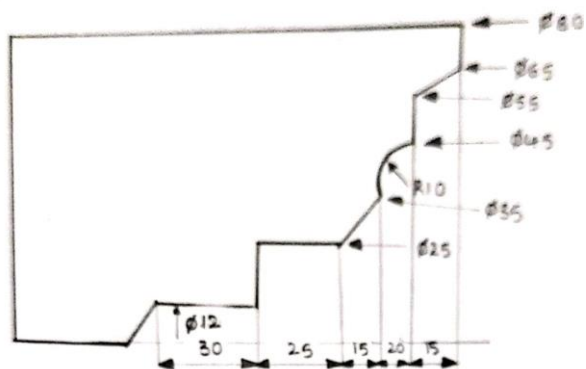


TURNING



O1002

G21 G98

G28 U0 W0

M06 T0101

M03 S1200

G00 X0 Z2

G01 Z0 F35

G74 R1

G74 X0 Z-5 Q500 F20

G28 U0 W0

M06 T0808

M03 S1000

G00 X0 Z1

G01 Z0

G74 R1

G74 X0 Z-105 Q500 F50

G00 X0 Z1

G28 U0 W0

M06 T0202

M03 S800

G00 X12 Z1

G01 Z0

G71 U1 R1

G71 P10 Q20 U0.1 W0.1 F35

N10 G01 X65 Z0

G01 X55 Z-15

G01 X45 Z-15

G01 X35 Z-35

G01 X25 Z-50

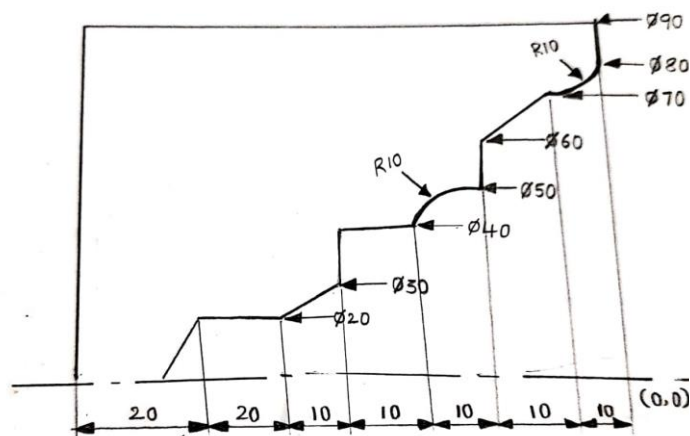
G01 X25 Z-7

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G28 U0 W0

M05 M30

TURNING



O1010

G21 G98

G28 U0 W0

M06 T0101

M03 S1200

G00 X0 Z2

G01 Z0 F35

G74 R1

G74 G01 Z-5 Q500 F20

G28 U0 W0

M06 T0202

M03 S1500

G00 X0 Z2

G01 Z0

G74 R1

G74 G01 X0 Z-70 Q500 F20

G28 U0 W0

M06 T0303

M03 S800

G00 X20 Z1

G01 Z0

G71 U1 R1

G71 P10 Q20 U0.1 W0.1 F25

N10 G00 X90

G01 X90 Z0 F45

G01 X80 Z0

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G01 X60 Z-20

G01 X50 Z-20

G03 X40 Z-30 R10 F25

G01 X40 Z-40

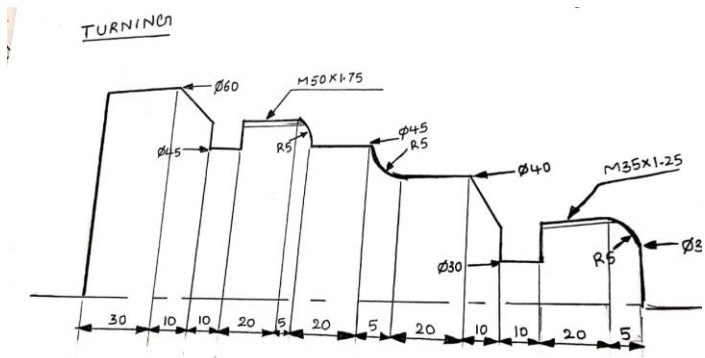
G01 X30 Z-40

G01 X20 Z-50

N20 G00 X0 Z0

G28 U0 W0

M05 M30



O1001

G21 G98

G28 U0 W0

M06 T0101

M03 S1200

G00 X60 Z0

G71 U1 R1

G71 P10 Q20 U0.1 W0.1 F35

N10 G01 X30 Z0

G03 X35 Z-5 R5 F35

G01 X35 Z-35

G01 X40 Z-45

G01 X40 Z-65

G02 X45 Z-70 R5 F35

G01 X45 Z-90

G03 X50 Z-95 R5 F35

G01 X50 Z-125

G01 X60 Z-135

N20 G01 Z-165

G28 U0 W0

M06 T0202

M03 S1450

G00 X60 Z1

G70 P10 Q20 U0 W0 F25

G28 U0 W0

M06 T0505

M03 S650

G00 X35 Z-34.9

G75 R5

G75 X30 Z-35 F25

G00 X50 Z-35

G01 X51

G00 Z-124.9

G75 R5

G75 X45 Z-125 F25

G28 U0 W0

M06 T0707

G00 X35 Z-5

G76 P031560 Q20 R0.15

G76 X34.235 Z-23 P0766 Q30 F1.75

G00 X50 Z-35

G01 X50

G00 Z-95

G76 P031560 Q20 R0.15

G76 X48.928 Z-113 P1073 Q30 F1.75

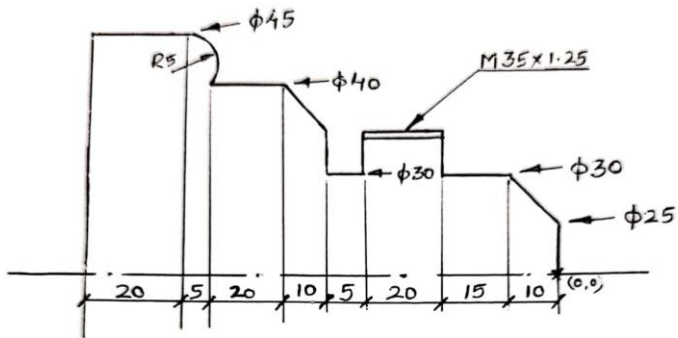
G28 U0 W0

M05 M30

G28 U0 W0

M05 M30

TURNING



O1001

G21 G98

G28 U0 W0

M06 T0101

M03 S1200

G00 X45 Z1

G71 U1 R1

G71 P10 Q20 U0.1 W0.1 F35

N10 G01 X25 Z0

G01 X30 Z-10

Z-25

G01 X35

Z-50

G01 X40 Z-60

G01 Z-80

G03 X45 Z-85 R5 F35

N20 G00 Z-105

G28 U0 W0

M06 T0202

M03 S1450

G00 X45 Z1

G70 P10 Q20 U0 W0 F25

G28 U0 W0

M06 T0505

M03 S800

G00 X35 Z-49.9

G75 R5

G75 X30 Z-50

G28 U0 W0

M06 T0707

G00 X35 Z-27

G76 P031560 Q20 R0.15

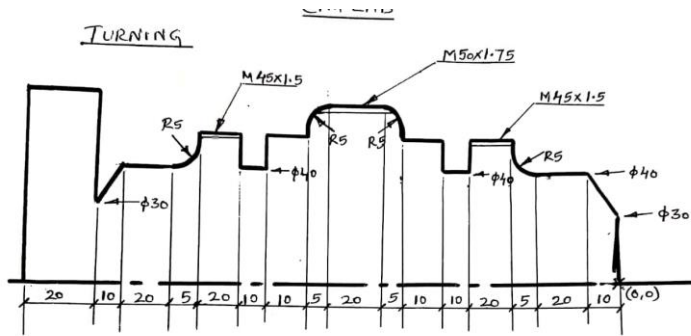
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G28 U0 W0

M05 M30

G28 U0 W0

M05 M30



O0101

G21 G98

G28 U0 W0

M06 T0101

M03 S1200

G00 X50 Z0

G71 U1 R1

G71 P10 Q20 U0 W0 F50

N10 G00 X30 Z0

G01 X40 Z-10

Z-30

G02 X45 Z-35 R5 F25

G01 Z-75

G03 X50 Z-80 R5 F25

G01 Z-100

G03 X45 Z-105 R5 F25

G01 X45 Z-115

G01 X45 Z-145

G02 X40 Z-150 R5 F25

G01 X40 Z-170

G01 X30 Z-180

G01 X50 Z-180

N20 G01 X50 Z0

G28 U0 W0

M06 T0505

M03 S800

G00 X60 Z-64.9

G75 R1

G75 G01 X40 Z-65 F45

G00 X60

Z-120

G00 X60 Z-124.9

G75 R1

G75 G01 X40 Z-125 F45

G00 X50

G28 U0 W0

M06 T0202

G00 X45 Z-35

G76 P031560 Q20 R0.5

G76 X44.0805 Z-53 P0919 Q30 F1.5

G01 X45 Z0

G00 X50

G00 Z-80

G76 P031560 Q20 R0.5

G76 X48.92 Z-98 P1072 Q30 F1.75

G01 X50

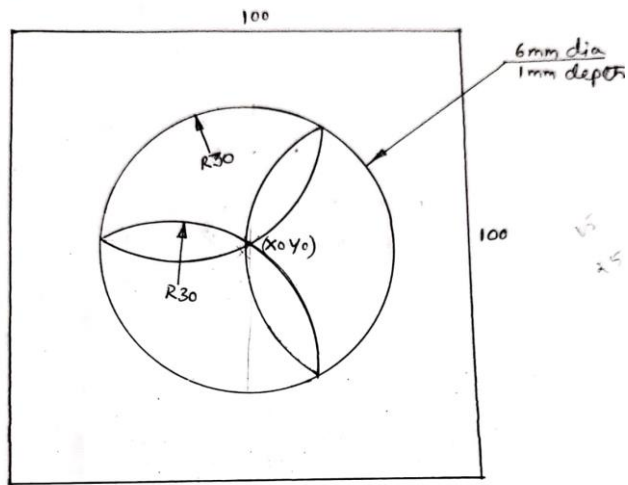
G00 Z-125

G76 P031560 Q20 R0.5

G76 X44.0805 Z-143 P0919 Q30 F1.5

G28 U0 W0

M05 M30



O1010

G21 G94

G91 G28 Z0

G28 X0 Y0

M06 T0101

M03 S1500

G90 G00 X0 Y0 F50

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G01 Z-5

G02 X30 Y0 R30

G02 X-30 Y0 R30

G02 X15 Y-25 R30

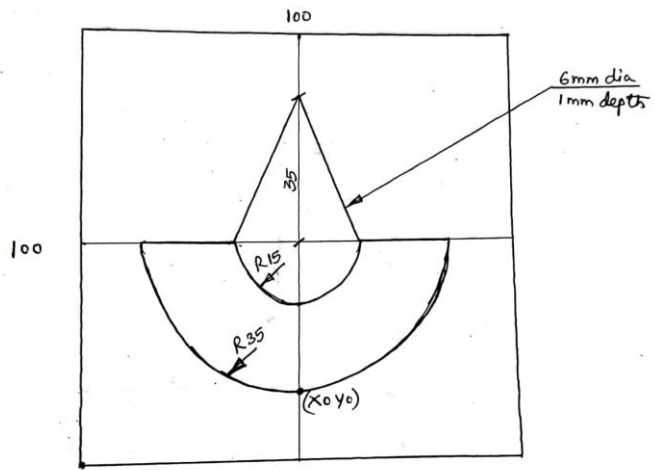
G02 X15 Y25 R30

G02 X-30 Y0 R30

G00 Z0

G28 X0 Y0

M05 M30



O1010

G21 G94

G91 G28 Z0

G28 X0 Y0

MO6 T0101

M03 S1500

G90 G00 X0 Y0 F35

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G01 Z-5

G01 X-35 Y0

G03 X35 Y0 R35

G01 X15 Y0

G02 X-15 Y0 R15

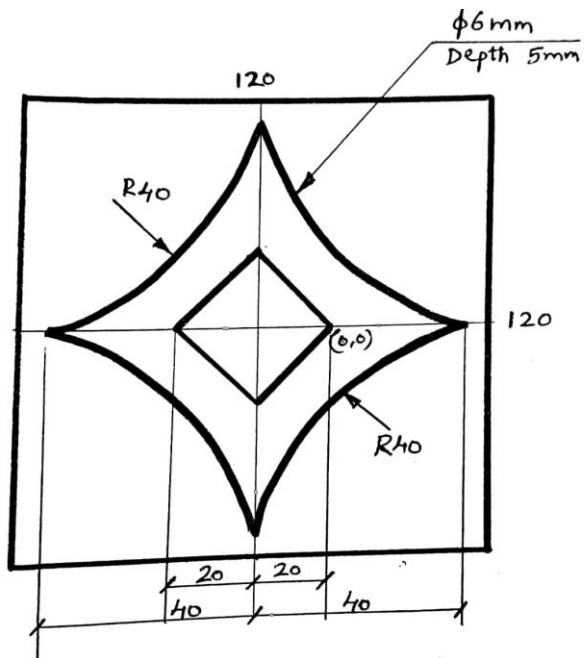
G01 X0 Y35

G01 X15 Y0

G00 Z0

G28 X0 Y0

M05 M30



O1010

G21 G94

G91 G28 Z0

G28 X0 Y0

M06 T0101

M03 S1500

G90 G00 X0 Y0 F35

G01 X-40 Y0

G01 Z-5

G02 X0 Y-40 R40

G02 X40 Y0 R40

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G01 Z0

G01 X-20 Y0

G01 Z-5

G01 X0 Y20

G01 X20 Y0

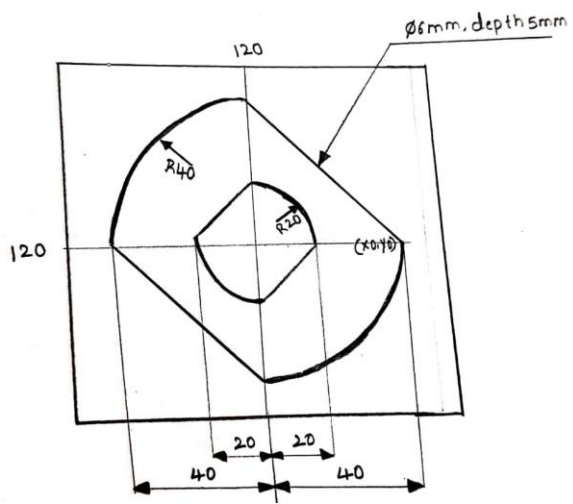
G01 X0 Y-20

G01 X-20 Y0

G01 Z0

G28 X0 Y0

M05 M30



O1010

G21 G94

G91 G28 Z0

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M06 T0101

M03 S1500

G90 G00 X0 Y0 F35

G01 X-20 Y0

G01 Z-5

G01 X0 Y20

G02 X20 Y0 R20

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G01 Z0

G01 X-40 Y0

G01 Z-5

G01 X0 Y-40

G03 X40 Y0 R40

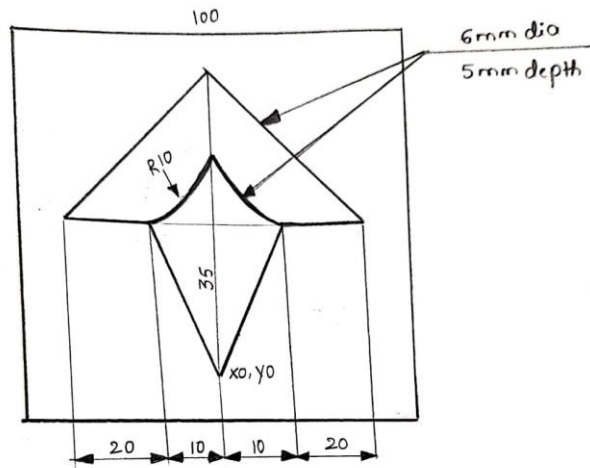
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G00 Z0

G28 X0 Y0

M05 M30



O1010

G21 G94

G91 G28 Z0

G28 X0 Y0

M06 T0101

M03 S1500

G90 G00 X0 Y0 F35

G00 X-10 Y0

G01 Z-5

G01 X-30 Y0

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G02 X0 Y10 R10

G02 X-10 Y0 R10

G01 X0 Y-35

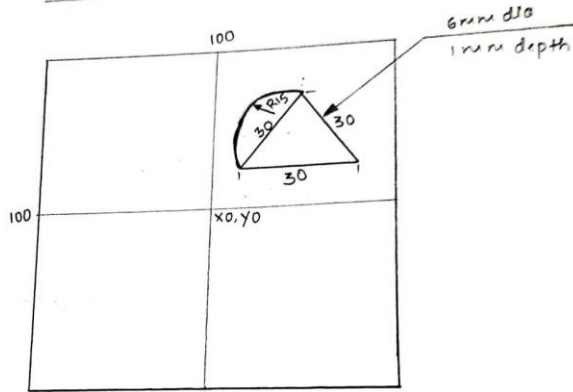
G01 X10 Y0

G00 Z0

G28 X0 Y0

M05 M30

MILLING — MIRRORING



O1010

G21 G94

G91 G28 Z0

G28 X0 Y0

M06 T0101

M03 S1500

G90 G00 X0 Y0 Z5

M98 P0015000

M70

M98 P0015000

M80

M70

M71

M98 P0015000

M80

M81

M71

M98 P0015000

G00 Z5

G91 G28 Z0

M05 M30

O5000

G00 X18 Y30 Z5

G01 Z-5 F45

G01 X30 Y18

G01 X42 Y30

G01 X30 Y42

G01 X18 Y30

G00 Z5

G00 X0 Y0

M99