

REMINGTON ARMS CO., INC. - PROGRAM MANUSCRIPT FOR L. & S. AVS 20-13 LATHE - Sht. 41
 Part Name 700 VARMINT BARREL Drawing No. D-754796 Tape No. HUB Date 1-18-67 Programmer NEZEZON Mat'l 4140

N SEQ. NO.	G PREP FUNC.	X DEPARTURE (DWELL)	Z DEPARTURE	X ARC OFF (SIN)(LEAD)	K ARC OFF (COS)(LEAD)	F FEED RATE	S SPIN. SPEED	T TOOL SEL	M MISC FUNC.	SPEED RPM	FEED SFM	FEED IPM	FEED IPR	ACCUMULAT ED X FROM ZERO	ACCUMULAT ED Z FROM ZERO	OPERATIONS - REMARKS
REWIND STOP CODE AT THIS POINT										INITIALIZE :						FROM SPINDLE NOSE
N001	G01	X02							M07					96998	23747	FROM PROGRAM ZERO
N002	G01		Z2293		K99999	F095								"	-0313	POSITION TO "HOME"
N003	G01	X02							M06					"	"	
N004									M08					"	"	
12 INCHES OF LEADER																GEAR RANGE - HIGH
REWIND STOP CODE AT THIS POINT																"HOME" POSITION
N001	G01	X02							M07					96998	-0313	
N002	G01	X-08998		I99999		F095				1196	425	14.7	011	0.8000	"	
N003	G01	X02						S21	M06	M03	M08			"	"	
N004	G01	X-01425		I99999		F005								0.6575	"	
N005			Z0865		K99999	F0147								"	0.8337	TURN TO 1.252 DIA
N006		X01		I99999		F005								0.7575	"	
N007			Z-0865		K99999	F02								"	-0313	
N008		X-01925		I99999		F005	S26			1434	425	19.4	011	0.5650	"	
N009			Z0865		K99999	F0194								"	0.8337	TURN TO 1.130 ± .005
N010		X0235		I99999		F005								0.8000	"	RETRACT
N011	G01	X02							M07	M05	M09			"	"	
N012	G01	X08998	Z-0865	I99999	K99999	F095								96998	-0313	HOME
N013	G01	X02							M06					"	"	
N014									M30					"	"	END OF PROGRAM REWIND