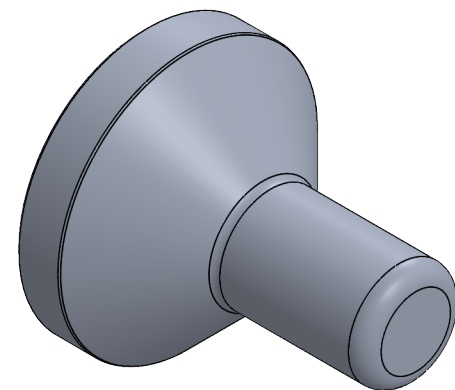
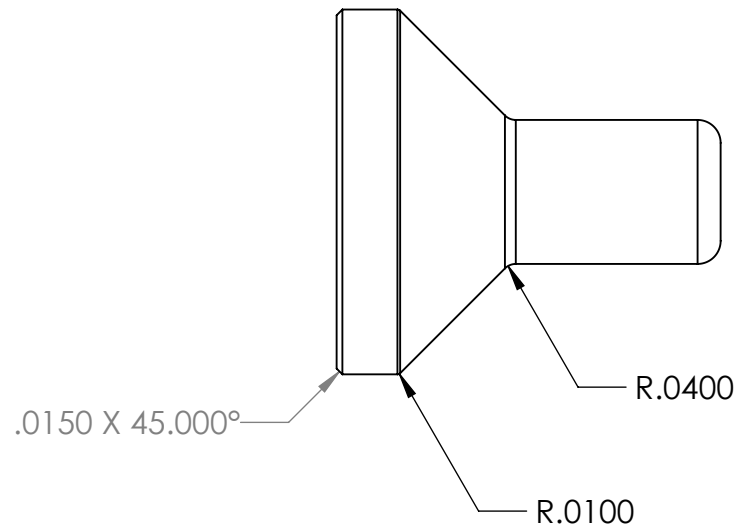


2

1

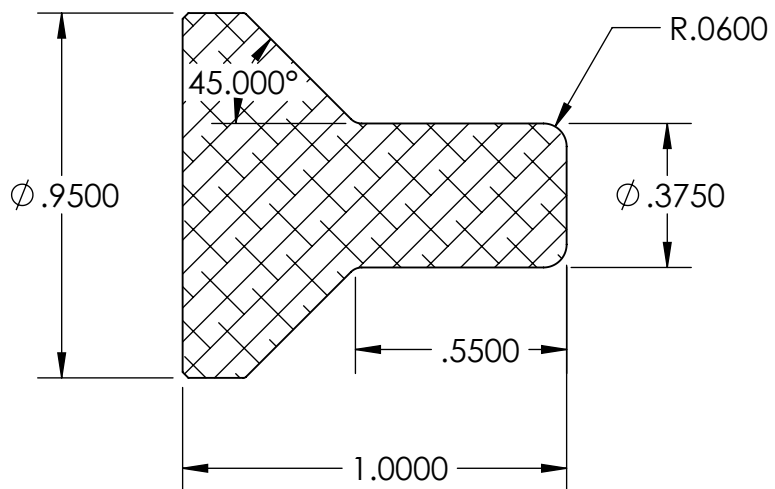
B

B



A

A



Adam Hathaway

TITLE:

Pawn

SIZE

Monday, June 18, 1812 9:32:52 AM

A

Material: 6061-T6 (SS)

SCALE: 2:1

SHEET 1 OF 1

2

1

%
 O01501 (PAWN MTT71C FALL 2021 9-4-21)
 (ELI GONZALEZ)
 (2.000 STOCK STICKOUT)
 (TOOL 0101 1/64R OD TURNING AND FACING TOOL)
 (TOOL 1020 .125 PARTING TOOL)
 (T0707 STOCK PULLER)
 N10 G00 G18 G80 G40 G99 (ROUGH AND FINISH THE
 OUTER CONTOUR)
 N20 G28 U0
 N30 G28 W0
 N40 T101 (1/64R OD TURNING AND FACING TOOL)
 N50 G97 S300 M03 (SET RPM)
 N60 G00 Z0.25
 N70 X1.325 / M08 (Tool Position #1)
 N80 G50 S4500
 N90 G96 S500
 / N100 G71 P120 Q210 U0.02 W0.003 D0.075 F0.01
 N110 G42 (1/64R)
 N120 G00 X0.0313 (Tool Position #2)
 (X = 2 * TOOL NOSE R1/64 = 0.03125)
 N130 G01 Z0. F0.005 (Tool Position #3)
 (F = SET FEEDRATE PER CHABOT STANDARDS)
 N140 X0.255 (Tool Position #4)
 N150 G03 X0.375 Z-0.06 I0 K-0.06 (Tool Position #5)
 N160 G01 Z-0.5334 (Tool Position #6)
 N170 G02 X0.3984 Z-0.5617 I0.04 K0 (Tool Position #7)
 N180 G01 X0.9441 Z-0.8346 (Tool Position #8)
 N190 G03 X0.95 Z-0.8416 I-0.0071 K-0.0071 (Tool Position
 #9)
 N200 G01 Z-1.25 (Tool Position #10)
 N210 G40 X1.325 (Tool Position #11)

N220 G00 Z0.25
 / N230 G70 P110 Q210
 N240 M09
 N250 G00 Z0.25 M05
 N260 G28 U0
 N270 G28 W0
 N280 M01
 N290 G00 G18 G80 G40 G99 (PART OFF WITH .015
 CHAMFER)
 N300 G28 U0
 N310 G28 W0
 N320 T1020 (.125 PARTING TOOL)
 N330 G97 S300 M03
 N340 G00 Z-1.
 N350 X1.325 / M08
 N360 G50 S3500
 N370 G96 S300
 N380 M36
 N390 G01 X0.9 F0.003
 N400 G04 P0.135
 N410 U0.25 F0.02
 N420 W0.1209
 N430 U-0.2417 W-0.1209 F0.003
 N440 X0
 N450 X1.325 F0.02 M09
 N460 M37
 N465 G00 Z0.25 M05
 N470 G28 U0
 N480 G28 W0
 N490 M01
 N500 G00 G18 G80 G40 G99 M05 (STOCK PULL)
 N510 G28 U0

```
N520 G28 W0
N530 T707 (STOCK PULLER)
N540 G00 Z-1.625
N550 X4.125
N560 G01 G98 X0 F50.
N570 M11
N580 G04 P0.5
N590 W1.155
N591 M10
N610 G04 P0.5
N620 G99
N630 G00 G28 U0
N640 G28 W0
N650 M30
%
```