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programming. 12 n030  
g81x2.000y0.875r0.10  
0z-1.000f5m03.  
explanation (some  
steps are left out) g81

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fixed cycle x2.000,  
y0.875 the m/c table  
will rapid to hole #1  
position r0.100 the m/c  
spindle will rapid down  
so that the drill point is  
0.100 inch above the  
surface of the

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NC Part Programming  
This manual describes  
the use of NC  
(Numerical Control)

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Part Programming, which includes the BNC (Basic Numerical Control) and the ISNC (Industry Standard Numerical Control) Editor portion of the CNC software as it is used on the machine tool console.

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