

```
%
OMilltronicsBasic
N1 G40 G80 G49 G90 G00 G17
N2 G90X0.Y0.
(Programmed by Author)
(Tool 0 is 5 mm Flat Endmill.)
(SHAPE PARAMETERS)
N3 T0 M06
N4 S1000 M03
(Operation - Profilecut 1)
(Tactic - Profilecut 1)
(Plan - )
(File - G code gallery test part.Z3)
N5 G90 G00 X49. Y-30.
N6 G43 Z100. H0 M08
N7 Z52.5
N8 G01 Z50. F50.
N9 Y-23.5 F150.
N10 G17 G03 X42.5 Y-30. I0 J-6.5
N11 G02 X23.75 Y-40.8253 I-12.5 J0 F250.
N12 Y-19.1747 I6.25 J10.8253
N13 X42.5 Y-30. I6.25 J-10.8253
N14 G03 X49. Y-36.5 I6.5 J0 F750.
N15 G01 Y-30.
N16 G00 Z100.
(Operation - Profilecut 2)
(Tactic - Profilecut 2)
(Plan - )
(File - G code gallery test part.Z3)
N17 X-35. Y-44.
N18 Z52.5
N19 G01 Z50. F50.
N20 X-28.5 F150.
N21 G03 X-35. Y-37.5 I-6.5 J0
N22 G02 X-37.5 Y-35. I0 J2.5 F250.
N23 G01 Y-25.
N24 G02 X-35. Y-22.5 I2.5 J0
N25 G01 X-25.
N26 G02 X-22.5 Y-25. I0 J-2.5
N27 G01 Y-35.
N28 G02 X-25. Y-37.5 I-2.5 J0
N29 G01 X-35.
N30 G03 X-41.5 Y-44. I0 J-6.5 F750.
N31 G01 X-35.
N32 G00 Z100.
N33 M09
(Tool 0 is 10 mm Flat Endmill.)
(SHAPE PARAMETERS)
N34 G91 G28 Z0
N35 G90
N36 T0 M06
N37 S1000 M03
(Operation - Zigzagcut 1)
(Tactic - Zigzagcut 1)
(Plan - )
(File - G code gallery test part.Z3)
N38 G90 G00 X-38.3798 Y10.8563
N39 G43 Z100. H0 M08
N40 Z67.5
```

N41 G01 Y6.5262 Z65. F50.
N42 G17 G02 X-45. Y5.2786 I-11.6202 J43.4738
N43 G01 Y45. F100.
N44 X-38.3798 F250.
N45 Y6.5262
N46 G03 X-31.7596 Y8.8626 I-11.6202 J43.4738
N47 G01 Y45.
N48 X-25.1393
N49 Y12.4907
N50 G03 X-18.5191 Y17.8449 I-24.8607 J37.5093
N51 G01 Y45.
N52 X-11.8989
N53 Y26.0562
N54 G03 X-5.2786 Y45. I-38.1011 J23.9438
N55 G01 X-11.8989
N56 G00 Z100.
N57 Z67.5
N58 G01 Z65. F50.
N59 X-45. F250.
N60 Y5.2786
N61 G03 X-5.2786 Y45. I-5. J44.7214
N62 G01 X-15.8989
N63 G03 X-22.3989 Y38.5 I0 J-6.5 F750.
N64 G01 Y32.
N65 G00 Z100.
(Operation - Rough Plunge 1)
(Tactic - Rough Plunge 1)
(Plan -)
(File - G code gallery test part.Z3)
N66 X-6.9286 Y-6.9286
N67 Z72.
N68 G01 Z67. F50.
N69 Z51. F250.
N70 Z72.
N71 Y0
N72 Z67. F50.
N73 Z51. F250.
N74 Z72.
N75 Y6.9286
N76 Z67. F50.
N77 Z51. F250.
N78 Z72.
N79 X0
N80 Z67. F50.
N81 Z51. F250.
N82 Z72.
N83 X6.9286
N84 Z67. F50.
N85 Z51. F250.
N86 Z72.
N87 Y0
N88 Z67. F50.
N89 Z51. F250.
N90 Z72.
N91 X0
N92 Z67. F50.
N93 Z51. F250.
N94 Z72.
N95 X6.9286 Y-6.9286

N96 Z67. F50.
N97 Z51. F250.
N98 Z72.
N99 X0
N100 Z67. F50.
N101 Z51. F250.
N102 G00 Z100.
(Operation - InterPath 1)
(Tactic - InterPath 1)
(Plan -)
(File - G code gallery test part.Z3)
N103 G01 X145. Y3.528 F250.
N104 X145.4358 Z99.981
N105 X145.8682 Z99.924
N106 X146.2941 Z99.8296
N107 X146.7101 Z99.6985
N108 X147.1131 Z99.5315
N109 X147.5 Z99.3301
N110 X147.8679 Z99.0958
N111 X148.2139 Z98.8302
N112 X148.5355 Z98.5355
N113 X148.8302 Z98.2139
N114 X149.0958 Z97.8679
N115 X149.3301 Z97.5
N116 X149.5315 Z97.1131
N117 X149.6985 Z96.7101
N118 X149.8296 Z96.2941
N119 X149.924 Z95.8682
N120 X149.981 Z95.4358
N121 X150. Z95.
N122 Z1.8698
(Operation - Spiralcut 1)
(Tactic - Spiralcut 1)
(Plan -)
(File - G code gallery test part.Z3)
N123 G00 X87.5
N124 G01 X87.2222 Y3.278 Z2.2799 F50.
N125 X86.9444 Y2.9804 Z2.6571
N126 X86.6667 Y2.6398 Z2.9958
N127 X86.3889 Y2.2609 Z3.2911
N128 X86.1111 Y1.8493 Z3.5388
N129 X85.8333 Y1.4109 Z3.7353
N130 X85.5556 Y.9521 Z3.8777
N131 X85.2778 Y.4795 Z3.964
N132 X85. Y0 Z4.
N133 G19 G03 Y-3.4641 Z-2. J0 K-4. F100.
N134 Y3.4641 J3.4641 K2.
N135 Y0 Z4. J-3.4641 K2.
N136 G01 Z10. F250.
N137 G03 Y-8.6603 Z-5. J0 K-10.
N138 Y8.6603 J8.6603 K5.
N139 Y0 Z10. J-8.6603 K5.
N140 Y-3.8942 Z9.2106 J0 K-10.
N141 Y-7.3499 Z.6925 J2.5312 K-5.9869 F750.
N142 G01 Y-4.8186 Z-5.2944
N143 G00 X150.
N144 Y-6.5 Z3.
N145 X87.5
N146 G01 X85. F50.

N147 Z-3.5 F150.
N148 G03 Y0 Z-10. J6.5 K0
N149 Y8.6603 Z-5. J0 K10. F250.
N150 Y0 Z10. J-8.6603 K5.
N151 Y-8.6603 Z-5. J0 K-10.
N152 Y0 Z-10. J8.6603 K5.
N153 Y3.8942 Z-9.2106 J0 K10.
N154 Y7.3499 Z-.6925 J-2.5312 K5.9869 F750.
N155 G01 Y4.8186 Z5.2944
N156 G00 X150.
N157 G91 G28 Z0 M05
N158 G91 G28 X0 Y0 M09
(End of program.)
N159 G90
N160 M30
%