

REMINGTON ARMS CO., INC.-PROGRAM MANUSCRIPT FOR L.&S. AVS 20-13 LATHE-Sht 41
 700 VACUUM BRIGEL ^{REACH TUBE} D-T-54796 Tape No. 444 Date 1-18-67 Programmer NEZESON Mat'l. 4440
 Part Name Drawing No.

N SEQ. NO.	G FREQ FUNG.	X DEPARTURE (DWELL)	Z DEPARTURE (COS(LEAD))	Y ARC OFF (SIN(LEAD))	K Z ARC OFF (COS(LEAD))	F FEED RATE	S SPINDLE SPEED	T TOOL SEL	M WISC FUNG	SPEED		FEED		ACCUMULATED		OPERATIONS - REMARKS	
										RPM	SFM	IPM	IPR	ED X FROM ZERO	ED Z FROM ZERO		
REWIND STOP CODE AT THIS POINT																	
N001	G01	X02	Z2293		K99999	F095			M07						96998	23747	FROM SPINDLE WISE
N002	G01														96998	23243	FROM PROGRAM ZERO
N003	G04	X02						T00	M06						"	- 0313	POSITION TO "HOME"
N004									M06						"	"	
12 INCHES OF LEADER																	
REWIND STOP CODE AT THIS POINT																	
N001	G04	X02						T11	M07						96998	- 0313	GEAR RANGE - HIGH
N002	G01	X-88998				F095					1196	425	K4.9	011	08000	"	"HOME" POSITION
N003	G04	X02					S21		M06	M03	M08				"	"	
N004	G01	X-0425				F005									06575	08337	TURN TO 1.252 DIA
N005			Z0865			F005									"	"	
N006		X01				F005									07575	- 0313	
N007			Z-0865			F02									"	"	
N008		X-01925				F005	S26				1434	425	19.4	011	05650	08337	TURN TO 1.1305 DIA
N009			Z0865			F0194									"	"	RETRACT
N010		X025				F005									08000	"	
N011	G04	X02								M07	M05	M09			"	"	HOME
N012	G01	X88998	Z-0865			F095									96998	- 0313	END OF PROGRAM
N013	G04	X02						T00	M06						"	"	REWIND
N014									M06						"	"	