

N1 (PARAMETRIC SURFACING SINGLE PASS)

N2 (SURFACES ANY SIZE BLOCK WITH ONE SINGLE PASS)

N3

N4 REAL #qLENGTH #qDEPTH #qHEIGHT #qINSERTHOLE #qINSERTCAP #qFINIAL #qNUMBERX #qNUMBERY #qTOOL
#qCOUNTERX #qCOUNTRY

N5

N6 #qLENGTH=6 (ENTER LENGTH OF BLOCK IN X)

N7 #qDEPTH=6 (ENTER DEPTH OF BLOCK IN Y)

N8 #qHEIGHT=.3125 (ENTER HEIGHT OF BLOCK IN Z)

N9 #qINSERTHOLE=0.40625 (ENTER DIAMETER OF HOLE FOR INSERT)

N10 #qINSERTCAP=0.79400 (ENTER DIAMETER OF HOLE FOR INSERT CAP)

N11 #qFINIAL=4.125 (ENTER DIAMETER OF FINIAL)

N12 #qNUMBERX=6 (ENTER THE NUMBER OF FINIALS TO RUN ON "X")

N13 #qNUMBERY=3 (ENTER THE NUMBER OF FINIALS TO RUN ON "Y")

N14

N15 #qTOOL=1 (TOOL: 0.313 inches dia. slot drill)

N16

N17 (TO CHANGE SPINDLE SPEED SEE LINE N36 - PLUNGE RATE SEE N53,N65,N72 - FEED RATE SEE
N54,N59,N66,N73,N78)

N18 (DO NOT MODIFY ANYTHING BELOW THIS LINE)

N19

N20 #qCOUNTERX=0

N21 #qCOUNTRY=0

N22

N23 (STREAMLINE AUTOMATION)

N24 (Spindle Enabled)

N25

N26 (FILE SET TO RUN IN INCHES)

N27 (FILE:SINGLE_FINIAL_REPEAT_ON_X)

N28

N29 (MATERIAL)

N30

N31 (X-SIZE = #qLENGTH- Y-SIZE = #qDEPTH Z-SIZE = #qHEIGHT)

N32

N33 (#qTOOL)

N34

N35 G90 (Absolute Mode)

N36 S6000 (Spindle Speed)

N37 G20 (Set Units to Inches)

N38 M3 (Spindle On)

N39 M8 (Dust Collector On)

N40 G0 X0.0000 Y0.0000(Go To X/Y Home)

N41

N42 G92 X-[#qFINIAL+0.125] Y-[#qFINIAL+0.125]

N43

 WHILE #qCOUNTERX<#qNUMBERX DO

N45 #qCOUNTERX=#qCOUNTERX+1

N46

N47 (G92.2 G92.1)

N48

N49 G92 X-[#qCOUNTERX*#qFINIAL]+0.125

N50

N51 G0 Z1.5000 (Go To Z Home)

N52 G0 X-#qINSERTHOLE Y0.0000 Z1.5000

N53 G1 Z-0.1250 F100.0

N54 G2 X0.0000 Y#qINSERTHOLE I#qINSERTHOLE J0.0000 F150.0

N55 G2 X#qINSERTHOLE Y0.0000 I0.0000 J-#qINSERTHOLE

N56 G2 X0.0000 Y-#qINSERTHOLE I-#qINSERTHOLE J0.0000
N57 G2 X-#qINSERTHOLE Y0.0000 I0.0000 J#qINSERTHOLE
N58 G1 Z-0.2500 F100.0
N59 G2 X0.0000 Y#qINSERTHOLE I#qINSERTHOLE J0.0000 F150.0
N60 G2 X#qINSERTHOLE Y0.0000 I0.0000 J-#qINSERTHOLE
N61 G2 X0.0000 Y-#qINSERTHOLE I-#qINSERTHOLE J0.0000
N62 G2 X-#qINSERTHOLE Y0.0000 I0.0000 J#qINSERTHOLE
N63 G0 Z1.5000
N64 G0 X-#qINSERTCAP Y0.0000
N65 G1 Z-0.0900 F100.0
N66 G2 X0.0000 Y#qINSERTCAP I#qINSERTCAP J0.0000 F150.0
N67 G2 X#qINSERTCAP Y0.0000 I0.0000 J-#qINSERTCAP
N68 G2 X0.0000 Y-#qINSERTCAP I-#qINSERTCAP J0.0000
N69 G2 X-#qINSERTCAP Y-0.0000 I0.0000 J#qINSERTCAP
N70 G0 Z1.5000
N71 G0 X-#qFINIAL
N72 G1 Z-0.1250 F100.0
N73 G3 X0.0000 Y-#qFINIAL I#qFINIAL J0.0000 F150.0
N74 G3 X#qFINIAL Y0.0000 I0.0000 J#qFINIAL
N75 G3 X0.0000 Y#qFINIAL I-#qFINIAL J0.0000
N76 G3 X-#qFINIAL Y0.0000 I0.0000 J-#qFINIAL
N77 G1 Z-0.2500 F100.0
N78 G3 X0.0000 Y-#qFINIAL I#qFINIAL J0.0000 F150.0
N79 G3 X#qFINIAL Y0.0000 I0.0000 J#qFINIAL
N80 G3 X0.0000 Y#qFINIAL I-#qFINIAL J0.0000
N81 G3 X-#qFINIAL Y0.0000 I0.0000 J-#qFINIAL
N82 G0 Z1.5000
N83

N84 G92 X0

ENDWHILE

N86

N87 G0 X0.0000 Y0.0000

N88 G53Z0 (Raise Head to Top)

N89 M9 (Dust Collector Off)

N90 M5 (Spindle Off)

N91 G0X0Y0 (Go Home)

N92 (End of File)