

SAMPLE

CNC CODE:

(ID WORK)

N1 G96 S600 M8

N2 G87 N3

N3 G81

G0 G90 X-2.196 Z4.1

G95 G1 X-2.55 Z4.0 G42 F0.004

Z3.105

G2 X-2.3 Z2.98 I0.125 F.002

G1 X-2.0

X-1.5

G0 Z4.1

G40

G80

(OD WORK)

N1 G96 S600 M8

N2 G87 N3

N3 G81

G0 G90 X3.804 Z4.1

G95 G1 X3.45 Z4.0 G42 F.004

Z2.0

Z1.985 F.002

X4.7

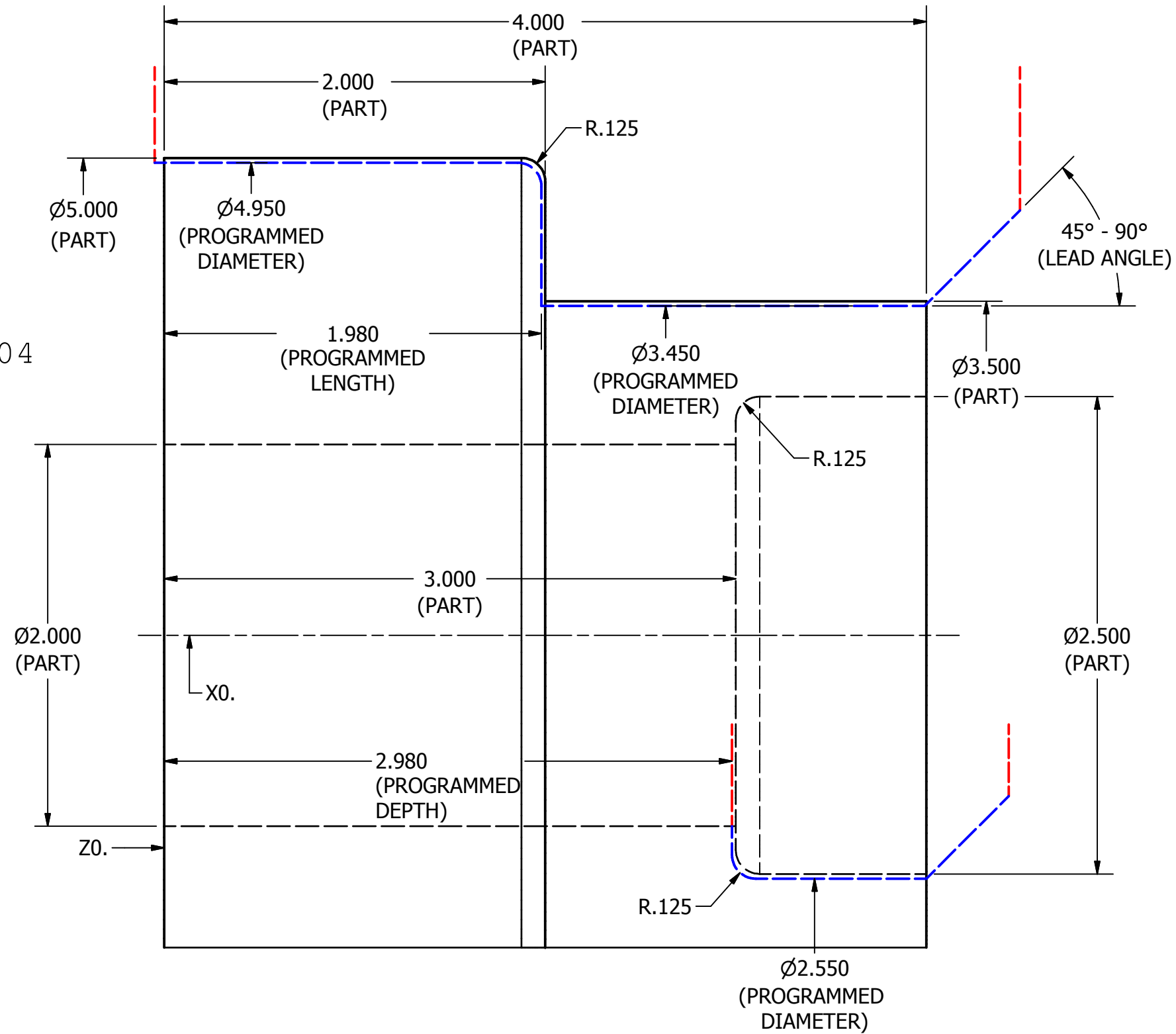
G3 X4.95 Z1.86 K-.125

G1 Z-.05 F.004

G0 X6.95

G40

G80



NOTES:

1. MACHINE CODE WAS PROCESSED FOR AN OKUMA LATHE.
2. THERE ARE MANY VARIABLES THAT ALTER MACHINE CODE, INCLUDING BUT NOT LIMITED TO THE MACHINE CONTROL, PART ORIENTATION, PART ORIGIN, TOOL NOSE RADIUS COMPENSATION, ABSOLUTE OR INCREMENTAL PROGRAMMING, ETC.
3. MACHINE CODE IS FOR REFERENCE ONLY AND MAY NOT BE COPIED, REPRODUCED OR USED TO MANUFACTURE ANYTHING HEREON WITHOUT WITTEN PERMISSION FROM ELLIOTT TOOL TECHNOLOGIES.

M MARKING METHOD					TOLERANCES UNLESS OTHERWISE SPECIFIED .XX = ±.02 .XXX = ±.005 ANGLES = ±.5°		MAT'L SPEC	MAT'L REQUIRED			THIS DRAWING CONTAINS INFORMATION OF A PROPRIETARY NATURE AND IS ISSUED FOR REFERENCE USE ONLY AND MAY NOT BE COPIED, REPRODUCED OR USED TO MANUFACTURE ANYTHING SHOWN HEREON WITHOUT WRITTEN PERMISSION.																																
					BREAK SHARP CORNERS .030" MAX.		HARDNESS	PROCESS SPEC	DESCRIPTION																																		
<table border="1"> <thead> <tr> <th>REV</th> <th>ECN</th> <th>DATE</th> <th>ENG</th> <th>DESCRIPTION</th> </tr> </thead> <tbody> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> </tbody> </table>					REV	ECN	DATE	ENG	DESCRIPTION																										MACHINED SURFACES - 125 MICRO. MAX.		FINISH		ENG	DRAW DATE	TOOL NO.	PROJECT NO.	
REV	ECN	DATE	ENG	DESCRIPTION																																							
					DIMENSIONS ENCLOSED IN PARENTHESIS ARE FOR REFERENCE ONLY				3/14/2016																																		
					DIAMETERS ON COMMON CENTERS TO BE CONCENTRIC WITHIN .003" T.I.R.		WEIGHT (LBS.)	VOLUME (CU. IN.)	CHECK	CHECK DATE	PART NO.	S2289 Tool Path																															
					DO NOT SCALE DRAWING																																						