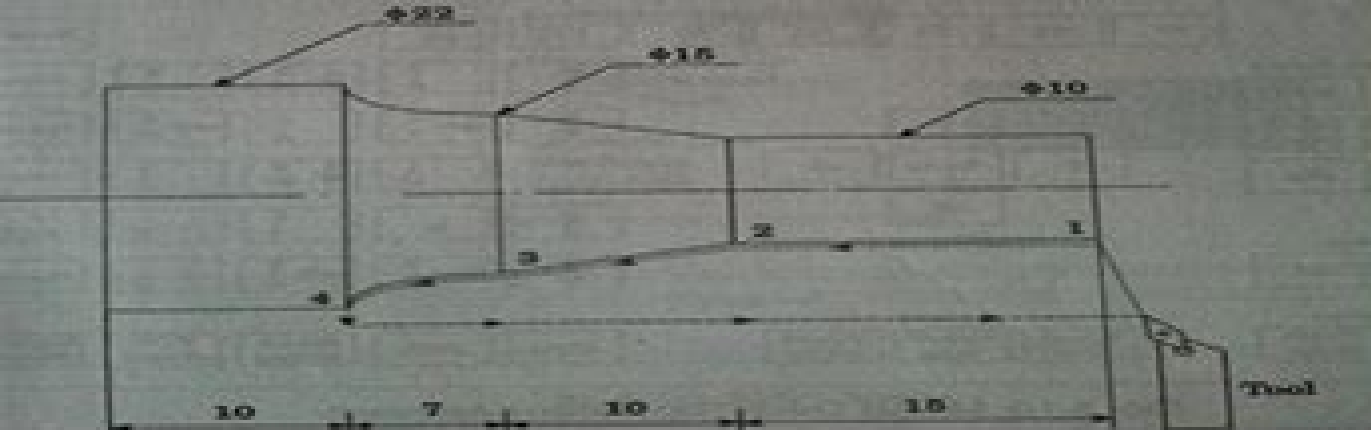




O000	Programmer number
BILLET X23 Z45	Billet size
N10 G21 G98	Feed & depth of cut in MKS units
N20 G28 U0 W0	Tool post home position
N30 M06 T0202	Tool number
N40 M03 S1200	Speed of the spindle
N50 G00 X23 Z2	Rapid feed to start position
N60 G71 U0.25 R1	Multi turning operation, 0.25 depth of cut, 1 mm tool retraction, 0.1 mm finishing allowance, 60 mm/min feed, from line N60 to N130
N70 G71 P80 Q120 U0.1 W0 F60	
N80 G01 X10	Linear motion of the tool
N90 G01 X10 Z-15	
N100 G01 X15 Z-25	
N110 G03 X22 Z-32 R7	Counter clockwise arc X22
N120 G01 X22 Z-42	
N130 G70 P60 Q120	Finishing cycle
N140 G28 U0 W0	Home position for the tool post
N150 M05	Spindle stop
N160 M30	END OF THE PROGRAMME

Example for Drilling

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Table of Contents Lathe Machine Experiment Manual

1. Understanding the eBook Lathe Machine Experiment Manual
 - The Rise of Digital Reading Lathe Machine Experiment Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Lathe Machine Experiment Manual
 - 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 Lathe Machine Experiment Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Lathe Machine Experiment Manual
 - Personalized Recommendations
 - Lathe Machine Experiment Manual User Reviews and Ratings
 - Lathe Machine Experiment Manual and Bestseller Lists
5. Accessing Lathe Machine Experiment Manual Free and Paid eBooks
 - Lathe Machine Experiment Manual Public Domain eBooks
 - Lathe Machine Experiment Manual eBook Subscription Services
 - Lathe Machine Experiment Manual Budget-Friendly Options

6. Navigating Lathe Machine Experiment Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Lathe Machine Experiment Manual Compatibility with Devices
 - Lathe Machine Experiment Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Lathe Machine Experiment Manual
 - Highlighting and Note-Taking Lathe Machine Experiment Manual
 - Interactive Elements Lathe Machine Experiment Manual
8. Staying Engaged with Lathe Machine Experiment Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Lathe Machine Experiment Manual
9. Balancing eBooks and Physical Books Lathe Machine Experiment Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Lathe Machine Experiment Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Lathe Machine Experiment Manual
 - Setting Reading Goals Lathe Machine Experiment Manual
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Lathe Machine Experiment Manual
 - Fact-Checking eBook Content of Lathe Machine Experiment Manual
 - 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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