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%
O F anuc15i_3axis;
N1 G90 G94 G21 G17;
(PROGRAMMED BY AUTHOR);
();
(TOOL 0 IS 5 MM FLAT ENDMILL.);
(SHAPE PARAMETERS);
N2 T0 M06;
N3 T0;
(x= 0,y= 0,z= 500,Tool No= 0);
N4 M999;
N5 M08;
N6 S1000;
N7 M03;
(OPERATION - PROFILECUT 1);
(TACTIC - PROFILECUT 1);
(PLAN - );
(FILE - G CODE GALLERY TEST PART.Z3);
N8 G90 G00 X49. Y-30.;
N9 G43 Z100. H0;
N10 Z52.5;
N11 G01 Z50. F50;
N12 Y-23.5 F150;
N13 G17 G03 X42.5 Y-30. I0 J-6.5;
N14 G02 X23.75 Y-40.825 I-12.5 J0 F250;
N15 Y-19.175 I6.25 J10.825;
N16 X42.5 Y-30. I6.25 J-10.825;
N17 G03 X49. Y-36.5 I6.5 J0 F750;
N18 G01 Y-30.;
N19 G00 Z100.;
(OPERATION - PROFILECUT 2);
(TACTIC - PROFILECUT 2);
(PLAN - );
(FILE - G CODE GALLERY TEST PART.Z3);
N20 X-35. Y-44.;
N21 Z52.5;
N22 G01 Z50. F50;
N23 X-28.5 F150;
N24 G03 X-35. Y-37.5 I-6.5 J0;
N25 G02 X-37.5 Y-35. I0 J2.5 F250;
N26 G01 Y-25.;
N27 G02 X-35. Y-22.5 I2.5 J0;
N28 G01 X-25.;
N29 G02 X-22.5 Y-25. I0 J-2.5;
N30 G01 Y-35.;
N31 G02 X-25. Y-37.5 I-2.5 J0;
N32 G01 X-35.;
N33 G03 X-41.5 Y-44. I0 J-6.5 F750;
N34 G01 X-35.;
N35 G00 Z100.;
N36 M09;
(TOOL 0 IS 10 MM FLAT ENDMILL.);
(SHAPE PARAMETERS);
N37 M05;
N38 M06;
N39 T0;
(x= -35,y= -44,z= 100,Tool No= 0);
N40 M999 R0;
N41 M08;

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N42 S1000;
N43 M03;
(OPERATION - ZIGZAGCUT 1);
(TACTIC - ZIGZAGCUT 1);
(PLAN -);
(FILE - G CODE GALLERY TEST PART.Z3);
N44 G90 G00 X-38.38 Y10.856;
N45 G43 Z100. H0;
N46 Z67.5;
N47 G01 Y6.526 Z65. F50;
N48 G17 G02 X-45. Y5.279 I-11.62 J43.474;
N49 G01 Y45. F100;
N50 X-38.38 F250;
N51 Y6.526;
N52 G03 X-31.76 Y8.863 I-11.62 J43.474;
N53 G01 Y45.;
N54 X-25.139;
N55 Y12.491;
N56 G03 X-18.519 Y17.845 I-24.861 J37.509;
N57 G01 Y45.;
N58 X-11.899;
N59 Y26.056;
N60 G03 X-5.279 Y45. I-38.101 J23.944;
N61 G01 X-11.899;
N62 G00 Z100.;
N63 Z67.5;
N64 G01 Z65. F50;
N65 X-45. F250;
N66 Y5.279;
N67 G03 X-5.279 Y45. I-5. J44.721;
N68 G01 X-15.899;
N69 G03 X-22.399 Y38.5 I0 J-6.5 F750;
N70 G01 Y32.;
N71 G00 Z100.;
(OPERATION - ROUGH PLUNGE 1);
(TACTIC - ROUGH PLUNGE 1);
(PLAN -);
(FILE - G CODE GALLERY TEST PART.Z3);
N72 X-6.929 Y-6.929;
N73 Z72.;
N74 G01 Z67. F50;
N75 Z51. F250;
N76 Z72.;
N77 Y0;
N78 Z67. F50;
N79 Z51. F250;
N80 Z72.;
N81 Y6.929;
N82 Z67. F50;
N83 Z51. F250;
N84 Z72.;
N85 X0;
N86 Z67. F50;
N87 Z51. F250;
N88 Z72.;
N89 X6.929;
N90 Z67. F50;
N91 Z51. F250;
N92 Z72.;

N93 Y0;
N94 Z67. F50;
N95 Z51. F250;
N96 Z72.;
N97 X0;
N98 Z67. F50;
N99 Z51. F250;
N100 Z72.;
N101 X6.929 Y-6.929;
N102 Z67. F50;
N103 Z51. F250;
N104 Z72.;
N105 X0;
N106 Z67. F50;
N107 Z51. F250;
N108 G00 Z100.;
(OPERATION - INTERPATH 1);
(TACTIC - INTERPATH 1);
(PLAN -);
(FILE - G CODE GALLERY TEST PART.Z3);
N109 G01 X145. Y3.528 F250;
N110 X145.436 Z99.981;
N111 X145.868 Z99.924;
N112 X146.294 Z99.83;
N113 X146.71 Z99.698;
N114 X147.113 Z99.532;
N115 X147.5 Z99.33;
N116 X147.868 Z99.096;
N117 X148.214 Z98.83;
N118 X148.536 Z98.536;
N119 X148.83 Z98.214;
N120 X149.096 Z97.868;
N121 X149.33 Z97.5;
N122 X149.532 Z97.113;
N123 X149.698 Z96.71;
N124 X149.83 Z96.294;
N125 X149.924 Z95.868;
N126 X149.981 Z95.436;
N127 X150. Z95.;
N128 Z1.87;
(OPERATION - SPIRALCUT 1);
(TACTIC - SPIRALCUT 1);
(PLAN -);
(FILE - G CODE GALLERY TEST PART.Z3);
N129 G00 X87.5;
N130 G01 X87.222 Y3.278 Z2.28 F50;
N131 X86.944 Y2.98 Z2.657;
N132 X86.667 Y2.64 Z2.996;
N133 X86.389 Y2.261 Z3.291;
N134 X86.111 Y1.849 Z3.539;
N135 X85.833 Y1.411 Z3.735;
N136 X85.556 Y.952 Z3.878;
N137 X85.278 Y.48 Z3.964;
N138 X85. Y0 Z4.;
N139 G19 G03 Y-3.464 Z-2. J0 K-4. F100;
N140 Y3.464 J3.464 K2.;
N141 Y0 Z4. J-3.464 K2.;
N142 G01 Z10. F250;
N143 G03 Y-8.66 Z-5. J0 K-10.;

N144 Y8.66 J8.66 K5.;
N145 Y0 Z10. J-8.66 K5.;
N146 Y-3.894 Z9.211 J0 K-10.;
N147 Y-7.35 Z.692 J2.531 K-5.987 F750;
N148 G01 Y-4.819 Z-5.294;
N149 G00 X150.;
N150 Y-6.5 Z3.;
N151 X87.5;
N152 G01 X85. F50;
N153 Z-3.5 F150;
N154 G03 Y0 Z-10. J6.5 K0;
N155 Y8.66 Z-5. J0 K10. F250;
N156 Y0 Z10. J-8.66 K5.;
N157 Y-8.66 Z-5. J0 K-10.;
N158 Y0 Z-10. J8.66 K5.;
N159 Y3.894 Z-9.211 J0 K10.;
N160 Y7.35 Z-.692 J-2.531 K5.987 F750;
N161 G01 Y4.819 Z5.294;
N162 G00 X150.;
N163 M05;
N164 M09;
(END OF PROGRAM.);
N165 M02;
N166 M30;
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