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1 BEGIN PGM MILL_5AXIS_HeiDH530_ACTT_MM MM
;Programmed by Author
;Tool 0 is 5 mm Flat Endmill.
;SHAPE PARAMETERS
2 Z0.0 FMAX M91
3 TOOL CALL 0 Z S1000
4 M03
5 M08
;Operation - Profilecut 1
;Tactic - Profilecut 1
;Plan -
;File - G code gallery test part.Z3
6 M126
7 M128
8 L X+49.000 Y-30.000 FMAX
9 L Z+100.000 FMAX
10 L Z+52.500 FMAX
11 L Z+50.000 F50
12 L Y-23.500 F150
13 CC X+49.000 Y-30.000 Z+50.000
14 C X+42.500 Y-30.000 DR+
15 CC X+30.000 Y-30.000 Z+50.000
16 C X+23.750 Y-40.825 DR- F250
17 CC X+30.000 Y-30.000 Z+50.000
18 C X+23.750 Y-19.175 DR-
19 CC X+30.000 Y-30.000 Z+50.000
20 C X+42.500 Y-30.000 DR-
21 CC X+49.000 Y-30.000 Z+50.000
22 C X+49.000 Y-36.500 DR+ F750
23 L Y-30.000
24 L Z+100.000 FMAX
;Operation - Profilecut 2
;Tactic - Profilecut 2
;Plan -
;File - G code gallery test part.Z3
25 L X-35.000 Y-44.000 FMAX
26 L Z+52.500 FMAX
27 L Z+50.000 F50
28 L X-28.500 F150
29 CC X-35.000 Y-44.000 Z+50.000
30 C X-35.000 Y-37.500 DR+
31 CC X-35.000 Y-35.000 Z+50.000
32 C X-37.500 Y-35.000 DR- F250
33 L Y-25.000
34 CC X-35.000 Y-25.000 Z+50.000
35 C X-35.000 Y-22.500 DR-
36 L X-25.000
37 CC X-25.000 Y-25.000 Z+50.000
38 C X-22.500 Y-25.000 DR-
39 L Y-35.000
40 CC X-25.000 Y-35.000 Z+50.000
41 C X-25.000 Y-37.500 DR-
42 L X-35.000
43 CC X-35.000 Y-44.000 Z+50.000
44 C X-41.500 Y-44.000 DR+ F750
45 L X-35.000
46 L Z+100.000 FMAX
47 M09
;Tool 0 is 10 mm Flat Endmill.
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;SHAPE PARAMETERS
48 Z0.0 FMAX M91
49 M05
50 TOOL CALL 0 Z S1000
51 M03
52 M08
;Operation - Zigzagcut 1
;Tactic - Zigzagcut 1
;Plan -
;File - G code gallery test part.Z3
53 L X-38.380 Y+10.856 FMAX
54 L Z+100.000 FMAX
55 L Z+67.500 FMAX
56 L Y+6.526 Z+65.000 F50
57 CC X-50.000 Y+50.000 Z+65.000
58 C X-45.000 Y+5.279 DR-
59 L Y+45.000 F100
60 L X-38.380 F250
61 L Y+6.526
62 CC X-50.000 Y+50.000 Z+65.000
63 C X-31.760 Y+8.863 DR+
64 L Y+45.000
65 L X-25.139
66 L Y+12.491
67 CC X-50.000 Y+50.000 Z+65.000
68 C X-18.519 Y+17.845 DR+
69 L Y+45.000
70 L X-11.899
71 L Y+26.056
72 CC X-50.000 Y+50.000 Z+65.000
73 C X-5.279 Y+45.000 DR+
74 L X-11.899
75 L Z+100.000 FMAX
76 L Z+67.500 FMAX
77 L Z+65.000 F50
78 L X-45.000 F250
79 L Y+5.279
80 CC X-50.000 Y+50.000 Z+65.000
81 C X-5.279 Y+45.000 DR+
82 L X-15.899
83 CC X-15.899 Y+38.500 Z+65.000
84 C X-22.399 Y+38.500 DR+ F750
85 L Y+32.000
86 L Z+100.000 FMAX
;Operation - Rough Plunge 1
;Tactic - Rough Plunge 1
;Plan -
;File - G code gallery test part.Z3
87 L X-6.929 Y-6.929 FMAX
88 L Z+72.000 FMAX
89 L Z+67.000 F50
90 L Z+51.000 F250
91 L Z+72.000
92 L Y+0.0
93 L Z+67.000 F50
94 L Z+51.000 F250
95 L Z+72.000
96 L Y+6.929
97 L Z+67.000 F50
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98 L Z+51.000 F250
99 L Z+72.000
100 L X+0.0
101 L Z+67.000 F50
102 L Z+51.000 F250
103 L Z+72.000
104 L X+6.929
105 L Z+67.000 F50
106 L Z+51.000 F250
107 L Z+72.000
108 L Y+0.0
109 L Z+67.000 F50
110 L Z+51.000 F250
111 L Z+72.000
112 L X+0.0
113 L Z+67.000 F50
114 L Z+51.000 F250
115 L Z+72.000
116 L X+6.929 Y-6.929
117 L Z+67.000 F50
118 L Z+51.000 F250
119 L Z+72.000
120 L X+0.0
121 L Z+67.000 F50
122 L Z+51.000 F250
123 L Z+100.000 FMAX
;Operation - InterPath 1
;Tactic - InterPath 1
;Plan -
;File - G code gallery test part.Z3
124 L X+145.000 Y+3.528 F250
125 L X+145.436 Z+99.981 A-5. C-90.
126 L X+145.868 Z+99.924 A-10.
127 L X+146.294 Z+99.830 A-15.
128 L X+146.710 Z+99.698 A-20.
129 L X+147.113 Z+99.532 A-25.
130 L X+147.500 Z+99.330 A-30.
131 L X+147.868 Z+99.096 A-35.
132 L X+148.214 Z+98.830 A-40.
133 L X+148.536 Z+98.536 A-45.
134 L X+148.830 Z+98.214 A-50.
135 L X+149.096 Z+97.868 A-55.
136 L X+149.330 Z+97.500 A-60.
137 L X+149.532 Z+97.113 A-65.
138 L X+149.698 Z+96.710 A-70.
139 L X+149.830 Z+96.294 A-75.
140 L X+149.924 Z+95.868 A-80.
141 L X+149.981 Z+95.436 A-85.
142 L X+150.000 Z+95.000 A-90.
143 L Z+1.870
;Operation - Spiralcut 1
;Tactic - Spiralcut 1
;Plan -
;File - G code gallery test part.Z3
144 L X+87.500 FMAX
145 L X+87.222 Y+3.278 Z+2.280 F50
146 L X+86.944 Y+2.980 Z+2.657
147 L X+86.667 Y+2.640 Z+2.996
148 L X+86.389 Y+2.261 Z+3.291
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149 L X+86.111 Y+1.849 Z+3.539  
150 L X+85.833 Y+1.411 Z+3.735  
151 L X+85.556 Y+.952 Z+3.878  
152 L X+85.278 Y+.480 Z+3.964  
153 L X+85.000 Y+0.0 Z+4.000  
154 CC X+85.000 Y+0.0 Z+0.0  
155 C Y-3.464 Z-2.000 DR+ F100  
156 CC X+85.000 Y+0.0 Z+0.0  
157 C Y+3.464 Z-2.000 DR+  
158 CC X+85.000 Y+0.0 Z+0.0  
159 C Y+0.0 Z+4.000 DR+  
160 L Z+10.000 F250  
161 CC X+85.000 Y+0.0 Z+0.0  
162 C Y-8.660 Z-5.000 DR+  
163 CC X+85.000 Y+0.0 Z+0.0  
164 C Y+8.660 Z-5.000 DR+  
165 CC X+85.000 Y+0.0 Z+0.0  
166 C Y+0.0 Z+10.000 DR+  
167 CC X+85.000 Y+0.0 Z+0.0  
168 C Y-3.894 Z+9.211 DR+  
169 CC X+85.000 Y-1.363 Z+3.224  
170 C Y-7.350 Z+.692 DR+ F750  
171 L Y-4.819 Z-5.294  
172 L X+150.000 FMAX  
173 L Z+3.000 FMAX  
174 L Y-6.500 FMAX  
175 L X+87.500 FMAX  
176 L X+85.000 F50  
177 L Z-3.500 F150  
178 CC X+85.000 Y+0.0 Z-3.500  
179 C Y+0.0 Z-10.000 DR+  
180 CC X+85.000 Y+0.0 Z+0.0  
181 C Y+8.660 Z-5.000 DR+ F250  
182 CC X+85.000 Y+0.0 Z+0.0  
183 C Y+0.0 Z+10.000 DR+  
184 CC X+85.000 Y+0.0 Z+0.0  
185 C Y-8.660 Z-5.000 DR+  
186 CC X+85.000 Y+0.0 Z+0.0  
187 C Y+0.0 Z-10.000 DR+  
188 CC X+85.000 Y+0.0 Z+0.0  
189 C Y+3.894 Z-9.211 DR+  
190 CC X+85.000 Y+1.363 Z-3.224  
191 C Y+7.350 Z-.692 DR+ F750  
192 L Y+4.819 Z+5.294  
193 L X+150.000 FMAX  
194 M05  
195 M09  
;End of program.  
196 M129  
197 Z0.0 M91  
198 X0.0 Y0.0 A0.0 C0.0  
END PGM MILL\_5AXIS\_HeiDH530\_ACTT\_MM MM