

This is a siemens programming example using the repeat command.

The tool used is a drill at the front and is ground down at the back to 45 Degrees to be able to back chamfer the hole that has just been drilled. The advantage of this method is that all the information is in the same program so we can view it easily and any changes only have to be made to the beginning of the section.

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N530 CS_TOOL1("401");LOAD 12.7MM DRILL CHAMFER 14 HOLES
N535 MSG("DRILL & CHAMFER JOINT FACE HOLES")
N540 G0 G90 G505 B=DC(0) M8 M3 S5000 T402 M21 M7
N542
N544 X-21.8642 Y128.1258 ; HOLE 1
N546
N544 MSG("DRILL AND CHAMFER ROUTINE")
N550
N552 START: G0 G90 Z10.0
N555 G0 Z2.0
N560 G1 Z-31.0 F1500
N562 G0 Z-21.0
N565 G1 G91 Y1.25 F800
N570 G3 J-1.25
N575 G1 Y-1.25
N580 END: G0 G90 Z10.0
N585
N590 G0 G90 X-71.9589 Y109.0417 ; HOLE 2
N595 REPEAT START END
N610 G0 G90 X-109.7801 Y70.8296 ; HOLE 3
N620 REPEAT START END
N630 G0 G90 X-114.7821 Y-62.3413 ; HOLE 4
N640 REPEAT START END
N650 G0 G90 X-73.9394 Y-107.6778 ; HOLE 5
N660 REPEAT START END
N670 G0 G90 X-16.7978 Y-129.5185 ; HOLE 6
N680 REPEAT START END
N690 G0 G90 X43.9791 Y-123.0166 ; HOLE 7
N700 REPEAT START END
N710 G0 G90 X95.0584 Y-89.5711 ; HOLE 8
N715 REPEAT START END
N730 G0 G90 X126.9673 Y-74.0559 ; HOLE 9
N740 REPEAT START END
N750 G0 G90 X151.6091 Y-48.8267 ; HOLE 10
N760 REPEAT START END
N770 G0 G90 X199.8977 Y-35.7892 ; HOLE 11
N780 REPEAT START END
N790 G0 G90 X188.5759 Y47.9489 ; HOLE 12
N800 REPEAT START END
N810 G0 G90 X123.5746 Y89.1108 ; HOLE 13
N820 REPEAT START END
N830 G0 G90 X77.625 Y105.0479 ; HOLE 14
N840 REPEAT START END
N845
N850 G0 G90 Z50.0
N860 SUPA M9 M20 Z550.0 D0
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Any questions please call me or e-mail david@forelink.co.uk