O0510(MC-SE-KADAI20110510)

G90G54G17

N1(FACEMILL-R)

G49T01M06

G90G54G17

G00X0Y0

G43Z100.0H01

S955M03

M08

G00X-60.0Y15.0

G00Z5.0

G01Z0.2F477

X60.0

Y-15.0

X-60.0

Y15.0

N2(FACEMILL-F)

S1910

G01Z0F287

X60.0

Y-15.0

X-60.0

G00Z100.0

X0X0

M09

M05

G91G28Z0

G49

G90

M01

N3(D12MILL-OUTLINE-R)

G49T02M06

G90G54G17

G00X0Y0

G43Z100.0H02

S2123M03

M08

G00X-45.0Y0

Z5.0

G01Z-9.8F637

M98<O1510.TXT>D02

G01Z-4.8

X-35.0Y0

M98<O2510.TXT>D12

M98<O2510.TXT>D02

G00Z100.0

X0Y0

M09

M05

G91G28Z0

G49

G90

M01

N4(D12MILL-OUTLINE-F)

G49T03M06

G90G54G17

G00X0Y0

G43Z100.0H03

S5308M03

M08

G00X-45.0Y0

Z5.0

G01Z-10.0F796

M98<O1510.TXT>D03

G01Z-5.0

X-35.0Y0

M98<O2510.TXT>D12

M98<O2510.TXT>D03

G00Z100.0

X0Y0

M09

M05

G91G28Z0

G49

G90

M01

N5(D10DRILL-CENTER&CHAMFER)

G49T06M06

G90G54G17

G00X0Y0

G43Z100.0H06

S1990M03

M08

G00Z5.0(INITIAL-POINT)

G98G82Z-8.85R0P91F199K0

M98<O3510.TXT>

G80G00Z100.0

X0Y0

M09

M05

G91G28Z0

G49

G90

M01

N6(D5DRILL-HOLE)

G49T04M06

G90G54G17

G00X0Y0

G43Z100.0H04

S3185M03

M08

G00Z5.0(INITIAL-POINT)

G98G73Z-25.04R0Q1.5F318K0

M98<O3510.TXT>

G80G00Z100.0

X0Y0

M09

M05

G91G28Z0

G49

G90

M01

N7(D6-TAPPING)

G49T05M06

G90G54G17

G00X0Y0

G43Z100.0H05

S1062M03

M08

G00Z5.0(INITIAL-POINT)

G98G84Z-19.5R0F1062K0

M98<O3510.TXT>

G80G00Z100.0

X0Y0

M09

M05

G91G28Z0

G49

G90

M01

N8(D10-CHAMFER)

G49T06M06

G90G54G17

G00X0Y0

G43Z100.0H06

S2654M03

M08

G00X-45.0Y0

Z0

G01Z-8.0F531

M98<O1510.TXT>D06

G01Z-3.0

X-35.0Y0

M98<O2510.TXT>D06

G00Z100.0

X0Y0

M09

M05

G91G28Z0

G28Y0

G49

G90

M30

O1510(RECTANG-SUB)

G41Y-20.0

G03X-25.0Y0R20.0

G01Y19.0

G02X-19.0Y25.0R6.0

G01X20.0

X25.0Y20.0

Y-19.0

G02X19.0Y-25.0R6.0

G01X-20.0

X-25.0Y-20.0

Y0

G03X-45.0Y20.0R20.0

G40G00Y0

M99

O2510(CIRCLE-SUB)

G41Y-20.0

G03X-15.0Y0R20.0

G02I15.0

G03X-35.0Y20.0R20.0

G40G01Y0

M99

O3510(HOLE-SUB)

X-18.0Y-18.0

Y18.0

X18.0

Y-18.0

M99