

MCAL2000 - Transition Layout 11.7.4

Your Company Name Here

2011-01-14 06:49:25 Page 1

Session : Transition w20.000 x s10.000 x d10.000 x h10.000

Q: _____ WO: _____

Comment : Customer Name Here

2 Segments Required

Matching Segments : Dia Offsets X 0.000, Y 0.000

TRANSITION DATA

Length - Work Side: 20.000 : 20"
 Length - Seam Side: 10.000 : 10"
 Diameter: 10.000 : 10"
 Height: 10.000 : 10"
 Diameter X Offset: 0.000 : 0"
 Diameter Y Offset: 0.000 : 0"
 Cut Path Deg Increment ..: 1.0 Degrees
 Lead In Distance: 0.500 : 0 1/2"
 Break Allowance: 0.750 : 0 3/4"
 Segment Border: 0.250 : 0 1/4"

SEGMENT LAYOUT: 2 Segments

Segment Developed Angle ..: 72.323 Degrees
 Convergence Point.....: 14.642, 22.156 : 14 5/8", 22 3/16"
 Curve Length: 15.708 : 15 11/16"
 Cut Path Point Distance ..: 0.087 : 0 1/16"
 Maximum Break Length: 14.142 : 14 1/8"
 Number Of Break Lines ...: 38.0
 Break Line Incr Angle ...: 5.0 Degrees
 Break Line Incr Distance : 0.000 : 0"
 Cut Distance(each): 71.569 : 71 9/16"
 Cut Distance(total): 143.137 : 143 1/8"

PLATE DATA: 2 Segments

Material Thickness: 0.250 : 0 1/4"
 Material Unit Weight: 10.200 lbs/Sq.Ft.
 Blank Size: 29.861 x 12.919 : 29 7/8" x 12 15/16"
 Blank Area(each): 2.679 Sq.Ft.
 Blank Area(total): 5.358 Sq.Ft.
 Blank Weight(each): 27.327 lbs.
 Blank Weight(total): 54.654 lbs.

QUOTE: 2 Segments

Material Unit Cost	1.00		
x Factor :	1.00 =	54.65	
Shop Hours	1.00		
x Rate/Hour :	1.00 =	1.00	
	Total =	55.65	

FILES

CNC.: C:\MicroCAL\TR2K\TR2K.txt
 DXF.: C:\MicroCAL\TR2K\TR2K.dxf
 DTA.: Not Saved

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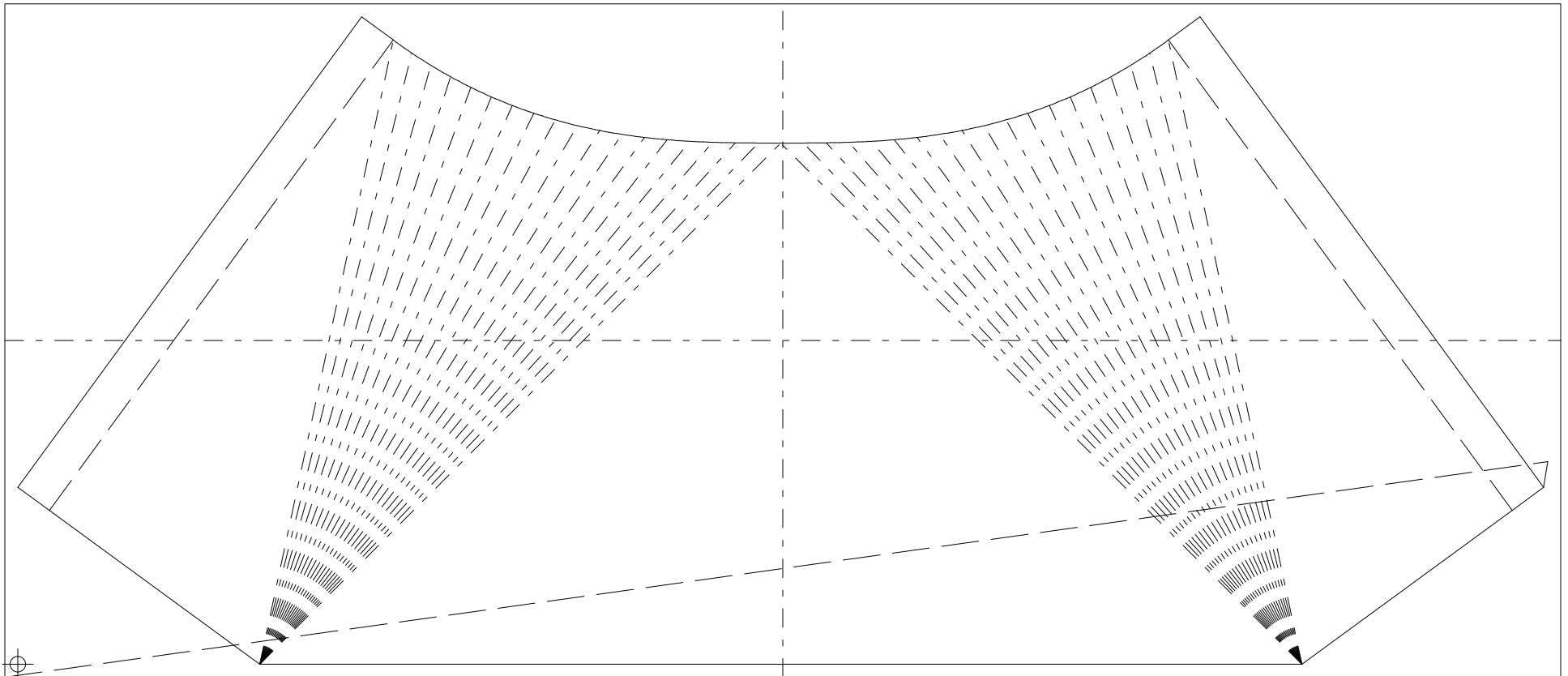
Q: _____ WO: _____

Comment : Customer Name Here

2 Segments Required

Material: PL 0 1/4" x 29 7/8" x 12 15/16", 2.679 Sq.Ft., 27.33 lbs.

Matching Segments : Dia Offsets X 0.000, Y 0.000



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Session : Transition w20.000 x s10.000 x d10.000 x h10.000

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2 Segments Required

Matching Segments : Dia Offsets X 0.000, Y 0.000

SEGMENT LAYOUT: 2 Segments

```

Blank Size .....: 29.861 x 12.919
Segment Border .....: 0.250
Segment Developed Angle ..: 72.323 Degrees
Convergence Point.....: 14.642, 22.156
Curve Length .....: 15.708
Cut Path Deg Increment ..: 1.0 Degrees
Cut Path Point Distance ..: 0.087
Maximum Break Length ....: 14.142
Number Of Break Lines ...: 38.0
Break Line Incr Angle ...: 5.0 Degrees
Break Line Incr Distance : 0.000
Cut Distance .....(each): 71.569
Cut Distance .....(total): 143.137

```

POINT LAYOUT

Duplicate Points Indicate Zero Break Allowance and/or Zero CNC Lead-In

Point Number Reference	Point X	Point Y	Distance
	0.000	0.000	0.000 Quadrant Zero

Point... 0	:	-0.250	-0.250	0.354 CNC Start
Point... 1	:	29.361	3.887	29.899 CNC Rapid

[Manual Layout Start Point and 1st Break Allowance]

Point... 2	:	29.285	3.393	0.500 Start
Point... 3	:	28.679	2.950	0.750 Line
Point... 4	:	24.642	0.000	5.000 Line
Point... 5	:	4.642	0.000	20.000 Line
Point... 6	:	0.606	2.950	5.000 Line
Point... 7	:	0.000	3.393	0.750 Line
Point... 8	:	6.597	12.419	11.180 Line

[Left Side Portion Of Curve]

Point...L 90	:	7.203	11.977	0.750 Line
Point...L 89	:	7.273	11.926	0.087 Line
Point...L 88	:	7.344	11.875	0.087 Line
Point...L 87	:	7.416	11.825	0.087 Line
Point...L 86	:	7.488	11.775	0.087 Line
Point...L 85	:	7.560	11.726	0.087 Line
Point...L 84	:	7.633	11.678	0.087 Line
Point...L 83	:	7.706	11.630	0.087 Line
Point...L 82	:	7.779	11.583	0.087 Line
Point...L 81	:	7.853	11.537	0.087 Line
Point...L 80	:	7.927	11.491	0.087 Line
Point...L 79	:	8.002	11.446	0.087 Line
Point...L 78	:	8.077	11.401	0.087 Line
Point...L 77	:	8.152	11.358	0.087 Line
Point...L 76	:	8.228	11.314	0.087 Line
Point...L 75	:	8.304	11.272	0.087 Line
Point...L 74	:	8.381	11.230	0.087 Line
Point...L 73	:	8.458	11.189	0.087 Line
Point...L 72	:	8.535	11.148	0.087 Line
Point...L 71	:	8.613	11.109	0.087 Line
Point...L 70	:	8.691	11.070	0.087 Line
Point...L 69	:	8.769	11.031	0.087 Line

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Session : Transition w20.000 x s10.000 x d10.000 x h10.000

Q: _____ WO: _____

Comment : Customer Name Here

2 Segments Required

Matching Segments : Dia Offsets X 0.000, Y 0.000

Point Number	Point X	Point Y	Distance
Point...L 68 :	8.848	10.994	0.087 Line
Point...L 67 :	8.927	10.957	0.087 Line
Point...L 66 :	9.007	10.921	0.087 Line
Point...L 65 :	9.086	10.885	0.087 Line
Point...L 64 :	9.167	10.850	0.087 Line
Point...L 63 :	9.247	10.817	0.087 Line
Point...L 62 :	9.328	10.783	0.087 Line
Point...L 61 :	9.409	10.751	0.087 Line
Point...L 60 :	9.490	10.719	0.087 Line
Point...L 59 :	9.571	10.688	0.087 Line
Point...L 58 :	9.653	10.658	0.087 Line
Point...L 57 :	9.735	10.628	0.087 Line
Point...L 56 :	9.818	10.600	0.087 Line
Point...L 55 :	9.901	10.572	0.087 Line
Point...L 54 :	9.983	10.544	0.087 Line
Point...L 53 :	10.067	10.518	0.087 Line
Point...L 52 :	10.150	10.492	0.087 Line
Point...L 51 :	10.234	10.467	0.087 Line
Point...L 50 :	10.317	10.443	0.087 Line
Point...L 49 :	10.401	10.419	0.087 Line
Point...L 48 :	10.486	10.396	0.087 Line
Point...L 47 :	10.570	10.374	0.087 Line
Point...L 46 :	10.655	10.353	0.087 Line
Point...L 45 :	10.739	10.332	0.087 Line
Point...L 44 :	10.824	10.313	0.087 Line
Point...L 43 :	10.910	10.293	0.087 Line
Point...L 42 :	10.995	10.275	0.087 Line
Point...L 41 :	11.080	10.257	0.087 Line
Point...L 40 :	11.166	10.240	0.087 Line
Point...L 39 :	11.252	10.224	0.087 Line
Point...L 38 :	11.338	10.208	0.087 Line
Point...L 37 :	11.423	10.193	0.087 Line
Point...L 36 :	11.510	10.179	0.087 Line
Point...L 35 :	11.596	10.165	0.087 Line
Point...L 34 :	11.682	10.152	0.087 Line
Point...L 33 :	11.768	10.140	0.087 Line
Point...L 32 :	11.855	10.128	0.087 Line
Point...L 31 :	11.941	10.117	0.087 Line
Point...L 30 :	12.028	10.107	0.087 Line
Point...L 29 :	12.115	10.097	0.087 Line
Point...L 28 :	12.202	10.088	0.087 Line
Point...L 27 :	12.288	10.079	0.087 Line
Point...L 26 :	12.375	10.071	0.087 Line
Point...L 25 :	12.462	10.063	0.087 Line
Point...L 24 :	12.549	10.056	0.087 Line
Point...L 23 :	12.636	10.050	0.087 Line
Point...L 22 :	12.723	10.044	0.087 Line
Point...L 21 :	12.810	10.038	0.087 Line
Point...L 20 :	12.898	10.033	0.087 Line
Point...L 19 :	12.985	10.029	0.087 Line
Point...L 18 :	13.072	10.024	0.087 Line
Point...L 17 :	13.159	10.021	0.087 Line
Point...L 16 :	13.246	10.017	0.087 Line
Point...L 15 :	13.333	10.014	0.087 Line
Point...L 14 :	13.421	10.012	0.087 Line

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Your Company Name Here

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Session : Transition w20.000 x s10.000 x d10.000 x h10.000

Q: _____ WO: _____

Comment : Customer Name Here

2 Segments Required

Matching Segments : Dia Offsets X 0.000, Y 0.000

Point Number	Point X	Point Y	Distance
Point...L 13 :	13.508	10.009	0.087 Line
Point...L 12 :	13.595	10.007	0.087 Line
Point...L 11 :	13.682	10.006	0.087 Line
Point...L 10 :	13.770	10.004	0.087 Line
Point...L 9 :	13.857	10.003	0.087 Line
Point...L 8 :	13.944	10.002	0.087 Line
Point...L 7 :	14.031	10.001	0.087 Line
Point...L 6 :	14.119	10.001	0.087 Line
Point...L 5 :	14.206	10.001	0.087 Line
Point...L 4 :	14.293	10.000	0.087 Line
Point...L 3 :	14.381	10.000	0.087 Line
Point...L 2 :	14.468	10.000	0.087 Line
Point...L 1 :	14.555	10.000	0.087 Line

[Mid Point Of Curve]

Point..LR 0 :	14.642	10.000	0.087 Line
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[Right Side Portion Of Curve]

Point...R 1 :	14.730	10.000	0.087 Line
Point...R 2 :	14.817	10.000	0.087 Line
Point...R 3 :	14.904	10.000	0.087 Line
Point...R 4 :	14.991	10.000	0.087 Line
Point...R 5 :	15.079	10.001	0.087 Line
Point...R 6 :	15.166	10.001	0.087 Line
Point...R 7 :	15.253	10.001	0.087 Line
Point...R 8 :	15.340	10.002	0.087 Line
Point...R 9 :	15.428	10.003	0.087 Line
Point...R 10 :	15.515	10.004	0.087 Line
Point...R 11 :	15.602	10.006	0.087 Line
Point...R 12 :	15.689	10.007	0.087 Line
Point...R 13 :	15.777	10.009	0.087 Line
Point...R 14 :	15.864	10.012	0.087 Line
Point...R 15 :	15.951	10.014	0.087 Line
Point...R 16 :	16.038	10.017	0.087 Line
Point...R 17 :	16.126	10.021	0.087 Line
Point...R 18 :	16.213	10.024	0.087 Line
Point...R 19 :	16.300	10.029	0.087 Line
Point...R 20 :	16.387	10.033	0.087 Line
Point...R 21 :	16.474	10.038	0.087 Line
Point...R 22 :	16.561	10.044	0.087 Line
Point...R 23 :	16.648	10.050	0.087 Line
Point...R 24 :	16.735	10.056	0.087 Line
Point...R 25 :	16.822	10.063	0.087 Line
Point...R 26 :	16.909	10.071	0.087 Line
Point...R 27 :	16.996	10.079	0.087 Line
Point...R 28 :	17.083	10.088	0.087 Line
Point...R 29 :	17.170	10.097	0.087 Line
Point...R 30 :	17.257	10.107	0.087 Line
Point...R 31 :	17.343	10.117	0.087 Line
Point...R 32 :	17.430	10.128	0.087 Line
Point...R 33 :	17.516	10.140	0.087 Line
Point...R 34 :	17.603	10.152	0.087 Line
Point...R 35 :	17.689	10.165	0.087 Line
Point...R 36 :	17.775	10.179	0.087 Line
Point...R 37 :	17.861	10.193	0.087 Line
Point...R 38 :	17.947	10.208	0.087 Line

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MCAL2000 - Transition Layout 11.7.4

Your Company Name Here

2011-01-14 06:49:26 Page 4

Session : Transition w20.000 x s10.000 x d10.000 x h10.000

Q: _____ WO: _____

Comment : Customer Name Here

2 Segments Required

Matching Segments : Dia Offsets X 0.000, Y 0.000

Point Number	Point X	Point Y	Distance
Point...R 39 :	18.033	10.224	0.087 Line
Point...R 40 :	18.119	10.240	0.087 Line
Point...R 41 :	18.204	10.257	0.087 Line
Point...R 42 :	18.290	10.275	0.087 Line
Point...R 43 :	18.375	10.293	0.087 Line
Point...R 44 :	18.460	10.313	0.087 Line
Point...R 45 :	18.545	10.332	0.087 Line
Point...R 46 :	18.630	10.353	0.087 Line
Point...R 47 :	18.715	10.374	0.087 Line
Point...R 48 :	18.799	10.396	0.087 Line
Point...R 49 :	18.883	10.419	0.087 Line
Point...R 50 :	18.967	10.443	0.087 Line
Point...R 51 :	19.051	10.467	0.087 Line
Point...R 52 :	19.135	10.492	0.087 Line
Point...R 53 :	19.218	10.518	0.087 Line
Point...R 54 :	19.301	10.544	0.087 Line
Point...R 55 :	19.384	10.572	0.087 Line
Point...R 56 :	19.467	10.600	0.087 Line
Point...R 57 :	19.549	10.628	0.087 Line
Point...R 58 :	19.631	10.658	0.087 Line
Point...R 59 :	19.713	10.688	0.087 Line
Point...R 60 :	19.795	10.719	0.087 Line
Point...R 61 :	19.876	10.751	0.087 Line
Point...R 62 :	19.957	10.783	0.087 Line
Point...R 63 :	20.038	10.817	0.087 Line
Point...R 64 :	20.118	10.850	0.087 Line
Point...R 65 :	20.198	10.885	0.087 Line
Point...R 66 :	20.278	10.921	0.087 Line
Point...R 67 :	20.357	10.957	0.087 Line
Point...R 68 :	20.436	10.994	0.087 Line
Point...R 69 :	20.515	11.031	0.087 Line
Point...R 70 :	20.594	11.070	0.087 Line
Point...R 71 :	20.672	11.109	0.087 Line
Point...R 72 :	20.749	11.148	0.087 Line
Point...R 73 :	20.827	11.189	0.087 Line
Point...R 74 :	20.904	11.230	0.087 Line
Point...R 75 :	20.980	11.272	0.087 Line
Point...R 76 :	21.056	11.314	0.087 Line
Point...R 77 :	21.132	11.358	0.087 Line
Point...R 78 :	21.208	11.401	0.087 Line
Point...R 79 :	21.283	11.446	0.087 Line
Point...R 80 :	21.357	11.491	0.087 Line
Point...R 81 :	21.432	11.537	0.087 Line
Point...R 82 :	21.505	11.583	0.087 Line
Point...R 83 :	21.579	11.630	0.087 Line
Point...R 84 :	21.652	11.678	0.087 Line
Point...R 85 :	21.725	11.726	0.087 Line
Point...R 86 :	21.797	11.775	0.087 Line
Point...R 87 :	21.869	11.825	0.087 Line
Point...R 88 :	21.940	11.875	0.087 Line
Point...R 89 :	22.011	11.926	0.087 Line
Point...R 90 :	22.082	11.977	0.087 Line

[2nd Break Allowance]

Point... 9 :	22.688	12.419	0.750 Line
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Your Company Name Here

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Session : Transition w20.000 x s10.000 x d10.000 x h10.000

Q: _____ WO: _____

Comment : Customer Name Here

2 Segments Required

Matching Segments : Dia Offsets X 0.000, Y 0.000

Point Number	Point X	Point Y	Distance
Point... 2 :	29.285	3.393	11.205 Line

[END]

MCAL2000 - Transition Layout 11.7.4

Your Company Name Here

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Session : Transition w20.000 x s10.000 x d10.000 x h10.000

Q: _____ WO: _____

Comment : Customer Name Here

2 Segments Required

Matching Segments : Dia Offsets X 0.000, Y 0.000

SEGMENT LAYOUT: 2 Segments

Blank Size: 29 7/8" x 12 15/16"
Segment Border: 0 1/4"
Segment Developed Angle .: 72.323 Degrees
Convergence Point.....: 14 5/8", 22 3/16"
Large Dia Curve Length ..: 15 11/16"
Cut Path Incr Angle: 1.0 Degrees
Cut Path Point Distance .: 0 1/16"
Maximum Break Length: 14 1/8"
Number Of Break Lines ...: 38.0
Break Line Incr Angle ...: 5.0 Degrees
Break Line Incr Distance : 0 7/16"
Cut Distance(each): 71 9/16"
Cut Distance(total): 143 1/8"

POINT LAYOUT

Duplicate Points Indicate Zero Break Allowance and/or Zero CNC Lead-In

Point Number	Point X	Point Y	Distance	
Reference	0"	0"	0"	Quadrant Zero
Point... 0 :	-0 1/4"	-0 1/4"	0 3/8"	CNC Start
Point... 1 :	29 3/8"	3 7/8"	29 7/8"	CNC Rapid

[Manual Layout Start Point and 1st Break Allowance]

Point... 2 :	29 5/16"	3 3/8"	0 1/2"	Start
Point... 3 :	28 11/16"	2 15/16"	0 3/4"	Line
Point... 4 :	24 5/8"	0"	5"	Line
Point... 5 :	4 5/8"	0"	20"	Line
Point... 6 :	0 5/8"	2 15/16"	5"	Line
Point... 7 :	0"	3 3/8"	0 3/4"	Line
Point... 8 :	6 5/8"	12 7/16"	11 3/16"	Line

[Left Side Portion Of Curve]

Point...L 90 :	7 3/16"	12"	0 3/4"	Line
Point...L 89 :	7 1/4"	11 15/16"	0 1/16"	Line
Point...L 88 :	7 3/8"	11 7/8"	0 1/16"	Line
Point...L 87 :	7 7/16"	11 13/16"	0 1/16"	Line
Point...L 86 :	7 1/2"	11 3/4"	0 1/16"	Line
Point...L 85 :	7 9/16"	11 3/4"	0 1/16"	Line
Point...L 84 :	7 5/8"	11 11/16"	0 1/16"	Line
Point...L 83 :	7 11/16"	11 5/8"	0 1/16"	Line
Point...L 82 :	7 3/4"	11 9/16"	0 1/16"	Line
Point...L 81 :	7 7/8"	11 9/16"	0 1/16"	Line
Point...L 80 :	7 15/16"	11 1/2"	0 1/16"	Line
Point...L 79 :	8"	11 7/16"	0 1/16"	Line
Point...L 78 :	8 1/16"	11 3/8"	0 1/16"	Line
Point...L 77 :	8 1/8"	11 3/8"	0 1/16"	Line
Point...L 76 :	8 1/4"	11 5/16"	0 1/16"	Line
Point...L 75 :	8 5/16"	11 1/4"	0 1/16"	Line
Point...L 74 :	8 3/8"	11 1/4"	0 1/16"	Line
Point...L 73 :	8 7/16"	11 3/16"	0 1/16"	Line
Point...L 72 :	8 9/16"	11 1/8"	0 1/16"	Line
Point...L 71 :	8 5/8"	11 1/8"	0 1/16"	Line
Point...L 70 :	8 11/16"	11 1/16"	0 1/16"	Line
Point...L 69 :	8 3/4"	11 1/16"	0 1/16"	Line

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Session : Transition w20.000 x s10.000 x d10.000 x h10.000

Q: _____ WO: _____

Comment : Customer Name Here

2 Segments Required

Matching Segments : Dia Offsets X 0.000, Y 0.000

Point Number	Point X	Point Y	Distance
Point...L 68 :	8 7/8"	11"	0 1/16" Line
Point...L 67 :	8 15/16"	10 15/16"	0 1/16" Line
Point...L 66 :	9"	10 15/16"	0 1/16" Line
Point...L 65 :	9 1/16"	10 7/8"	0 1/16" Line
Point...L 64 :	9 3/16"	10 7/8"	0 1/16" Line
Point...L 63 :	9 1/4"	10 13/16"	0 1/16" Line
Point...L 62 :	9 5/16"	10 13/16"	0 1/16" Line
Point...L 61 :	9 7/16"	10 3/4"	0 1/16" Line
Point...L 60 :	9 1/2"	10 3/4"	0 1/16" Line
Point...L 59 :	9 9/16"	10 11/16"	0 1/16" Line
Point...L 58 :	9 5/8"	10 11/16"	0 1/16" Line
Point...L 57 :	9 3/4"	10 5/8"	0 1/16" Line
Point...L 56 :	9 13/16"	10 5/8"	0 1/16" Line
Point...L 55 :	9 7/8"	10 9/16"	0 1/16" Line
Point...L 54 :	10"	10 9/16"	0 1/16" Line
Point...L 53 :	10 1/16"	10 1/2"	0 1/16" Line
Point...L 52 :	10 1/8"	10 1/2"	0 1/16" Line
Point...L 51 :	10 1/4"	10 7/16"	0 1/16" Line
Point...L 50 :	10 5/16"	10 7/16"	0 1/16" Line
Point...L 49 :	10 3/8"	10 7/16"	0 1/16" Line
Point...L 48 :	10 1/2"	10 3/8"	0 1/16" Line
Point...L 47 :	10 9/16"	10 3/8"	0 1/16" Line
Point...L 46 :	10 5/8"	10 3/8"	0 1/16" Line
Point...L 45 :	10 3/4"	10 5/16"	0 1/16" Line
Point...L 44 :	10 13/16"	10 5/16"	0 1/16" Line
Point...L 43 :	10 15/16"	10 5/16"	0 1/16" Line
Point...L 42 :	11"	10 1/4"	0 1/16" Line
Point...L 41 :	11 1/16"	10 1/4"	0 1/16" Line
Point...L 40 :	11 3/16"	10 1/4"	0 1/16" Line
Point...L 39 :	11 1/4"	10 1/4"	0 1/16" Line
Point...L 38 :	11 5/16"	10 3/16"	0 1/16" Line
Point...L 37 :	11 7/16"	10 3/16"	0 1/16" Line
Point...L 36 :	11 1/2"	10 3/16"	0 1/16" Line
Point...L 35 :	11 5/8"	10 3/16"	0 1/16" Line
Point...L 34 :	11 11/16"	10 1/8"	0 1/16" Line
Point...L 33 :	11 3/4"	10 1/8"	0 1/16" Line
Point...L 32 :	11 7/8"	10 1/8"	0 1/16" Line
Point...L 31 :	11 15/16"	10 1/8"	0 1/16" Line
Point...L 30 :	12"	10 1/8"	0 1/16" Line
Point...L 29 :	12 1/8"	10 1/8"	0 1/16" Line
Point...L 28 :	12 3/16"	10 1/16"	0 1/16" Line
Point...L 27 :	12 5/16"	10 1/16"	0 1/16" Line
Point...L 26 :	12 3/8"	10 1/16"	0 1/16" Line
Point...L 25 :	12 7/16"	10 1/16"	0 1/16" Line
Point...L 24 :	12 9/16"	10 1/16"	0 1/16" Line
Point...L 23 :	12 5/8"	10 1/16"	0 1/16" Line
Point...L 22 :	12 3/4"	10 1/16"	0 1/16" Line
Point...L 21 :	12 13/16"	10 1/16"	0 1/16" Line
Point...L 20 :	12 7/8"	10 1/16"	0 1/16" Line
Point...L 19 :	13"	10"	0 1/16" Line
Point...L 18 :	13 1/16"	10"	0 1/16" Line
Point...L 17 :	13 3/16"	10"	0 1/16" Line
Point...L 16 :	13 1/4"	10"	0 1/16" Line
Point...L 15 :	13 5/16"	10"	0 1/16" Line

Continued On Page 3

MCAL2000 - Transition Layout 11.7.4

Your Company Name Here

2011-01-14 06:49:26 Page 3

Session : Transition w20.000 x s10.000 x d10.000 x h10.000

Q: _____ WO: _____

Comment : Customer Name Here

2 Segments Required

Matching Segments : Dia Offsets X 0.000, Y 0.000

Point Number	Point X	Point Y	Distance
Point...L 14 :	13 7/16"	10"	0 1/16" Line
Point...L 13 :	13 1/2"	10"	0 1/16" Line
Point...L 12 :	13 5/8"	10"	0 1/16" Line
Point...L 11 :	13 11/16"	10"	0 1/16" Line
Point...L 10 :	13 3/4"	10"	0 1/16" Line
Point...L 9 :	13 7/8"	10"	0 1/16" Line
Point...L 8 :	13 15/16"	10"	0 1/16" Line
Point...L 7 :	14 1/16"	10"	0 1/16" Line
Point...L 6 :	14 1/8"	10"	0 1/16" Line
Point...L 5 :	14 3/16"	10"	0 1/16" Line
Point...L 4 :	14 5/16"	10"	0 1/16" Line
Point...L 3 :	14 3/8"	10"	0 1/16" Line
Point...L 2 :	14 7/16"	10"	0 1/16" Line
Point...L 1 :	14 9/16"	10"	0 1/16" Line
[Mid Point Of Curve]			
Point..LR 0 :	14 5/8"	10"	0 1/16" Line
[Right Side Portion Of Curve]			
Point... 1 :	14 3/4"	10"	0 1/16" Line
Point... 2 :	14 13/16"	10"	0 1/16" Line
Point... 3 :	14 7/8"	10"	0 1/16" Line
Point... 4 :	15"	10"	0 1/16" Line
Point... 5 :	15 1/16"	10"	0 1/16" Line
Point... 6 :	15 3/16"	10"	0 1/16" Line
Point... 7 :	15 1/4"	10"	0 1/16" Line
Point... 8 :	15 5/16"	10"	0 1/16" Line
Point... 9 :	15 7/16"	10"	0 1/16" Line
Point... 10 :	15 1/2"	10"	0 1/16" Line
Point... 11 :	15 5/8"	10"	0 1/16" Line
Point... 12 :	15 11/16"	10"	0 1/16" Line
Point... 13 :	15 3/4"	10"	0 1/16" Line
Point... 14 :	15 7/8"	10"	0 1/16" Line
Point... 15 :	15 15/16"	10"	0 1/16" Line
Point... 16 :	16 1/16"	10"	0 1/16" Line
Point... 17 :	16 1/8"	10"	0 1/16" Line
Point... 18 :	16 3/16"	10"	0 1/16" Line
Point... 19 :	16 5/16"	10"	0 1/16" Line
Point... 20 :	16 3/8"	10 1/16"	0 1/16" Line
Point... 21 :	16 1/2"	10 1/16"	0 1/16" Line
Point... 22 :	16 9/16"	10 1/16"	0 1/16" Line
Point... 23 :	16 5/8"	10 1/16"	0 1/16" Line
Point... 24 :	16 3/4"	10 1/16"	0 1/16" Line
Point... 25 :	16 13/16"	10 1/16"	0 1/16" Line
Point... 26 :	16 15/16"	10 1/16"	0 1/16" Line
Point... 27 :	17"	10 1/16"	0 1/16" Line
Point... 28 :	17 1/16"	10 1/16"	0 1/16" Line
Point... 29 :	17 3/16"	10 1/8"	0 1/16" Line
Point... 30 :	17 1/4"	10 1/8"	0 1/16" Line
Point... 31 :	17 5/16"	10 1/8"	0 1/16" Line
Point... 32 :	17 7/16"	10 1/8"	0 1/16" Line
Point... 33 :	17 1/2"	10 1/8"	0 1/16" Line
Point... 34 :	17 5/8"	10 1/8"	0 1/16" Line
Point... 35 :	17 11/16"	10 3/16"	0 1/16" Line
Point... 36 :	17 3/4"	10 3/16"	0 1/16" Line

Continued On Page 4

MCAL2000 - Transition Layout 11.7.4

Your Company Name Here

2011-01-14 06:49:26 Page 4

Session : Transition w20.000 x s10.000 x d10.000 x h10.000

Q: _____ WO: _____

Comment : Customer Name Here

2 Segments Required

Matching Segments : Dia Offsets X 0.000, Y 0.000

Point Number	Point X	Point Y	Distance
Point... 37 :	17 7/8"	10 3/16"	0 1/16" Line
Point... 38 :	17 15/16"	10 3/16"	0 1/16" Line
Point... 39 :	18 1/16"	10 1/4"	0 1/16" Line
Point... 40 :	18 1/8"	10 1/4"	0 1/16" Line
Point... 41 :	18 3/16"	10 1/4"	0 1/16" Line
Point... 42 :	18 5/16"	10 1/4"	0 1/16" Line
Point... 43 :	18 3/8"	10 5/16"	0 1/16" Line
Point... 44 :	18 7/16"	10 5/16"	0 1/16" Line
Point... 45 :	18 9/16"	10 5/16"	0 1/16" Line
Point... 46 :	18 5/8"	10 3/8"	0 1/16" Line
Point... 47 :	18 11/16"	10 3/8"	0 1/16" Line
Point... 48 :	18 13/16"	10 3/8"	0 1/16" Line
Point... 49 :	18 7/8"	10 7/16"	0 1/16" Line
Point... 50 :	18 15/16"	10 7/16"	0 1/16" Line
Point... 51 :	19 1/16"	10 7/16"	0 1/16" Line
Point... 52 :	19 1/8"	10 1/2"	0 1/16" Line
Point... 53 :	19 3/16"	10 1/2"	0 1/16" Line
Point... 54 :	19 5/16"	10 9/16"	0 1/16" Line
Point... 55 :	19 3/8"	10 9/16"	0 1/16" Line
Point... 56 :	19 7/16"	10 5/8"	0 1/16" Line
Point... 57 :	19 9/16"	10 5/8"	0 1/16" Line
Point... 58 :	19 5/8"	10 11/16"	0 1/16" Line
Point... 59 :	19 11/16"	10 11/16"	0 1/16" Line
Point... 60 :	19 13/16"	10 3/4"	0 1/16" Line
Point... 61 :	19 7/8"	10 3/4"	0 1/16" Line
Point... 62 :	19 15/16"	10 13/16"	0 1/16" Line
Point... 63 :	20 1/16"	10 13/16"	0 1/16" Line
Point... 64 :	20 1/8"	10 7/8"	0 1/16" Line
Point... 65 :	20 3/16"	10 7/8"	0 1/16" Line
Point... 66 :	20 1/4"	10 15/16"	0 1/16" Line
Point... 67 :	20 3/8"	10 15/16"	0 1/16" Line
Point... 68 :	20 7/16"	11"	0 1/16" Line
Point... 69 :	20 1/2"	11 1/16"	0 1/16" Line
Point... 70 :	20 9/16"	11 1/16"	0 1/16" Line
Point... 71 :	20 11/16"	11 1/8"	0 1/16" Line
Point... 72 :	20 3/4"	11 1/8"	0 1/16" Line
Point... 73 :	20 13/16"	11 3/16"	0 1/16" Line
Point... 74 :	20 7/8"	11 1/4"	0 1/16" Line
Point... 75 :	21"	11 1/4"	0 1/16" Line
Point... 76 :	21 1/16"	11 5/16"	0 1/16" Line
Point... 77 :	21 1/8"	11 3/8"	0 1/16" Line
Point... 78 :	21 3/16"	11 3/8"	0 1/16" Line
Point... 79 :	21 5/16"	11 7/16"	0 1/16" Line
Point... 80 :	21 3/8"	11 1/2"	0 1/16" Line
Point... 81 :	21 7/16"	11 9/16"	0 1/16" Line
Point... 82 :	21 1/2"	11 9/16"	0 1/16" Line
Point... 83 :	21 9/16"	11 5/8"	0 1/16" Line
Point... 84 :	21 5/8"	11 11/16"	0 1/16" Line
Point... 85 :	21 3/4"	11 3/4"	0 1/16" Line
Point... 86 :	21 13/16"	11 3/4"	0 1/16" Line
Point... 87 :	21 7/8"	11 13/16"	0 1/16" Line
Point... 88 :	21 15/16"	11 7/8"	0 1/16" Line
Point... 89 :	22"	11 15/16"	0 1/16" Line
Point... 90 :	22 1/16"	12"	0 1/16" Line

Continued On Page 5

MCAL2000 - Transition Layout 11.7.4

Your Company Name Here

2011-01-14 06:49:26 Page 5

Session : Transition w20.000 x s10.000 x d10.000 x h10.000

Q: _____ WO: _____

Comment : Customer Name Here

2 Segments Required

Matching Segments : Dia Offsets X 0.000, Y 0.000

Point Number	Point X	Point Y	Distance
[2nd Break Allowance]			
Point... 9	: 22 11/16"	12 7/16"	0 3/4" Line
Point... 2	: 29 5/16"	3 3/8"	11 3/16" Line

[END]

MCAL2000 - Transition Layout 11.7.4

Your Company Name Here

2011-01-14 06:49:26 Page 1

Session : Transition w20.000 x s10.000 x d10.000 x h10.000

Q: _____ WO: _____

Comment : Customer Name Here

2 Segments Required

Matching Segments : Dia Offsets X 0.000, Y 0.000

CNC FileName: C:\MicroCAL\TR2K\TR2K.txt

%%

N0010 M31

N0020 G90

N0030 G70

N0040 F20.0

(

Transition w20.000 x s10.000 x d10.000 x h10.000

)

N0050 M00

N0060 G92 X-0000.250 Y-0000.250

N0070 G00 X+0029.361 Y+0003.887

N0080 G41

N0090 M07

N0100 G01

N0110 X+0029.285 Y+0003.393

N0120 X+0024.642 Y+0000.000

N0130 X+0004.642 Y+0000.000

N0140 X+0000.000 Y+0003.393

N0150 X+0006.597 Y+0012.419

N0160 X+0007.203 Y+0011.977

N0170 X+0007.273 Y+0011.926

N0180 X+0007.344 Y+0011.875

N0190 X+0007.416 Y+0011.825

N0200 X+0007.488 Y+0011.775

N0210 X+0007.560 Y+0011.726

N0220 X+0007.633 Y+0011.678

N0230 X+0007.706 Y+0011.630

N0240 X+0007.779 Y+0011.583

N0250 X+0007.853 Y+0011.537

N0260 X+0007.927 Y+0011.491

N0270 X+0008.002 Y+0011.446

N0280 X+0008.077 Y+0011.401

N0290 X+0008.152 Y+0011.358

N0300 X+0008.228 Y+0011.314

N0310 X+0008.304 Y+0011.272

N0320 X+0008.381 Y+0011.230

N0330 X+0008.458 Y+0011.189

N0340 X+0008.535 Y+0011.148

N0350 X+0008.613 Y+0011.109

N0360 X+0008.691 Y+0011.070

N0370 X+0008.769 Y+0011.031

N0380 X+0008.848 Y+0010.994

N0390 X+0008.927 Y+0010.957

N0400 X+0009.007 Y+0010.921

N0410 X+0009.086 Y+0010.885

N0420 X+0009.167 Y+0010.850

N0430 X+0009.247 Y+0010.817

N0440 X+0009.328 Y+0010.783

N0450 X+0009.409 Y+0010.751

N0460 X+0009.490 Y+0010.719

N0470 X+0009.571 Y+0010.688

N0480 X+0009.653 Y+0010.658

N0490 X+0009.735 Y+0010.628

N0500 X+0009.818 Y+0010.600

Continued On Page 2

MCAL2000 - Transition Layout 11.7.4

Your Company Name Here

2011-01-14 06:49:26 Page 2

Session : Transition w20.000 x s10.000 x d10.000 x h10.000

Q: _____ WO: _____

Comment : Customer Name Here

2 Segments Required

Matching Segments : Dia Offsets X 0.000, Y 0.000

CNC FileName: C:\MicroCAL\TR2K\TR2K.txt

N0510 X+0009.901 Y+0010.572
N0520 X+0009.983 Y+0010.544
N0530 X+0010.067 Y+0010.518
N0540 X+0010.150 Y+0010.492
N0550 X+0010.234 Y+0010.467
N0560 X+0010.317 Y+0010.443
N0570 X+0010.401 Y+0010.419
N0580 X+0010.486 Y+0010.396
N0590 X+0010.570 Y+0010.374
N0600 X+0010.655 Y+0010.353
N0610 X+0010.739 Y+0010.332
N0620 X+0010.824 Y+0010.313
N0630 X+0010.910 Y+0010.293
N0640 X+0010.995 Y+0010.275
N0650 X+0011.080 Y+0010.257
N0660 X+0011.166 Y+0010.240
N0670 X+0011.252 Y+0010.224
N0680 X+0011.338 Y+0010.208
N0690 X+0011.423 Y+0010.193
N0700 X+0011.510 Y+0010.179
N0710 X+0011.596 Y+0010.165
N0720 X+0011.682 Y+0010.152
N0730 X+0011.768 Y+0010.140
N0740 X+0011.855 Y+0010.128
N0750 X+0011.941 Y+0010.117
N0760 X+0012.028 Y+0010.107
N0770 X+0012.115 Y+0010.097
N0780 X+0012.202 Y+0010.088
N0790 X+0012.288 Y+0010.079
N0800 X+0012.375 Y+0010.071
N0810 X+0012.462 Y+0010.063
N0820 X+0012.549 Y+0010.056
N0830 X+0012.636 Y+0010.050
N0840 X+0012.723 Y+0010.044
N0850 X+0012.810 Y+0010.038
N0860 X+0012.898 Y+0010.033
N0870 X+0012.985 Y+0010.029
N0880 X+0013.072 Y+0010.024
N0890 X+0013.159 Y+0010.021
N0900 X+0013.246 Y+0010.017
N0910 X+0013.333 Y+0010.014
N0920 X+0013.421 Y+0010.012
N0930 X+0013.508 Y+0010.009
N0940 X+0013.595 Y+0010.007
N0950 X+0013.682 Y+0010.006
N0960 X+0013.770 Y+0010.004
N0970 X+0013.857 Y+0010.003
N0980 X+0013.944 Y+0010.002
N0990 X+0014.031 Y+0010.001
N1000 X+0014.119 Y+0010.001
N1010 X+0014.206 Y+0010.001
N1020 X+0014.293 Y+0010.000
N1030 X+0014.381 Y+0010.000
N1040 X+0014.468 Y+0010.000

Continued On Page 3

MCAL2000 - Transition Layout 11.7.4

Your Company Name Here

2011-01-14 06:49:26 Page 3

Session : Transition w20.000 x s10.000 x d10.000 x h10.000

Q: _____ WO: _____

Comment : Customer Name Here

2 Segments Required

Matching Segments : Dia Offsets X 0.000, Y 0.000

CNC FileName: C:\MicroCAL\TR2K\TR2K.txt

N1050 X+0014.555 Y+0010.000
N1060 X+0014.642 Y+0010.000
N1070 X+0014.730 Y+0010.000
N1080 X+0014.817 Y+0010.000
N1090 X+0014.904 Y+0010.000
N1100 X+0014.991 Y+0010.000
N1110 X+0015.079 Y+0010.001
N1120 X+0015.166 Y+0010.001
N1130 X+0015.253 Y+0010.001
N1140 X+0015.340 Y+0010.002
N1150 X+0015.428 Y+0010.003
N1160 X+0015.515 Y+0010.004
N1170 X+0015.602 Y+0010.006
N1180 X+0015.689 Y+0010.007
N1190 X+0015.777 Y+0010.009
N1200 X+0015.864 Y+0010.012
N1210 X+0015.951 Y+0010.014
N1220 X+0016.038 Y+0010.017
N1230 X+0016.126 Y+0010.021
N1240 X+0016.213 Y+0010.024
N1250 X+0016.300 Y+0010.029
N1260 X+0016.387 Y+0010.033
N1270 X+0016.474 Y+0010.038
N1280 X+0016.561 Y+0010.044
N1290 X+0016.648 Y+0010.050
N1300 X+0016.735 Y+0010.056
N1310 X+0016.822 Y+0010.063
N1320 X+0016.909 Y+0010.071
N1330 X+0016.996 Y+0010.079
N1340 X+0017.083 Y+0010.088
N1350 X+0017.170 Y+0010.097
N1360 X+0017.257 Y+0010.107
N1370 X+0017.343 Y+0010.117
N1380 X+0017.430 Y+0010.128
N1390 X+0017.516 Y+0010.140
N1400 X+0017.603 Y+0010.152
N1410 X+0017.689 Y+0010.165
N1420 X+0017.775 Y+0010.179
N1430 X+0017.861 Y+0010.193
N1440 X+0017.947 Y+0010.208
N1450 X+0018.033 Y+0010.224
N1460 X+0018.119 Y+0010.240
N1470 X+0018.204 Y+0010.257
N1480 X+0018.290 Y+0010.275
N1490 X+0018.375 Y+0010.293
N1500 X+0018.460 Y+0010.313
N1510 X+0018.545 Y+0010.332
N1520 X+0018.630 Y+0010.353
N1530 X+0018.715 Y+0010.374
N1540 X+0018.799 Y+0010.396
N1550 X+0018.883 Y+0010.419
N1560 X+0018.967 Y+0010.443
N1570 X+0019.051 Y+0010.467
N1580 X+0019.135 Y+0010.492

Continued On Page 4

MCAL2000 - Transition Layout 11.7.4

Your Company Name Here

2011-01-14 06:49:26 Page 4

Session : Transition w20.000 x s10.000 x d10.000 x h10.000

Q: _____ WO: _____

Comment : Customer Name Here

2 Segments Required

Matching Segments : Dia Offsets X 0.000, Y 0.000

CNC FileName: C:\MicroCAL\TR2K\TR2K.txt

N1590 X+0019.218 Y+0010.518
N1600 X+0019.301 Y+0010.544
N1610 X+0019.384 Y+0010.572
N1620 X+0019.467 Y+0010.600
N1630 X+0019.549 Y+0010.628
N1640 X+0019.631 Y+0010.658
N1650 X+0019.713 Y+0010.688
N1660 X+0019.795 Y+0010.719
N1670 X+0019.876 Y+0010.751
N1680 X+0019.957 Y+0010.783
N1690 X+0020.038 Y+0010.817
N1700 X+0020.118 Y+0010.850
N1710 X+0020.198 Y+0010.885
N1720 X+0020.278 Y+0010.921
N1730 X+0020.357 Y+0010.957
N1740 X+0020.436 Y+0010.994
N1750 X+0020.515 Y+0011.031
N1760 X+0020.594 Y+0011.070
N1770 X+0020.672 Y+0011.109
N1780 X+0020.749 Y+0011.148
N1790 X+0020.827 Y+0011.189
N1800 X+0020.904 Y+0011.230
N1810 X+0020.980 Y+0011.272
N1820 X+0021.056 Y+0011.314
N1830 X+0021.132 Y+0011.358
N1840 X+0021.208 Y+0011.401
N1850 X+0021.283 Y+0011.446
N1860 X+0021.357 Y+0011.491
N1870 X+0021.432 Y+0011.537
N1880 X+0021.505 Y+0011.583
N1890 X+0021.579 Y+0011.630
N1900 X+0021.652 Y+0011.678
N1910 X+0021.725 Y+0011.726
N1920 X+0021.797 Y+0011.775
N1930 X+0021.869 Y+0011.825
N1940 X+0021.940 Y+0011.875
N1950 X+0022.011 Y+0011.926
N1960 X+0022.082 Y+0011.977
N1970 X+0022.688 Y+0012.419
N1980 X+0029.285 Y+0003.393
N1990 M08
N2000 G40
N2010 M02
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