

```

%
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 X1.9291 Y-1.1811
N6 G43 Z3.937 H0 M08
N7 Z2.0669
N8 G01 Z1.9685 F1.969
N9 Y-.9252 F5.906
N10 G17 G03 X42.5 Y-30. Z50. I47.0709 J-29.0748
N11 G02 X23.75 Y-40.8253 I-12.5 J0 F9.843
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 F29.528
N15 G01 X1.9291 Y-1.1811 Z1.9685
N16 G00 Z3.937
(Operation - Profilecut 2)
(Tactic - Profilecut 2)
(Plan - )
(File - G code gallery test part.Z3)
N17 X-1.378 Y-1.7323
N18 Z2.0669
N19 G01 Z1.9685 F1.969
N20 X-1.122 F5.906
N21 G03 X-35. Y-37.5 Z50. I-33.878 J-42.2677
N22 G02 X-37.5 Y-35. I0 J2.5 F9.843
N23 G01 X-1.4764 Y-.9843 Z1.9685
N24 G02 X-35. Y-22.5 Z50. I-33.5236 J-24.0157
N25 G01 X-.9843 Y-.8858 Z1.9685
N26 G02 X-22.5 Y-25. Z50. I-24.0157 J-24.1142
N27 G01 X-.8858 Y-1.378 Z1.9685
N28 G02 X-25. Y-37.5 Z50. I-24.1142 J-33.622
N29 G01 X-1.378 Y-1.4764 Z1.9685
N30 G03 X-41.5 Y-44. Z50. I-33.622 J-42.5236 F29.528
N31 G01 X-1.378 Y-1.7323 Z1.9685
N32 G00 Z3.937
N33 M09
(Tool 0 is 10 mm Flat Endmill.)
(SHAPE PARAMETERS)
N34 X0 Y0
N35 G40
N36 M05
N37 M01
N38 T0 M06
N39 S1000 M03
(Operation - Zigzagcut 1)
(Tactic - Zigzagcut 1)
(Plan - )
(File - G code gallery test part.Z3)
N40 G90 G00 X-1.511 Y.4274
N41 G43 Z3.937 H0 M08

```

N42 Z2.6575
N43 G01 Y.2569 Z2.5591 F1.969
N44 G17 G02 X-45. Y5.2786 Z65. I-48.489 J49.7431
N45 G01 X-1.7717 Y1.7717 Z2.5591 F3.937
N46 X-1.511 F9.843
N47 Y.2569
N48 G03 X-31.7596 Y8.8626 Z65. I-48.489 J49.7431
N49 G01 X-1.2504 Y1.7717 Z2.5591
N50 X-.9897
N51 Y.4918
N52 G03 X-18.5191 Y17.8449 Z65. I-49.0103 J49.5082
N53 G01 X-.7291 Y1.7717 Z2.5591
N54 X-.4685
N55 Y1.0258
N56 G03 X-5.2786 Y45. Z65. I-49.5315 J48.9742
N57 G01 X-.4685 Y1.7717 Z2.5591
N58 G00 Z3.937
N59 Z2.6575
N60 G01 Z2.5591 F1.969
N61 X-1.7717 F9.843
N62 Y.2078
N63 G03 X-5.2786 Y45. Z65. I-48.2283 J49.7922
N64 G01 X-.6259 Y1.7717 Z2.5591
N65 G03 X-22.3989 Y38.5 Z65. I-15.2729 J36.7283 F29.528
N66 G01 X-.8818 Y1.2598 Z2.5591
N67 G00 Z3.937
(Operation - Rough Plunge 1)
(Tactic - Rough Plunge 1)
(Plan -)
(File - G code gallery test part.Z3)
N68 X-.2728 Y-.2728
N69 Z2.8346
N70 G01 Z2.6378 F1.969
N71 Z2.0079 F9.843
N72 Z2.8346
N73 Y0
N74 Z2.6378 F1.969
N75 Z2.0079 F9.843
N76 Z2.8346
N77 Y.2728
N78 Z2.6378 F1.969
N79 Z2.0079 F9.843
N80 Z2.8346
N81 X0
N82 Z2.6378 F1.969
N83 Z2.0079 F9.843
N84 Z2.8346
N85 X.2728
N86 Z2.6378 F1.969
N87 Z2.0079 F9.843
N88 Z2.8346
N89 Y0
N90 Z2.6378 F1.969
N91 Z2.0079 F9.843
N92 Z2.8346
N93 X0
N94 Z2.6378 F1.969
N95 Z2.0079 F9.843
N96 Z2.8346

N97 X.2728 Y-.2728
N98 Z2.6378 F1.969
N99 Z2.0079 F9.843
N100 Z2.8346
N101 X0
N102 Z2.6378 F1.969
N103 Z2.0079 F9.843
N104 G00 Z3.937
(Operation - InterPath 1)
(Tactic - InterPath 1)
(Plan -)
(File - G code gallery test part.Z3)
N105 G01 X5.7087 Y.1389 F9.843
N106 X5.7258 Z3.9363
N107 X5.7428 Z3.934
N108 X5.7596 Z3.9303
N109 X5.776 Z3.9251
N110 X5.7919 Z3.9186
N111 X5.8071 Z3.9106
N112 X5.8216 Z3.9014
N113 X5.8352 Z3.891
N114 X5.8479 Z3.8794
N115 X5.8595 Z3.8667
N116 X5.8699 Z3.8531
N117 X5.8791 Z3.8386
N118 X5.8871 Z3.8234
N119 X5.8936 Z3.8075
N120 X5.8988 Z3.7911
N121 X5.9025 Z3.7743
N122 X5.9048 Z3.7573
N123 X5.9055 Z3.7402
N124 Z.0736
(Operation - Spiralcut 1)
(Tactic - Spiralcut 1)
(Plan -)
(File - G code gallery test part.Z3)
N125 G00 X3.4449
N126 G01 X3.4339 Y.1291 Z.0898 F1.969
N127 X3.423 Y.1173 Z.1046
N128 X3.4121 Y.1039 Z.1179
N129 X3.4011 Y.089 Z.1296
N130 X3.3902 Y.0728 Z.1393
N131 X3.3793 Y.0555 Z.1471
N132 X3.3683 Y.0375 Z.1527
N133 X3.3574 Y.0189 Z.1561
N134 X3.3465 Y0 Z.1575
N135 G19 G03 X85. Y-3.4641 Z-2. J0 K-.1575 F3.937
N136 Y3.4641 J3.4641 K2.
N137 Y0 Z4. J-3.4641 K2.
N138 G01 X3.3465 Z.3937 F9.843
N139 G03 X85. Y-8.6603 Z-5. J0 K-.3937
N140 Y8.6603 J8.6603 K5.
N141 Y0 Z10. J-8.6603 K5.
N142 Y-3.8942 Z9.2106 J0 K-10.
N143 Y-7.3499 Z.6925 J2.5312 K-5.9869 F29.528
N144 G01 X3.3465 Y-.1897 Z-.2084
N145 G00 X5.9055
N146 Y-.2559 Z.1181
N147 X3.4449

N148 G01 X3.3465 F1.969
N149 Z-.1378 F5.906
N150 G03 X85. Y0 Z-10. J.2559 K-3.3622
N151 Y8.6603 Z-5. J0 K10. F9.843
N152 Y0 Z10. J-8.6603 K5.
N153 Y-8.6603 Z-5. J0 K-10.
N154 Y0 Z-10. J8.6603 K5.
N155 Y3.8942 Z-9.2106 J0 K10.
N156 Y7.3499 Z-.6925 J-2.5312 K5.9869 F29.528
N157 G01 X3.3465 Y.1897 Z.2084
N158 G00 X5.9055
(End of program.)
N159 G49 G90 G00 Z0 M09
N160 X0 Y0 M05
N161 M30
%