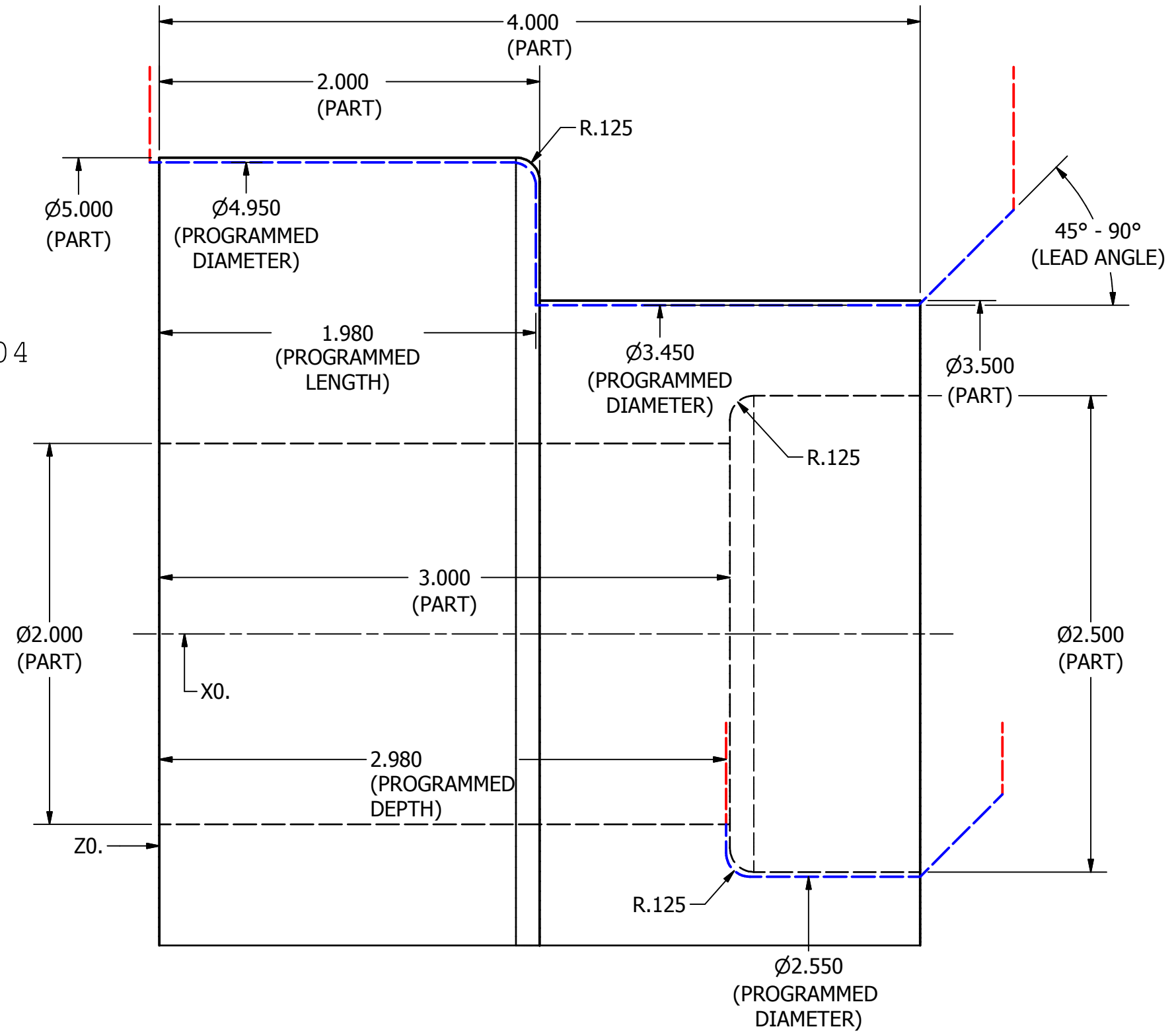


SAMPLE
 CNC CODE:
 (ID WORK)
 N1 G96 S600 M8
 N2 G87 N3
 N3 G81
 G0 G90 X-2.196 Z4.1
 G95 G1 X-2.55 Z4.0 G42 F0.004
 Z3.105
 G2 X-2.3 Z2.98 I0.125 F.002
 G1 X-2.0
 X-1.5
 G0 Z4.1
 G40
 G80

(OD WORK)
 N1 G96 S600 M8
 N2 G87 N3
 N3 G81
 G0 G90 X3.804 Z4.1
 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° BREAK SHARP CORNERS .030" MAX.		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.	
				MACHINED SURFACES - 125 MICRO. MAX.		HARDNESS		PROCESS SPEC		DESCRIPTION	
REV	ECN	DATE	ENG	DESCRIPTION		FINISH		ENG		DRAW DATE	
										3/14/2016	
				DIMENSIONS ENCLOSED IN PARENTHESIS ARE FOR REFERENCE ONLY		WEIGHT (LBS.)		VOLUME (CU. IN.)		CHECK	
				DIAMETERS ON COMMON CENTERS TO BE CONCENTRIC WITHIN .003" T.I.R.						CHECK DATE	
				DO NOT SCALE DRAWING						PART NO.	
										S2320 Tool Path	