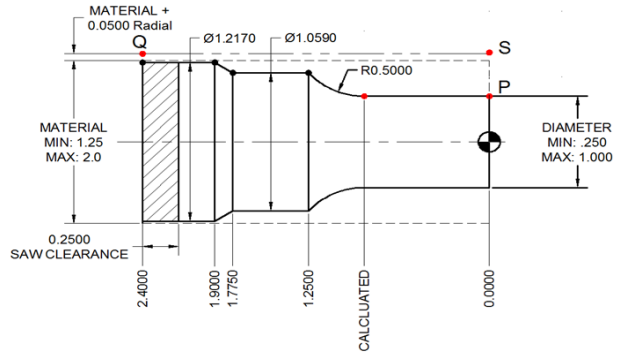


0.6250 Enter Punch Diameter (Min: .25, Max: 1.0)
1.2500 Enter Material Diameter (Min: 1.25)

Process Details

0.15 Depth of cut for each pass (Radius value)
0.012 Roughing Feed rate
0.004 Finishing Feed Rate
450 Roughing Cutting Speed (SFM)
500 Finishing Cutting Speed (SFM)
0.01 Diameter Finish Allowance (Diameter value)
0.005 Length Finish Allowance



CODE - Automatically Generated DO NOT EDIT

```
O0001 (219 PUNCH - DIAMETER: 1.25)
T101 (CNMG 432) (Tool change & apply offsets)
G00 G54 X1.3500 Z0.000 M08 (RAPID TO POINT S)
G50 S2000 (Set Max RPM 2000)
G97 S600 M03 (Spindle On 600 rpm)
G96 S450 (Constant surface speed On)
G71 P1 Q7 D0.15 U0.01 W0.005 F0.012 (Define rough cycle)
N1 G00 X1.3500 Z0.0000 (POINT P)
N2 G01 X0.6250 Z0.0000 F0.0040
N3 G02 X1.0590 Z1.2500 R0.5
N4 G01 X1.0590 Z1.7750
N5 G01 X1.2170 Z1.9000
N6 G01 X1.2170 Z2.4000
N7 G01 X1.3500 Z2.4000 (POINT Q)
Check: G00 X0 Z0 T100 (Rapid to tool change position)
T202 (Finish tool)
G50 S2500
G97 S500 M03
G00 X1.3500 Z0.0000 M08
G96 S1500
G70 P1 Q7 (FINISH CYCLE)
Check: G00 X0 Z0 T200
M30
%
```

Assumptions

Material is O1 Tool Steel - Annealed
 Carbide Insert: C6/P20, M20 - CNMG432
 Roughing Tool is T101
 Finishing Tool is T202
 G18 Z-X plane must be active
 Z zero is safe to rapid to