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| Label | Value  |
|-------|--------|
| X     | 0.0000 |
| Z     | 0.0000 |
| Y     | 0.0000 |
| C     | 0.0000 |
| A     | 0.0000 |
| E     | 0.0000 |



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|         | F   | 0.10000000 |      |
|         | G40 | 10         | 40   |
|         | G54 | 00         | 97   |
| 05      | G70 | 69.1       | 13.1 |

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168 G90 G97 F950 ;
169 G0 Z-0.0 Y0 M43 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 R29 ;
177 R1 ;

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Figure 1

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**Lingsheng Yao**



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