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example nc part programming. 12

n030g81x2.000y0.875r0.100z-1.000f5m03. explanation (some steps are left out) g81 fixed cycle x2.000, y0.875 the m/c table will rapid to hole #1 position r0.100 the m/c spindle will rapid down so that the drill point is 0.100 inch above the surface of the

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NC Part Programming This manual describes the use of NC (Numerical Control) Part Programming, which includes the BNC (Basic Numerical Control) and the ISNC (Industry Standard

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Numerical Control) Editor portion of the CNC software as it is used on the machine tool console.

NC Part Programming Manual - Stone Machinery

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