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O00002 (GIVE YOUR PROGRAM A NAME)
(YOUR PROGRAM NAME SHOULD INCLUDE)
(DRAWING #)
(REVISION LEVEL)

G17 G20 G40 G49 G64 G80 G90 G98 (SAFE BLOCK)

(*****SPOT DRILL HOLE LOCATIONS*****)

T01 M06 (1/2 X 90 SPOT DRILL)
G00 G90 G54 X0.575 Y0.575 S500 M03 (POSITION TO HOLE 1)
G43 Z1.00 H01 M08 (TOOL LENGTH COMPENSATION ON - COOLANT ON)
G01 Z0.100 F25.0 (FEED TO SAFE DISTANCE)
G81 Z-0.166 R0.100 F12.0 (DRILLING CANNED CYCLE ON - DRILL HOLE 1
X0.575 Y2.425 (POSITION TO HOLE 2 AND DRILL)
X3.425  (POSITION TO HOLE 3 AND DRILL)
Y1.250 (POSITION TO HOLE 4 AND DRILL)
X2.5 Y0.5 Z-0.291 R-0.025 (POSITION TO HOLE 5 AND DRILL)
X3.0 (POSITION TO HOLE 6 AND DRILL)
X3.5 (POSITION TO HOLE 7 AND DRILL)
G80 (CANCEL CANNED CYCLE)
G00 G49 Z0.0 M09 (TOOL LENGTH COMPENSATION OFF)


(*****DRILL THRU HOLES*****)

T02 M06 (1/4 JOBBER LENGTH DRILL)
G00 G90 G54 X0.575 Y0.575 S1387 M03 (POSITION TO HOLE 1)
G43 Z1.0 H02 M08 (TOOL LENGTH COMPENSATION ON - COOLANT ON)
G01 Z0.1 F25.0 (FEED TO SAFE DISTANCE)
G81 Z-0.643 F1.35 R0.1 (DRILLING CANNED CYCLE ON - DRILL HOLE 1)
X0.575 Y2.425 (POSITION TO HOLE 2 AND DRILL)
X3.425  (POSITION TO HOLE 3 AND DRILL)
Y1.250 (POSITION TO HOLE 4 AND DRILL)
X2.5 Y0.5 Z-0.291 R-0.025 (POSITION TO HOLE 5 AND DRILL)
X3.0 (POSITION TO HOLE 6 AND DRILL)
X3.5 (POSITION TO HOLE 7 AND DRILL)
G80 (CANCEL CANNED CYCLE)
G00 G49 Z0.0 M09 (TOOL LENGTH COMPENSATION OFF)
G28 G91 Z0.0 (HOME Z AXIS)
G28 Y0.0 (HOME Y AXIS)
M30 (PROGRAM END - REWIND)
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