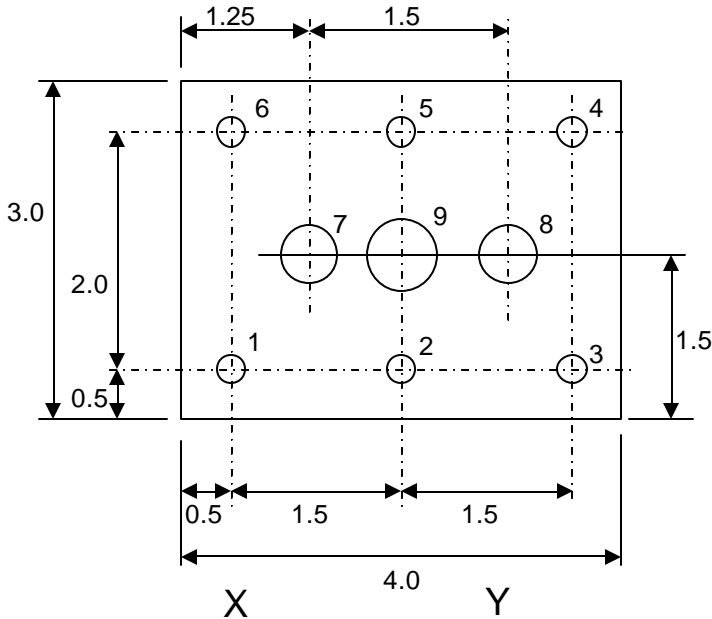


# Coordinate system for a CNC vertical mill (continued)

## Exercise 4

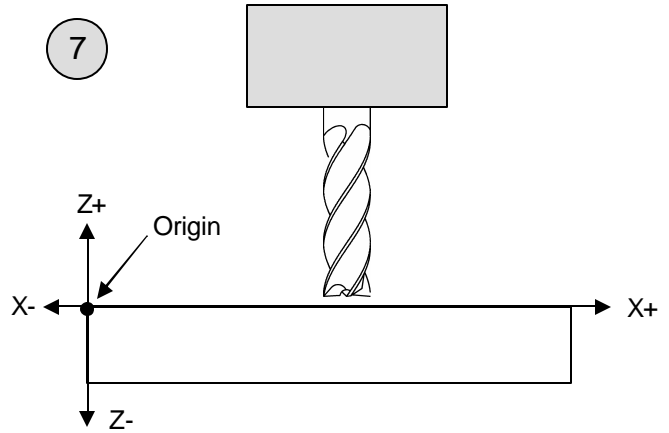
**Instructions:** Mark the location of the origin (which corner?) based upon the way this workpiece is drawn. Then fill in the coordinate sheet below. When you're finished type your coordinates into NCPlot and confirm that they are correct (answers below). Answers are also in the file named exercisem4.nc



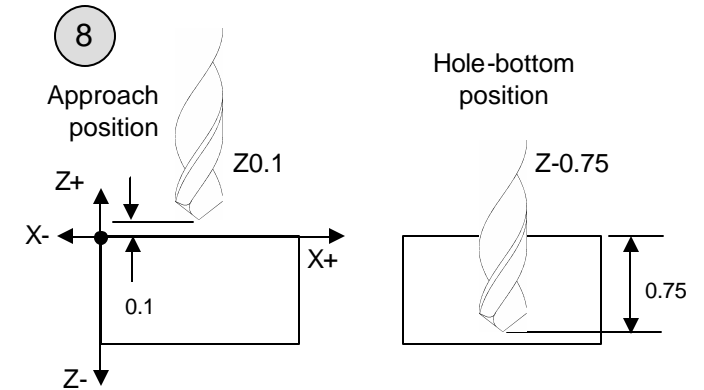
1		
2		
3		
4		
5		
6		
7		
8		
9		

**Answers:**

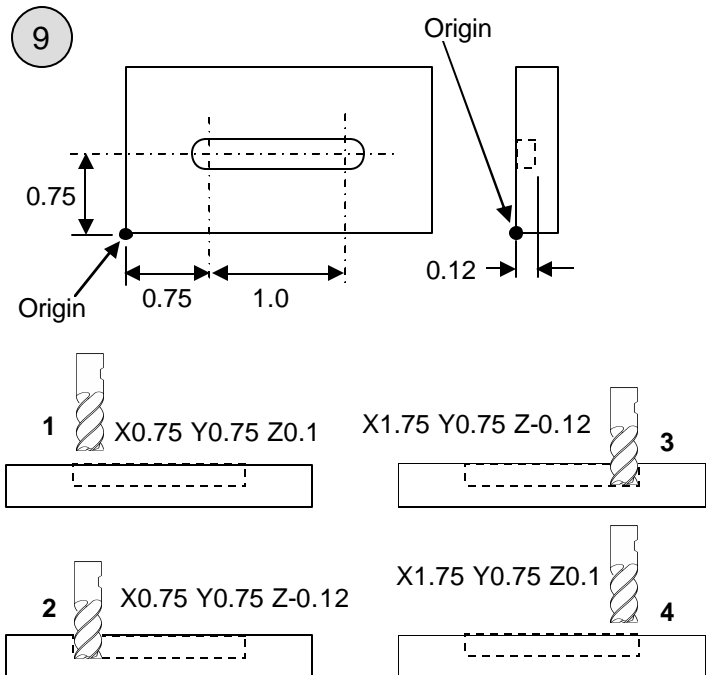
Program origin is at lower-left corner  
 1: X0.5 Y0.5  
 2: X2.0 Y0.5  
 3: X3.5 Y0.5  
 4: X3.5 Y2.5  
 5: X2.0 Y2.5  
 6: X0.5 Y2.5  
 7: X1.25 Y1.5  
 8: X2.0 Y1.5  
 9: X2.75 Y1.5



The Z axis origin is usually at the top surface.



Machining a hole will require at least two Z positions.



Positions for milling a slot.