



SAMPLE CNC CODE:

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N1 G96 S600 M8
N2 G87 N3
N3 G81
G0 G90 X6.95 Z4.05
X3.804 Z4.177
G95 G1 X3.45 Z4.0 G42 F.004
Z2.0
Z1.985 F.002
X4.7
G3 X4.95 Z1.86 K-.125
G1 Z-.05 F.004
G0 X6.95
G40
G80
    
```

- NOTES:
1. MACHINE CODE WAS PROCESSED FOR AN OKUMA LATHE.
 2. THERE ARE MANY VARIABLES THAT ALTER MACHINE CODE, INCLUDING BUT NOT LIMITED TO THE MACHINE CONTROL, PART ORIENTATION, PART ORIGIN, TOOL NOSE RADIUS COMPENSATION, ABSOLUTE OR INCREMENTAL PROGRAMMING, ETC.
 3. MACHINE CODE IS FOR REFERENCE ONLY AND MAY NOT BE COPIED, REPRODUCED OR USED TO MANUFACTURE ANYTHING HEREON WITHOUT WITTEN PERMISSION FROM ELLIOTT TOOL TECHNOLOGIES.

M MARKING METHOD					TOLERANCES UNLESS OTHERWISE SPECIFIED .XX = ±.02 .XXX = ±.005 ANGLES = ±.5°		MAT'L SPEC	MAT'L REQUIRED			THIS DRAWING CONTAINS INFORMATION OF A PROPRIETARY NATURE AND IS ISSUED FOR REFERENCE USE ONLY AND MAY NOT BE COPIED, REPRODUCED OR USED TO MANUFACTURE ANYTHING SHOWN HEREON WITHOUT WRITTEN PERMISSION.		
					BREAK SHARP CORNERS .030" MAX.		HARDNESS	PROCESS SPEC	DESCRIPTION				
REV	ECN	DATE	ENG	DESCRIPTION	MACHINED SURFACES - 125 MICRO. MAX.		FINISH		ENG	DRAW DATE	TOOL NO.	PROJECT NO.	
					DIMENSIONS ENCLOSED IN PARENTHESIS ARE FOR REFERENCE ONLY					3/14/2016			
					DIAMETERS ON COMMON CENTERS TO BE CONCENTRIC WITHIN .003" T.I.R.		WEIGHT (LBS.)		VOLUME (CU. IN.)		CHECK	CHECK DATE	PART NO.
					DO NOT SCALE DRAWING						S2075 Tool Path		

SUPERSEDES