

Date:	Pages:	Filename:
8/2/2021 8:26:32 AM	1	D:\...\DieSetProject\CAM\GNM\axlePART1.mpf

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; % N_AXLEPART_MPF
; this is axle support part
N10 G90 G94 G18
N11 G71
N12 LIMS=S6000
N13 G53 G0 X0.

; Face1
N14 T1 D1
N15 G54
N16 M8
N17 G95
N18 G97 S485 M3
N19 G0 X60. Z5
N20 G96 S91 M3
N21 LIMS=S5000
N22 G0 Z1.414
N23 X40.
N24 G1 X32.828 F0.127
N25 X30. Z0
N26 X-1.6
N27 X1.228 Z1.414
N28 G0 X60.
N29 Z5
N30 G97 S485 M3

; Profile1
N31 G95
N32 G97 S582 M3
N33 G0 X50. Z5
N34 G96 S91 M3
N35 LIMS=S5000
N36 G0 Z1.414
N37 X31.795
N38 G1 X30.828 F0.127
N39 X28. Z0
N40 Z-78.8
N41 X30.
N42 X34.
N43 G0 Z1.414
N44 X28.828
N45 G1 X26. Z0 F0.127
N46 Z-78.8
N47 X28.
N48 X30.828 Z-77.386
N49 G0 Z1.414
N50 X26.828
N51 G1 X24. Z0 F0.127
N52 Z-78.8
N53 X26.
N54 X28.828 Z-77.386
N55 G0 Z1.414
N56 X24.828
N57 G1 X22. Z0 F0.127
N58 Z-11.213
N59 G18 G3 X23.9 Z-12.8 I-0.85 K-1.587
N60 G1 Z-66.8
N61 X23.886 Z-66.957
N62 X22.907 Z-72.554
N63 Z-78.8
N64 X24.
N65 X26.828 Z-77.386
N66 G0 Z1.414
N67 X22.828
N68 G1 X20. Z0 F0.127
N69 Z-11
N70 X20.3
N71 G3 X23. Z-11.609 K-1.8
N72 G1 X25.828 Z-10.195
N73 G0 Z1.414
N74 X20.828
N75 G1 X18. Z0 F0.127
N76 Z-1.104
N77 X18.846 Z-1.527
N78 G3 X19.9 Z-2.8 I-1.273 K-1.273
N79 G1 Z-11
N80 X20.3
N81 G3 X21. Z-11.034 K-1.8
N82 G1 X23.828 Z-9.62
N83 G0 Z1.414
N84 X19.724
N85 G1 X16.896 Z0 F0.127
N86 Z-0.552
N87 X18.846 Z-1.527
N88 X19. Z-1.609
N89 X21.828 Z-0.195
N90 G0 Z1.414
N91 X18.62
N92 G1 X15.791 Z0 F0.127

N93 X17.896 Z-1.052
N94 X20.724 Z0.362
N95 G0 X25.735
N96 Z-10.145
N97 G1 Z-71.139 F0.127
N98 X22.907 Z-72.554
N99 X21.814 Z-78.8
N100 X22.907
N101 X25.735 Z-77.386
N102 G0 Z1.18
N103 X16.26
N104 G1 X13.431 Z-0.234 F0.127
N105 X17.431 Z-2.234
N106 G3 X17.9 Z-2.8 I-0.566 K-0.566
N107 G1 Z-12
N108 X20.3
N109 G3 X21.9 Z-12.8 K-0.8
N110 G1 Z-66.8
N111 X21.894 Z-66.87
N112 X19.806 Z-78.8
N113 X22.635 Z-77.386
N114 X24.069
N115 G0 X50.
N116 Z5
N117 G97 S582 M3

N118 M9
N119 G53 X0.
N120 G53 Z0
N121 M30

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