

R810301N

%

O0001 (R810301N)

(CREATED ON 06 AUG 13 - 08:58)

(MATERIAL: 15 mm Baltic Birch Ply)

(LOAD: Material face UP)

G0 G21 G91 G28 Z0 M15

G90 G40 M22

M88 B0

M89 B0

G08 P1

M25

(ROUTE TOOL #16: 1/4 DOWN SHEAR)

(DIAMETER: 6.35)

G0 G54 G90 X0. Y0.

T16

G0 G54 G90 X1076.325 Y1881.886 M13 S18000

G43 H16 Z40.386

G0 Z21.336

G1 Z8.636 F1200.

Y2423.414 F450.

G0 Z40.386

X1196.975 Y1767.586 Z40.386

Z21.336

G1 Z8.636 F1200.

Y2423.414 F450.

G0 Z40.386

X1120.775 Y1737.614 Z40.386

Z21.336

R810301N

G1 Z8.636 F1200.
Y1081.786 F450.
G0 Z40.386
X1120.775 Y1051.814 Z40.386
Z21.336
G1 Z8.636 F1200.
Y510.286 F450.
G0 Z40.386
G80
G17 G91 G28 Z0 M95
M92
(ROUTE TOOL #14: 3/8 DOWN SHEAR)
(DIAMETER: 9.525)
G0 G54 G90 X1120.775 Y510.286
T14
G0 G54 G90 X1012.825 Y2427.2875 M13 S18000
G43 H14 Z40.386
G0 Z21.336
G1 G42 D4 X1038.225 Z8.636 F14000.
X1092.2
Y2421.8265
X984.25
Y2427.2875
X1038.225
X1047.75
G40 X1073.15 Z21.336
G0 Z40.386
X1196.975 Y2436.8125 Z40.386

R810301N

Z21.336
G1 G42 D4 X1158.875 Z2.286
X1104.9
Y2443.1625
X1212.85
Y2436.8125
X1158.875
X1149.35
G40 X1111.25 Z21.336
G0 Z40.386
X1063.625 Y1878.0125 Z40.386
Z21.336
G1 G42 D4 X1038.225 Z8.636
X984.25
Y1883.4735
X1092.2
Y1878.0125
X1038.225
X1028.7
G40 X1003.3 Z21.336
G0 Z40.386
X1120.775 Y1754.1875 Z40.386
Z21.336
G1 G42 D4 X1158.875 Z2.286
X1212.85
Y1747.8375
X1104.9
Y1754.1875

R810301N

X1158.875
X1168.4
G40 X1206.5 Z21.336
G0 Z40.386
X1196.975 Y1751.0125 Z40.386
Z21.336
G1 G42 D4 X1158.875 Z2.286
X1104.9
Y1757.3625
X1212.85
Y1751.0125
X1158.875
X1149.35
G40 X1111.25 Z21.336
G0 Z40.386
X1120.775 Y1068.3875 Z40.386
Z21.336
G1 G42 D4 X1158.875 Z2.286
X1212.85
Y1062.0375
X1104.9
Y1068.3875
X1158.875
X1168.4
G40 X1206.5 Z21.336
G0 Z40.386
X1133.475 Y1055.6875 Z40.386
Z21.336

R810301N

G1 G42 D4 X1158.875 Z8.636

X1212.85

Y1050.2265

X1104.9

Y1055.6875

X1158.875

X1168.4

G40 X1193.8 Z21.336

G0 Z40.386

X1184.275 Y506.4125 Z40.386

Z21.336

G1 G42 D4 X1158.875 Z8.636

X1104.9

Y511.8735

X1212.85

Y506.4125

X1158.875

X1149.35

G40 X1123.95 Z21.336

G0 Z40.386

X1200.404 Y1751.0125 Z40.386

Z21.336

G1 Z5.461

Y1765.3

X1199.896

Y1751.0125

X1172.8873

Y1765.3

R810301N

X1172.3793
Y1751.0125
X1145.3707
Y1765.3
X1144.8627
Y1751.0125
X1117.854
Y1765.3
X1117.346
Y1751.0125
G0 Z40.386
X1117.346 Y1754.1875 Z40.386
Z21.336
G1 Z5.461
Y1739.9
X1117.854
Y1754.1875
X1144.8627
Y1739.9
X1145.3707
Y1754.1875
X1172.3793
Y1739.9
X1172.8873
Y1754.1875
X1199.896
Y1739.9
X1200.404

R810301N

Y1754.1875
G0 Z40.386
X1117.346 Y2439.9875 Z40.386
Z21.336
G1 Z5.461
Y2425.7
X1117.854
Y2439.9875
X1144.8627
Y2425.7
X1145.3707
Y2439.9875
X1172.3793
Y2425.7
X1172.8873
Y2439.9875
X1199.896
Y2425.7
X1200.404
Y2439.9875
G0 Z40.386
X1200.404 Y1065.2125 Z40.386
Z21.336
G1 Z5.461
Y1079.5
X1199.896
Y1065.2125
X1172.8873

R810301N

Y1079.5
X1172.3793
Y1065.2125
X1145.3707
Y1079.5
X1144.8627
Y1065.2125
X1117.854
Y1079.5
X1117.346
Y1065.2125
G0 Z40.386
G80
G17 G91 G28 Z0 M95
M92
(ROUTE TOOL #17: 1/8 DOWN SHEAR)
(DIAMETER: 3.175)
G0 G54 G90 X1117.346 Y1065.2125
T17
G0 G54 G90 X975.36 Y2418.6515 M13 S18000
G43 H17 Z40.386
G0 Z21.336
G1 G41 D7 X978.535 Z18.161 F1200.
X981.71 F382.
Z0. F1200.
X991.7158 F382.
G3 X991.9868 Y2419.3169 R0.9525
X991.9017 Y2419.7107 R0.9525

R810301N

G1 X989.4031 Y2425.2148
G2 X989.2157 Y2426.081 R2.0955
X991.3112 Y2428.1765 R2.0955
G1 X1002.5888
G2 X1004.6843 Y2426.081 R2.0955
X1004.4969 Y2425.2148 R2.0955
G1 X1001.9983 Y2419.7107
G3 X1001.9132 Y2419.3169 R0.9525
X1002.1842 Y2418.6515 R0.9525
G1 X1019.2325
G3 X1019.5035 Y2419.3169 R0.9525
X1019.4183 Y2419.7107 R0.9525
G1 X1016.9198 Y2425.2148
G2 X1016.7324 Y2426.081 R2.0955
X1018.8278 Y2428.1765 R2.0955
G1 X1030.1055
G2 X1032.201 Y2426.081 R2.0955
X1032.0136 Y2425.2148 R2.0955
G1 X1029.515 Y2419.7107
G3 X1029.4298 Y2419.3169 R0.9525
X1029.7009 Y2418.6515 R0.9525
G1 X1046.7491
G3 X1047.0202 Y2419.3169 R0.9525
X1046.935 Y2419.7107 R0.9525
G1 X1044.4364 Y2425.2148
G2 X1044.249 Y2426.081 R2.0955
X1046.3445 Y2428.1765 R2.0955
G1 X1057.6222

R810301N

G2 X1059.7176 Y2426.081 R2.0955
X1059.5302 Y2425.2148 R2.0955
G1 X1057.0317 Y2419.7107
G3 X1056.9465 Y2419.3169 R0.9525
X1057.2175 Y2418.6515 R0.9525
G1 X1074.2658
G3 X1074.5368 Y2419.3169 R0.9525
X1074.4517 Y2419.7107 R0.9525
G1 X1071.9531 Y2425.2148
G2 X1071.7657 Y2426.081 R2.0955
X1073.8612 Y2428.1765 R2.0955
G1 X1085.1388
G2 X1087.2343 Y2426.081 R2.0955
X1087.0469 Y2425.2148 R2.0955
G1 X1084.5483 Y2419.7107
G3 X1084.4632 Y2419.3169 R0.9525
X1084.7342 Y2418.6515 R0.9525
G1 X1094.74
Z18.161 F1200.
X1097.915 F382.
G40 X1101.09 Z21.336
G0 Z40.386
X1101.09 Y1886.6485 Z40.386
Z21.336
G1 G41 D7 X1097.915 Z18.161 F1200.
X1094.74 F382.
Z0. F1200.
X1084.7342 F382.

R810301N

G3 X1084.4632 Y1885.983 R0.9525
X1084.5483 Y1885.5893 R0.9525
G1 X1087.0469 Y1880.0852
G2 X1087.2343 Y1879.219 R2.0955
X1085.1388 Y1877.1235 R2.0955
G1 X1073.8612
G2 X1071.7657 Y1879.219 R2.0955
X1071.9531 Y1880.0852 R2.0955
G1 X1074.4517 Y1885.5893
G3 X1074.5368 Y1885.983 R0.9525
X1074.2658 Y1886.6485 R0.9525
G1 X1057.2175
G3 X1056.9465 Y1885.983 R0.9525
X1057.0317 Y1885.5893 R0.9525
G1 X1059.5302 Y1880.0851
G2 X1059.7176 Y1879.219 R2.0955
X1057.6222 Y1877.1235 R2.0955
G1 X1046.3445
G2 X1044.249 Y1879.219 R2.0955
X1044.4364 Y1880.0851 R2.0955
G1 X1046.935 Y1885.5893
G3 X1047.0202 Y1885.983 R0.9525
X1046.7491 Y1886.6485 R0.9525
G1 X1029.7009
G3 X1029.4298 Y1885.983 R0.9525
X1029.515 Y1885.5893 R0.9525
G1 X1032.0136 Y1880.0851
G2 X1032.201 Y1879.219 R2.0955

R810301N

X1030.1055 Y1877.1235 R2.0955
G1 X1018.8278
G2 X1016.7324 Y1879.219 R2.0955
X1016.9198 Y1880.0851 R2.0955
G1 X1019.4183 Y1885.5893
G3 X1019.5035 Y1885.983 R0.9525
X1019.2325 Y1886.6485 R0.9525
G1 X1002.1842
G3 X1001.9132 Y1885.983 R0.9525
X1001.9983 Y1885.5893 R0.9525
G1 X1004.4969 Y1880.0852
G2 X1004.6843 Y1879.219 R2.0955
X1002.5888 Y1877.1235 R2.0955
G1 X991.3112
G2 X989.2157 Y1879.219 R2.0955
X989.4031 Y1880.0852 R2.0955
G1 X991.9017 Y1885.5893
G3 X991.9868 Y1885.983 R0.9525
X991.7158 Y1886.6485 R0.9525
G1 X981.71
Z18.161 F1200.
X978.535 F382.
G40 X975.36 Z21.336
G0 Z40.386
X1096.01 Y1047.0515 Z40.386
Z21.336
G1 G41 D7 X1099.185 Z18.161 F1200.
X1102.36 F382.

R810301N

Z0. F1200.

X1112.3658 F382.

G3 X1112.6368 Y1047.717 R0.9525

X1112.5517 Y1048.1107 R0.9525

G1 X1110.0531 Y1053.6148

G2 X1109.8657 Y1054.481 R2.0955

X1111.9612 Y1056.5765 R2.0955

G1 X1123.2388

G2 X1125.3343 Y1054.481 R2.0955

X1125.1469 Y1053.6148 R2.0955

G1 X1122.6483 Y1048.1107

G3 X1122.5632 Y1047.717 R0.9525

X1122.8342 Y1047.0515 R0.9525

G1 X1139.8825

G3 X1140.1535 Y1047.717 R0.9525

X1140.0683 Y1048.1107 R0.9525

G1 X1137.5698 Y1053.6148

G2 X1137.3824 Y1054.481 R2.0955

X1139.4778 Y1056.5765 R2.0955

G1 X1150.7555

G2 X1152.851 Y1054.481 R2.0955

X1152.6636 Y1053.6148 R2.0955

G1 X1150.165 Y1048.1107

G3 X1150.0798 Y1047.717 R0.9525

X1150.3509 Y1047.0515 R0.9525

G1 X1167.3991

G3 X1167.6702 Y1047.717 R0.9525

X1167.585 Y1048.1107 R0.9525

R810301N

G1 X1165.0864 Y1053.6148
G2 X1164.899 Y1054.481 R2.0955
X1166.9945 Y1056.5765 R2.0955
G1 X1178.2722
G2 X1180.3676 Y1054.481 R2.0955
X1180.1802 Y1053.6148 R2.0955
G1 X1177.6817 Y1048.1107
G3 X1177.5965 Y1047.717 R0.9525
X1177.8675 Y1047.0515 R0.9525
G1 X1194.9158
G3 X1195.1868 Y1047.717 R0.9525
X1195.1017 Y1048.1107 R0.9525
G1 X1192.6031 Y1053.6148
G2 X1192.4157 Y1054.481 R2.0955
X1194.5112 Y1056.5765 R2.0955
G1 X1205.7888
G2 X1207.8843 Y1054.481 R2.0955
X1207.6969 Y1053.6148 R2.0955
G1 X1205.1983 Y1048.1107
G3 X1205.1132 Y1047.717 R0.9525
X1205.3842 Y1047.0515 R0.9525
G1 X1215.39
Z18.161 F1200.
X1218.565 F382.
G40 X1221.74 Z21.336
G0 Z40.386
X1221.74 Y515.0485 Z40.386
Z21.336

R810301N

G1 G41 D7 X1218.565 Z18.161 F1200.
X1215.39 F382.
Z0. F1200.
X1205.3842 F382.
G3 X1205.1132 Y514.383 R0.9525
X1205.1983 Y513.9893 R0.9525
G1 X1207.6969 Y508.4852
G2 X1207.8843 Y507.619 R2.0955
X1205.7888 Y505.5235 R2.0955
G1 X1194.5112
G2 X1192.4157 Y507.619 R2.0955
X1192.6031 Y508.4852 R2.0955
G1 X1195.1017 Y513.9893
G3 X1195.1868 Y514.383 R0.9525
X1194.9158 Y515.0485 R0.9525
G1 X1177.8675
G3 X1177.5965 Y514.383 R0.9525
X1177.6817 Y513.9893 R0.9525
G1 X1180.1802 Y508.4852
G2 X1180.3676 Y507.619 R2.0955
X1178.2722 Y505.5235 R2.0955
G1 X1166.9945
G2 X1164.899 Y507.619 R2.0955
X1165.0864 Y508.4852 R2.0955
G1 X1167.585 Y513.9893
G3 X1167.6702 Y514.383 R0.9525
X1167.3991 Y515.0485 R0.9525
G1 X1150.3509

R810301N

G3 X1150.0798 Y514.383 R0.9525
X1150.165 Y513.9893 R0.9525
G1 X1152.6636 Y508.4852
G2 X1152.851 Y507.619 R2.0955
X1150.7555 Y505.5235 R2.0955
G1 X1139.4778
G2 X1137.3824 Y507.619 R2.0955
X1137.5698 Y508.4852 R2.0955
G1 X1140.0683 Y513.9893
G3 X1140.1535 Y514.383 R0.9525
X1139.8825 Y515.0485 R0.9525
G1 X1122.8342
G3 X1122.5632 Y514.383 R0.9525
X1122.6483 Y513.9893 R0.9525
G1 X1125.1469 Y508.4852
G2 X1125.3343 Y507.619 R2.0955
X1123.2388 Y505.5235 R2.0955
G1 X1111.9612
G2 X1109.8657 Y507.619 R2.0955
X1110.0531 Y508.4852 R2.0955
G1 X1112.5517 Y513.9893
G3 X1112.6368 Y514.383 R0.9525
X1112.3658 Y515.0485 R0.9525
G1 X1102.36
Z18.161 F1200.
X1099.185 F382.
G40 X1096.01 Z21.336
G0 Z40.386

R810301N

G80

G17 G91 G28 Z0 M95

M92

(ROUTE TOOL #13: 3/8 COMPRESSION)

(DIAMETER: 9.525)

G0 G54 G90 X1096.01 Y515.0485

T13

G0 G54 G90 X1100.1375 Y819.442 M13 S18000

G43 H13 Z40.386

G0 Z21.336

G1 G42 D3 Y781.05 Z8.563 F14000.

Y496.8875

X1217.6125

Y1065.2125

X1100.1375

Y781.05

Y771.525

G40 Y733.133 Z21.336

G0 Z40.386

X1100.1375 Y819.442 Z40.386

Z14.913

G1 G42 D3 Y781.05 Z2.14

Y496.8875

X1217.6125

Y1065.2125

X1100.1375

Y781.05

Y771.525

R810301N

G40 Y733.133 Z14.913
G0 Z40.386
X1100.1375 Y1448.092 Z40.386
Z21.336
G1 G42 D3 Y1409.7 Z8.563
Y1068.3875
X1217.6125
Y1751.0125
X1100.1375
Y1409.7
Y1400.175
G40 Y1361.783 Z21.336
G0 Z40.386
X1100.1375 Y1448.092 Z40.386
Z14.913
G1 G42 D3 Y1409.7 Z2.14
Y1068.3875
X1217.6125
Y1751.0125
X1100.1375
Y1409.7
Y1400.175
G40 Y1361.783 Z14.913
G0 Z40.386
X1100.1375 Y2133.892 Z40.386
Z21.336
G1 G42 D3 Y2095.5 Z8.563
Y1754.1875

R810301N

X1217.6125
Y1779.5875
X1204.9125
Y1805.0383
X1217.6125
Y2385.9617
X1204.9125
Y2411.4125
X1217.6125
Y2436.8125
X1100.1375
Y2095.5
Y2085.975
G40 Y2047.583 Z21.336
G0 Z40.386
X1100.1375 Y2133.892 Z40.386
Z14.913
G1 G42 D3 Y2095.5 Z2.14
Y1754.1875
X1217.6125
Y1779.5875
X1204.9125
Y1805.0383
X1217.6125
Y2385.9617
X1204.9125
Y2411.4125
X1217.6125

R810301N

Y2436.8125
X1100.1375
Y2095.5
Y2085.975
G40 Y2047.583 Z14.913
G0 Z40.386
X979.4875 Y2191.042 Z40.386
Z21.336
G1 G42 D3 Y2152.65 Z8.563
Y1868.4875
X1096.9625
Y2436.8125
X979.4875
Y2152.65
Y2143.125
G40 Y2104.733 Z21.336
G0 Z40.386
X979.4875 Y2191.042 Z40.386
Z14.913
G1 G42 D3 Y2152.65 Z2.14
Y1868.4875
X1096.9625
Y2436.8125
X979.4875
Y2152.65
Y2143.125
G40 Y2104.733 Z14.913
G0 Z40.386

R810301N

Z40.386

X1100.1375 Y829.7607 Z40.386

Z21.336

G1 G42 D3 Y786.2887 Z-0.4

Y496.8875

X1217.6125

Y1065.2125

X1153.16

Y1068.3875

X1217.6125

Y1751.0125

X1153.16

Y1754.1875

X1217.6125

Y1779.5875

X1204.9125

Y1805.0383

X1217.6125

Y2385.9617

X1204.9125

Y2411.4125

X1217.6125

Y2436.8125

X1100.1375

Y2146.935

X1096.9625

Y2436.8125

X979.4875

R810301N

Y1868.4875
X1096.9625
Y2158.365
X1100.1375
Y1754.1875
X1164.59
Y1751.0125
X1100.1375
Y1068.3875
X1164.59
Y1065.2125
X1100.1375
Y775.8112
G40 Y732.3392 Z21.336
G0 Z40.386
G80
M22
G91 G28 Z0 M15
G90 H0 M25
M88 B0
M89 B0
G91 G28
G90 X24. Y96.
M07
G08 P0
M30
%