%

**O**06061 (Tic Tac Pin)

**G28 U0.0**

**G28 W0.0**

**T202**

G50 S1000

**G54**

G00 Z1.75

X0.

**M00**

Z1.85

**G28 U0.**

G00 Z1.85

G97 S300 M03

G00 X1.0

G96 S1000 **M08**

G01 X1.0 F0.008 (PASS 1)

Z0.34

G00 X1.1

Z1.85

G01 X0.960 (PASS 2)

Z0.34

G00 X1.0

Z1.85

G01 X0.95 (PASS 3-1ST DIA)

Z0.34

G00 X1.1

Z1.85

G01 X0.91 (PASS 4)

Z0.75

G00 X1.0

Z1.85

G01 X0.85 (PASS 5-FST CHMFR PT)

Z0.75

G00 X0.95

Z1.85

G01 X0.81 (PASS 6)

Z.75

G00 X0.85

Z1.85

G01 X0.77 (PASS 7)

Z0.75

G00 X0.87

Z1.85

G01 X0.74(PASS 8 2ND DIA)

Z0.75

X0.85

Z0.75

X0.95 Z.7 (1ST CHAMFER FINISH)

G00 X1.1 (START 2ND CHAMFER)

Z1.625

G01 X.74

X.70 Z1.85

G00 X.75

Z1.625

G01 X.74

X.66 Z1.85

G00 X.75

Z1.625

G01 X.74

X.62 Z1.85

G00 X.75

Z 1.625

G01 X.74

X.58 Z1.85

G00 X.75

Z 1.625

G01 X0.74

X.54 Z1.85

G00 X.75

Z1.625

G01 X.74

X.49 Z1.85

G00 X1.0

Z1.85 (CHAMFER FINISHED)

**M09**

M05

**G28 U0.**

**M01**

**T404**

**G54**

G00 X1.75

G97 S400 M03

**M08**

G00 X1.1 Z1.75

G01 X-0.1 F0.003

G00 X1.0

G00 Z0.345

G01 X-0.1

G00 X1.5

**G28 U0.**

**M09**

M05

M19

**M30**

%