```
%
O05000 (BROACH)
(C/T = 7:00 PER SLOT / 84 MIN TOTAL)

T6 M06 (BRT-318 / BI-315 - BROACH TOOL)
(*** SET TOOL TO CUT @ 12:00 ***)
(*** MUST USE COLLET HOLDER / NOT EM HOLDER ***)
(*** APPROACH IS @ Y-.025 FOR CLEARANCE ***)
G90 G58 G00 X0 Y3.409 M05
G43 H06 Z0.1 (M8)

( 12:00 )
G90 M19 P0.
M97 P1000

( 1:00 )
G90 M19 P30.
G90 X0 Y0 G68 R-30.
M97 P1000

( 2:00 )
G90 M19 P60.
G90 X0 Y0 G68 R-60.
M97 P1000

( 3:00 )
G90 M19 P90.
G90 X0 Y0 G68 R-90.
M97 P1000

( 4:00 )
G90 M19 P120.
G90 X0 Y0 G68 R-120.
M97 P1000

( 5:00 )
G90 M19 P150.
G90 X0 Y0 G68 R-150.
M97 P1000

( 6:00 )
G90 M19 P180.
G90 X0 Y0 G68 R-180.
M97 P1000

( 7:00 )
G90 M19 P210.
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G90 X0 Y0 G68 R-210.
M97 P1000

( 8:00 )
G90 M19 P240.
G90 X0 Y0 G68 R-240.
M97 P1000

( 9:00 )
G90 M19 P270.
G90 X0 Y0 G68 R-270.
M97 P1000

( 10:00 )
G90 M19 P300.
G90 X0 Y0 G68 R-300.
M97 P1000

( 11:00 )
G90 M19 P330.
G90 X0 Y0 G68 R-330.
M97 P1000

G90 G00 Z1. M09
G91 G28 Z0
M30


N1000 ( R/F SLOT )
(LEFT SIDE ROUGH)
G90 G00 X-0.1205 Y3.409
Z-0.5
M97 P100 L205
(RIGHT SIDE ROUGH)
G90 G00 X0.1205 Y3.409
Z-0.5
M97 P100 L205

(RIGHT SIDE FINISH)
G90 G00 X0.1205 Y3.409
Z-0.5
M97 P200

(LEFT SIDE FINISH)
G90 G00 X-0.1205 Y3.409
Z-0.5
M97 P200
M99
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N100 ( ROUGH BROACH - LOCAL SUB )
G91 G00 Y0.026
G01 Z-2.3 F450.
Y-0.025
G00 Z2.3
M99

N200 ( FINISH BROACH - LOCAL SUB )
G91 G00 Y0.231
G01 Z-2.3 F150.
Y-0.231
G00 Z2.3
M99
%
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