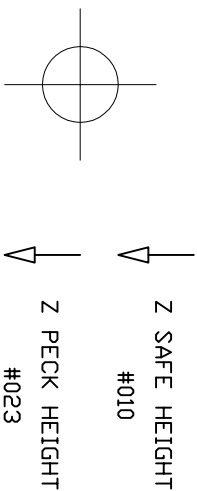


SINGLE HOLE X-Y COORDINATES

#011 = 0 0 = SINGLE HOLE 1 = MULTIPLE HOLES  
 #012 = 0 0 = X-Y COORDINATES 1 = ROTATED FROM X AXIS

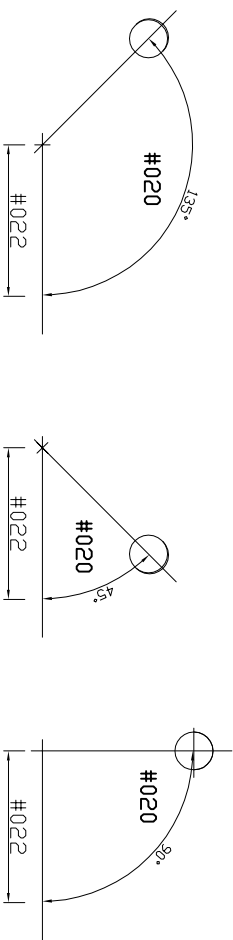
HOLE DATA

#001 TODL NUMBER  
 #002 TODL DIAMETER  
 #003 SPINDLE SPEED  
 #004 NON DRILLING FEEDRATE  
 #005 HOLE DRILLING FEEDRATE



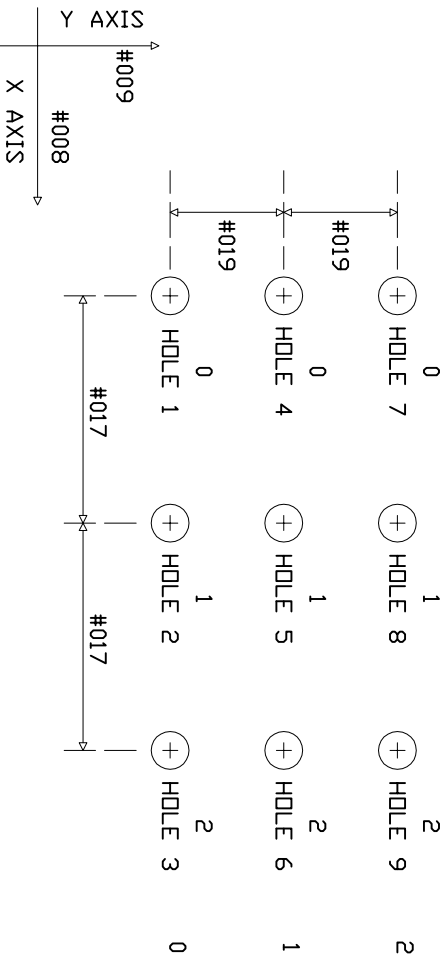
SINGLE HOLE POLAR COORDINATES

#011 = 0 0 = SINGLE HOLE 1 = MULTIPLE HOLES  
 #012 = 1 0 = X-Y COORDINATES 1 = ROTATED FROM X AXIS  
 #020 = ANGLE OF ROTATION



X-Y MATRIX OF HOLES

#011 = 1 0 = SINGLE HOLE 1 = MULTIPLE HOLES  
 #012 = 0 0 = X-Y COORDINATES 1 = ROTATED FROM X AXIS  
 #013 = 0 0 = MATRIX 1 = ROTARY ARRAY  
 #016 = 3 X AXIS ARRAY QUANTITY  
 #018 = 3 Y AXIS ARRAY QUANTITY



ROTARY ARRAY OF HOLES

#011 = 1 0 = SINGLE HOLE 1 = MULTIPLE HOLES  
 #012 = 1 0 = X-Y COORDINATES 1 = ROTATED FROM X AXIS  
 #013 = 1 0 = MATRIX 1 = ROTARY ARRAY  
 #015 = 4 NUMBER OF HOLES TO CUT

