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X	0.0000
Z	0.0000
Y	0.0000
C	0.0000
A	0.0000
E	0.0000



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MIN/MIN	5	3500	10
	F	0.10000000	
	G40	10	40
	G54	00	97
05	G70	69.1	13.1

ES-02 SPARKING TEST OF SE — STANDARD METHOD

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168 G90 G97 F950 ;
169 G0 Z-0.0 Y0 M43 S3500 P12 ;
170 G0 X41.0 C0 R20 ;
171 (CYCLE HERE) ;
172 G1111 G0.5 H2. 11. J20.5 L-6.
    C1. F125. P0.5 Z11. A0.5 S125.
    B0.5 E125. U1.5 V110. K0.451 ;
173 M90 P500 (CROSS DRILL 1.5) ;
174 G0 X100.0 ;
175 G20 G0. V0. M45 ;
176 R29 ;
177 R1 ;

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Figure 1

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M Planty



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Troubleshooting tips Learn to identify and resolve common programming errors ensuring efficient and accurate machining
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debugging a mill program including contour milling is covered together with the intricacies of lathe programming and there
are detailed discussions of APT and COMPACT II The book contains many sample programs references to specific machines
and end of chapter review questions

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