

MILL – E1	LATHE-E1
G71 G90 M04 1700 FEED 670 G00 X8 G01 Z-2 G01 X15 G01 X20 Y17.83 G01 X25 Y0 G00 X50 G03 X50 Y10 X60 Y10 G01 X60 Y19.97 G02 X60 Y34.97 X60 Y49.97 G01 X47.5 Y65 G01 X35 G01 X30 Y44.11 G01 X25 Y65 G01 X10 G03 X10 Y55 X0 Y55 G01 X0 Y45 G02 X0 Y30 X0 Y15 G01 X0 Y8 G03 X8 Y8 X8 Y0 G00 Z1 G00 X18.45 Y30 G00 Z0 G83 3 2 X30 Y30 Z-5 X41.55 Y30 G00 X41.55 Y30 G83 0 2 X30 Y30 Z-5 X18.45 Y30 M30	G71 G90 M04 640 FEED 320 V10 2 V11 0.5 G00 X25 Z70 G81 X10 Z51 G00 X10 G81 X4.56 Z56 G00 X0 G02 X4.56 Z56 R23 G00 X10 G00 Z51 G85 X4.67 Z56 R5 G00 X25 G00 Z34 G83 X15 Z51 G00 Z34 G03 X25 Z10 R30 M30
	SUB-E1
	M98 SUB G91 G01 Z-2 Y8 X20 Y-8 X-8 Y4 X-8 Y-4 X-4 G00 Z2 G90 M99

MILL – E2	LATHE-E2
G71 G90 M04 1700 FEED 670 G00 X8 G01 Z-2 G01 X16 Y0 G01 Z-2 G01 X25 G02 X35 Y0 X45 Y0 G01 X50 G03 X50 Y10 X60 Y10 G01 Y30 G01 X43 G01 X60 Y50 G01 Y57 G03 X52 Y57 X52 Y65 G01 X38 G03 X38 Y57 X30 Y57 G01 Y52 G01 X0 G03 X0 Y40 X0 Y30 G01 X18 G01 X8 Y11 G03 X16 Y8 X16 Y0 G00 Z2 G00 X23 Y25 G00 Z0 G83 0 2 X30 Y32 Z-5 X37 Y38 G00 X37 Y38 G83 3 2 X30 Y32 Z-5 X23 Y25 M30	G71 G90 M04 640 FEED 320 V10 2 V11 0.5 G81 X20 Z5 G00 X20 G81 X15 Z15 G00 Z10 G85 X15 Z15 R5 G00 Z70 G00 X15 G81 X10 Z25 G00 Z20 G85 X10 Z25 R5 G00 X10 Z52.68 G83 X0 Z70 G00 X10 Z47.68 G03 X10 Z32 R22 M30
	SUB-E2
	M98 SUB G91 G01 Z-2 Y8 X4 Y-4 X8 Y4 X8 Y-8 X-20 G00 Z2 G90 M99

MILL – E3	LATHE-E3
G71	G71
G90	G90
M04 1700	M04 640
FEED 670	FEED 320
G00 X8	V10 2
G01 Z-2	V11 0.5
G01 X10 Y8	G00 X25 Z70
G01 Z-2	G81 X22 Z10
G03 X18 Y8	G00 X22
X18 Y0	G81 X20 Z25
G01 X25	G00 X20 Z25
G02 X35 Y0	G02 X22 Z10 R57.25
X45 Y0	G00 Z70
G01 X50	G00 X20
G03 X50 Y10	G81 X15 Z50
X60 Y10	G00 Z30
G01 X38 Y29	G83 X15 Z50
G01 X60 Y65	G00 Z70
G01 X45	G00 X15
G02 X30 Y65	G81 X10 Z60
X15 Y65	G00 X10
G01 X10	G81 X5 Z65
G03 X10 Y55	G00 X5 Z65
X0 Y55	G85 X0 Z70 R5
G01 Y42	G00 X10
G01 X21 Y29	G00 Z60
G01 X10 Y13	G84 X5 Z65 R5
G01 Y8	G00 X15
G00 Z2	G00 Z55
G00 X24 Y35	G85 X10 Z60 R5
G00 Z0	M30
G83 0 2	SUB-E3
X30 Y41 Z-5	M98 SUB
X36 Y47	G91
G00 X36 Y47	G01 Z-2
G83 3 2	Y8
X30 Y41 Z-5	X20
X24 Y35	Y-8
M30	X-4
	Y4
	X-8
	Y-4
	X-8
	G00 Z2
	G90
	M99

MILL – E4	LATHE-E4
G71	G71
G90	G90
M04 1700	M04 640
FEED 670	FEED 320
G00 X8	V10 2
G01 Z-2	V11 0.5
G01 X13	G00 X25 Z70.12
G01 Y10	G81 X20 Z15
G01 X24 Y0	G00 X25
G01 X36	G00 Z10
G01 Y12	G84 X20 Z15 R5
G02 X43 Y12	G00 Z70.12
X50 Y12	G00 X20
G01 Y0	G81 X15 Z21.82
G01 X60	G00 Z16.82
G01 Y20	G85 X15 Z21.82 R5
G02 X60 Y30	G00 Z70.12
X60 Y40	G00 X15
G01 Y65	G81 X10 Z26.82
G01 X50	G00 Z21.82
G01 Y47	G84 X10 Z26.82 R5
G01 X30 Y65	G00 Z70.12
G01 X20	G00 X10
G01 Y53	G81 X6 Z50.56
G02 X17 Y53	G00 Z35.72
X14 Y53	G83 X6 Z50.56
G01 Y65	G00 Z70.12
G03 X13 Y52	G00 X5
X0 Y52	G03 X6 Z60 R9.64
G01 X0 Y0	M30
G00 Z2	SUB-E4
G00 X13 Y23	M98 SUB
G00 Z0	G91
G83 3 2	G01 Z-2
X20 Y30 Z-5	Y8
X27 Y37	X8
G00 X27 Y37	Y-4
G83 0 2	X8
X20 Y30 Z-5	Y4
X13 Y23	X4
M30	Y-8
	X-20
	G00 Z2
	G90
	M99