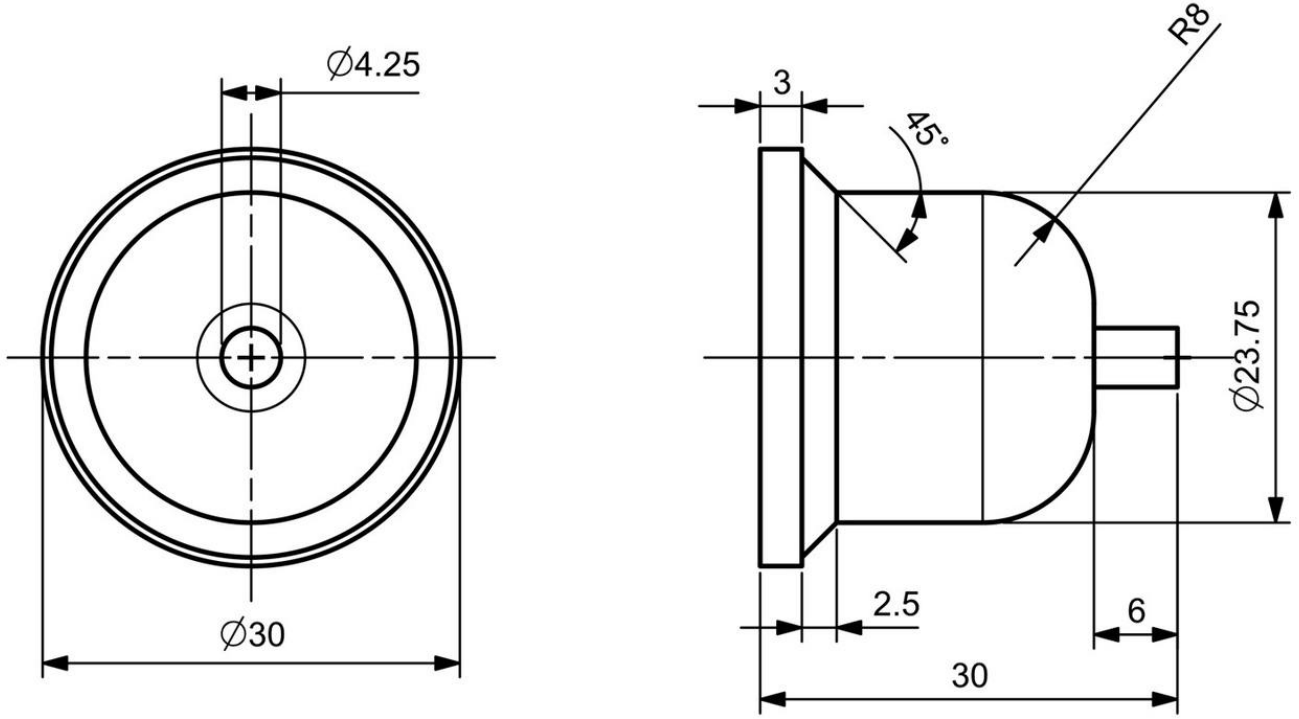
LENGTH OR DIA	UP TO 6	6 30	30 120	120 315	315 1000	1000 2000	2000 4000	4000 ABOVE
MACHININIG DEVIATION TO ISI:2102(MEDIUM GRADE) UNLESS SPECIFIED OTHERWISE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±3.0

LENGTH IN mm OF SHORTER SIDE OF ANGLE				MACHINING FINISH MICRONS			
UP TO 6	6-30	30-120	120-400	▽	▽▽	▽▽▽	▽▽▽▽
±60'	±30'	±20'	±10'	8-25	1.6-8	0.025-1.6	<0.025



NOTE
DO NOT SCALE THE DRAWING .
ALL DIMENSIONS ARE IN MILLIMETERS .
REMOVE SHARP EDGES AND BURRS

http://www.facebook.com/afsalabba.in
http://www.youtube.com/c/afsalabbaabba

	TITLE :	
DRAWN BY :	TKMCE	
CHECKED BY :	MATERIAL : ALUMINUM	DRG.NO :
APPROVED BY:	SCALE : 1:1	QTY : 1

A4

```
G75 X0 z0
T1 D1
G96 S200 LIMS=1500 M03
M08
G00 X36 Z2
CYCLE95(“AB:BC”,1,0.2,0.4,0,0.15,0.1,0.05,9,,,)
G00 X36 Z2
G75 X0 Z0
M05
M09
M30

AB:
G01 X0 Z0 F0.1
G01 X4.25 Z0
G01 X4.25 Z-6
G01 X7.75 Z-6
G03 X23.75 Z-14 CR=8
G01 X23.75 Z-24.5
G01 X28.75 Z-27
G01 X30 Z-27
G01 X30 Z-30
G01 X32 Z-30
BC:
```