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168 G90 G97 F950 ;
169 G0 Z-0.0 Y0 M3 S3500 P12 ;
170 G0 X41.0 C0 R28 ;
171 (CYCLE HERE) ;
172 G1111 G0.5 H2. 11. J20.5 L-6.
    C1. F125. P0.5 Z11. A0.5 S125.
    B0.5 E125. U1.5 V118. K0.451 ;
173 M98 P506 (CROSS DRILL 1.5) ;
174 G0 X100.0 ;
175 G28 U0. V0. M45 ;
176 M29 ;
177 M1 ;

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