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O M I L L _5A X I S _S I N M S840 D _A C T T _M M
N1 G40 G17 G94 G90 G71
N2 ;Programmed by Author
N3 ;
N4 ;Tool 0 is 5 mm Flat Endmill.
N5 ;SHAPE PARAMETERS
N6 SUPA G91 G74 Z0.0
N7 G90 T0 M06
N8 S1000 M03
N9 M08
N10 ;Operation - Profilecut 1
N11 ;Tactic - Profilecut 1
N12 ;Plan -
N13 ;File - G code gallery test part.Z3
N14 ORIWKS
N15 ORIAXES
N16 TRAORI
N17 G90 G00 X49. Y-30.
N18 Z100.
N19 Z52.5
N20 G01 Z50. F50.
N21 Y-23.5 F150.
N22 G17 G03 X42.5 Y-30. I0 J-6.5
N23 G02 X23.75 Y-40.8253 I-12.5 J0 F250.
N24 Y-19.1747 I6.25 J10.8253
N25 X42.5 Y-30. I6.25 J-10.8253
N26 G03 X49. Y-36.5 I6.5 J0 F750.
N27 G01 Y-30.
N28 G00 Z100.
N29 ;Operation - Profilecut 2
N30 ;Tactic - Profilecut 2
N31 ;Plan -
N32 ;File - G code gallery test part.Z3
N33 X-35. Y-44.
N34 Z52.5
N35 G01 Z50. F50.
N36 X-28.5 F150.
N37 G03 X-35. Y-37.5 I-6.5 J0
N38 G02 X-37.5 Y-35. I0 J2.5 F250.
N39 G01 Y-25.
N40 G02 X-35. Y-22.5 I2.5 J0
N41 G01 X-25.
N42 G02 X-22.5 Y-25. I0 J-2.5
N43 G01 Y-35.
N44 G02 X-25. Y-37.5 I-2.5 J0
N45 G01 X-35.
N46 G03 X-41.5 Y-44. I0 J-6.5 F750.
N47 G01 X-35.
N48 G00 Z100.
N49 M09
N50 ;Tool 0 is 10 mm Flat Endmill.
N51 ;SHAPE PARAMETERS
N52 SUPA G91 G74 Z0.0
N53 G90 M06
N54 S1000 M03
N55 M08
N56 ;Operation - Zigzagcut 1
N57 ;Tactic - Zigzagcut 1
N58 ;Plan -
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N59 ;File - G code gallery test part.Z3  
N60 G90 G00 X-38.3798 Y10.8563  
N61 Z100.  
N62 Z67.5  
N63 G01 Y6.5262 Z65. F50.  
N64 G17 G02 X-45. Y5.2786 I-11.6202 J43.4738  
N65 G01 Y45. F100.  
N66 X-38.3798 F250.  
N67 Y6.5262  
N68 G03 X-31.7596 Y8.8626 I-11.6202 J43.4738  
N69 G01 Y45.  
N70 X-25.1393  
N71 Y12.4907  
N72 G03 X-18.5191 Y17.8449 I-24.8607 J37.5093  
N73 G01 Y45.  
N74 X-11.8989  
N75 Y26.0562  
N76 G03 X-5.2786 Y45. I-38.1011 J23.9438  
N77 G01 X-11.8989  
N78 G00 Z100.  
N79 Z67.5  
N80 G01 Z65. F50.  
N81 X-45. F250.  
N82 Y5.2786  
N83 G03 X-5.2786 Y45. I-5. J44.7214  
N84 G01 X-15.8989  
N85 G03 X-22.3989 Y38.5 I0 J-6.5 F750.  
N86 G01 Y32.  
N87 G00 Z100.  
N88 ;Operation - Rough Plunge 1  
N89 ;Tactic - Rough Plunge 1  
N90 ;Plan -  
N91 ;File - G code gallery test part.Z3  
N92 X-6.9286 Y-6.9286  
N93 Z72.  
N94 G01 Z67. F50.  
N95 Z51. F250.  
N96 Z72.  
N97 Y0  
N98 Z67. F50.  
N99 Z51. F250.  
N100 Z72.  
N101 Y6.9286  
N102 Z67. F50.  
N103 Z51. F250.  
N104 Z72.  
N105 X0  
N106 Z67. F50.  
N107 Z51. F250.  
N108 Z72.  
N109 X6.9286  
N110 Z67. F50.  
N111 Z51. F250.  
N112 Z72.  
N113 Y0  
N114 Z67. F50.  
N115 Z51. F250.  
N116 Z72.  
N117 X0

N118 Z67. F50.  
N119 Z51. F250.  
N120 Z72.  
N121 X6.9286 Y-6.9286  
N122 Z67. F50.  
N123 Z51. F250.  
N124 Z72.  
N125 X0  
N126 Z67. F50.  
N127 Z51. F250.  
N128 G00 Z100.  
N129 ;Operation - InterPath 1  
N130 ;Tactic - InterPath 1  
N131 ;Plan -  
N132 ;File - G code gallery test part.Z3  
N133 G01 X145. Y3.528 F250.  
N134 X145.4358 Z99.981 A-5.0003 C-90.  
N135 X145.8682 Z99.924 A-10.0001  
N136 X146.2941 Z99.8296 A-15.  
N137 X146.7101 Z99.6985 A-20.  
N138 X147.1131 Z99.5315 A-25.  
N139 X147.5 Z99.3301 A-29.9999  
N140 X147.8679 Z99.0958 A-35.0002  
N141 X148.2139 Z98.8302 A-40.0003  
N142 X148.5355 Z98.5355 A-45.  
N143 X148.8302 Z98.2139 A-49.9997  
N144 X149.0958 Z97.8679 A-54.9998  
N145 X149.3301 Z97.5 A-60.0001  
N146 X149.5315 Z97.1131 A-65.  
N147 X149.6985 Z96.7101 A-70.  
N148 X149.8296 Z96.2941 A-75.  
N149 X149.924 Z95.8682 A-79.9999  
N150 X149.981 Z95.4358 A-84.9997  
N151 X150. Z95. A-90.  
N152 Z1.8698  
N153 ;Operation - Spiralcut 1  
N154 ;Tactic - Spiralcut 1  
N155 ;Plan -  
N156 ;File - G code gallery test part.Z3  
N157 G00 X87.5  
N158 G01 X87.2222 Y3.278 Z2.2799 F50.  
N159 X86.9444 Y2.9804 Z2.6571  
N160 X86.6667 Y2.6398 Z2.9958  
N161 X86.3889 Y2.2609 Z3.2911  
N162 X86.1111 Y1.8493 Z3.5388  
N163 X85.8333 Y1.4109 Z3.7353  
N164 X85.5556 Y.9521 Z3.8777  
N165 X85.2778 Y.4795 Z3.964  
N166 X85. Y0 Z4.  
N167 G19 G03 Y-3.4641 Z-2. J0 K-4. F100.  
N168 Y3.4641 J3.4641 K2.  
N169 Y0 Z4. J-3.4641 K2.  
N170 G01 Z10. F250.  
N171 G03 Y-8.6603 Z-5. J0 K-10.  
N172 Y8.6603 J8.6603 K5.  
N173 Y0 Z10. J-8.6603 K5.  
N174 Y-3.8942 Z9.2106 J0 K-10.  
N175 Y-7.3499 Z.6925 J2.5312 K-5.9869 F750.  
N176 G01 Y-4.8186 Z-5.2944

N177 G00 X150.  
N178 Y-6.5 Z3.  
N179 X87.5  
N180 G01 X85. F50.  
N181 Z-3.5 F150.  
N182 G03 Y0 Z-10. J6.5 K0  
N183 Y8.6603 Z-5. J0 K10. F250.  
N184 Y0 Z10. J-8.6603 K5.  
N185 Y-8.6603 Z-5. J0 K-10.  
N186 Y0 Z-10. J8.6603 K5.  
N187 Y3.8942 Z-9.2106 J0 K10.  
N188 Y7.3499 Z-.6925 J-2.5312 K5.9869 F750.  
N189 G01 Y4.8186 Z5.2944  
N190 G00 X150.  
N191 M05  
N192 M09  
N193 ;End of program.  
N194 M02  
N195 TRAF00F  
N196 SUPA G91 G74 Z0.0  
N197 SUPA G74 X0.0 Y0.0 A0.0 C0.0  
N198 M30