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OMilltronics_Inch_MTC
N1 G90 G17 G49 G00
N2 (Programmed by Author)
N3 (Tool 0 is 5 mm Flat Endmill.)
N4 (SHAPE PARAMETERS)
N5 T0 M06
N6 S1000 M03
N7 (Operation - Profilecut 1)
N8 (Tactic - Profilecut 1)
N9 (Plan - )
N10 (File - G code gallery test part.Z3)
N11 G90 G00 X1.9291 Y-1.1811
N12 G43 Z3.937 H0 M08
N13 Z2.0669
N14 G01 Z1.9685 F1.969
N15 Y-.9252 F5.906
N16 G17 G03 X42.5 Y-30. Z50. I47.0709 J-29.0748
N17 G02 X23.75 Y-40.8253 I-12.5 J0 F9.843
N18 Y-19.1747 I6.25 J10.8253
N19 X42.5 Y-30. I6.25 J-10.8253
N20 G03 X49. Y-36.5 I6.5 J0 F29.528
N21 G01 X1.9291 Y-1.1811 Z1.9685
N22 G00 Z3.937
N23 (Operation - Profilecut 2)
N24 (Tactic - Profilecut 2)
N25 (Plan - )
N26 (File - G code gallery test part.Z3)
N27 X-1.378 Y-1.7323
N28 Z2.0669
N29 G01 Z1.9685 F1.969
N30 X-1.122 F5.906
N31 G03 X-35. Y-37.5 Z50. I-33.878 J-42.2677
N32 G02 X-37.5 Y-35. I0 J2.5 F9.843
N33 G01 X-1.4764 Y-.9843 Z1.9685
N34 G02 X-35. Y-22.5 Z50. I-33.5236 J-24.0157
N35 G01 X-.9843 Y-.8858 Z1.9685
N36 G02 X-22.5 Y-25. Z50. I-24.0157 J-24.1142
N37 G01 X-.8858 Y-1.378 Z1.9685
N38 G02 X-25. Y-37.5 Z50. I-24.1142 J-33.622
N39 G01 X-1.378 Y-1.4764 Z1.9685
N40 G03 X-41.5 Y-44. Z50. I-33.622 J-42.5236 F29.528
N41 G01 X-1.378 Y-1.7323 Z1.9685
N42 G00 Z3.937
N43 M09
N44 (Tool 0 is 10 mm Flat Endmill.)
N45 (SHAPE PARAMETERS)
N46 T0 M06
N47 S1000 M03
N48 (Operation - Zigzagcut 1)
N49 (Tactic - Zigzagcut 1)
N50 (Plan - )
N51 (File - G code gallery test part.Z3)
N52 G90 G00 X-1.511 Y.4274
N53 G43 Z3.937 H0 M08
N54 Z2.6575
N55 G01 Y.2569 Z2.5591 F1.969
N56 G17 G02 X-45. Y5.2786 Z65. I-48.489 J49.7431
N57 G01 X-1.7717 Y1.7717 Z2.5591 F3.937
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N58 X-1.511 F9.843
N59 Y.2569
N60 G03 X-31.7596 Y8.8626 Z65. I-48.489 J49.7431
N61 G01 X-1.2504 Y1.7717 Z2.5591
N62 X-.9897
N63 Y.4918
N64 G03 X-18.5191 Y17.8449 Z65. I-49.0103 J49.5082
N65 G01 X-.7291 Y1.7717 Z2.5591
N66 X-.4685
N67 Y1.0258
N68 G03 X-5.2786 Y45. Z65. I-49.5315 J48.9742
N69 G01 X-.4685 Y1.7717 Z2.5591
N70 G00 Z3.937
N71 Z2.6575
N72 G01 Z2.5591 F1.969
N73 X-1.7717 F9.843
N74 Y.2078
N75 G03 X-5.2786 Y45. Z65. I-48.2283 J49.7922
N76 G01 X-.6259 Y1.7717 Z2.5591
N77 G03 X-22.3989 Y38.5 Z65. I-15.2729 J36.7283 F29.528
N78 G01 X-.8818 Y1.2598 Z2.5591
N79 G00 Z3.937
N80 (Operation - Rough Plunge 1)
N81 (Tactic - Rough Plunge 1)
N82 (Plan -)
N83 (File - G code gallery test part.Z3)
N84 X-.2728 Y-.2728
N85 Z2.8346
N86 G01 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 Y.2728
N94 Z2.6378 F1.969
N95 Z2.0079 F9.843
N96 Z2.8346
N97 X0
N98 Z2.6378 F1.969
N99 Z2.0079 F9.843
N100 Z2.8346
N101 X.2728
N102 Z2.6378 F1.969
N103 Z2.0079 F9.843
N104 Z2.8346
N105 Y0
N106 Z2.6378 F1.969
N107 Z2.0079 F9.843
N108 Z2.8346
N109 X0
N110 Z2.6378 F1.969
N111 Z2.0079 F9.843
N112 Z2.8346
N113 X.2728 Y-.2728
N114 Z2.6378 F1.969
N115 Z2.0079 F9.843
N116 Z2.8346

N117 X0
N118 Z2.6378 F1.969
N119 Z2.0079 F9.843
N120 G00 Z3.937
N121 (Operation - InterPath 1)
N122 (Tactic - InterPath 1)
N123 (Plan -)
N124 (File - G code gallery test part.Z3)
N125 G01 X5.7087 Y.1389 F9.843
N126 X5.7258 Z3.9363
N127 X5.7428 Z3.934
N128 X5.7596 Z3.9303
N129 X5.776 Z3.9251
N130 X5.7919 Z3.9186
N131 X5.8071 Z3.9106
N132 X5.8216 Z3.9014
N133 X5.8352 Z3.891
N134 X5.8479 Z3.8794
N135 X5.8595 Z3.8667
N136 X5.8699 Z3.8531
N137 X5.8791 Z3.8386
N138 X5.8871 Z3.8234
N139 X5.8936 Z3.8075
N140 X5.8988 Z3.7911
N141 X5.9025 Z3.7743
N142 X5.9048 Z3.7573
N143 X5.9055 Z3.7402
N144 Z.0736
N145 (Operation - Spiralcut 1)
N146 (Tactic - Spiralcut 1)
N147 (Plan -)
N148 (File - G code gallery test part.Z3)
N149 G00 X3.4449
N150 G01 X3.4339 Y.1291 Z.0898 F1.969
N151 X3.423 Y.1173 Z.1046
N152 X3.4121 Y.1039 Z.1179
N153 X3.4011 Y.089 Z.1296
N154 X3.3902 Y.0728 Z.1393
N155 X3.3793 Y.0555 Z.1471
N156 X3.3683 Y.0375 Z.1527
N157 X3.3574 Y.0189 Z.1561
N158 X3.3465 Y0 Z.1575
N159 G19 G03 X85. Y-3.4641 Z-2. J0 K-.1575 F3.937
N160 Y3.4641 J3.4641 K2.
N161 Y0 Z4. J-3.4641 K2.
N162 G01 X3.3465 Z.3937 F9.843
N163 G03 X85. Y-8.6603 Z-5. J0 K-.3937
N164 Y8.6603 J8.6603 K5.
N165 Y0 Z10. J-8.6603 K5.
N166 Y-3.8942 Z9.2106 J0 K-10.
N167 Y-7.3499 Z.6925 J2.5312 K-5.9869 F29.528
N168 G01 X3.3465 Y-.1897 Z-.2084
N169 G00 X5.9055
N170 Y-.2559 Z.1181
N171 X3.4449
N172 G01 X3.3465 F1.969
N173 Z-.1378 F5.906
N174 G03 X85. Y0 Z-10. J.2559 K-3.3622
N175 Y8.6603 Z-5. J0 K10. F9.843

N176 Y0 Z10. J-8.6603 K5.
N177 Y-8.6603 Z-5. J0 K-10.
N178 Y0 Z-10. J8.6603 K5.
N179 Y3.8942 Z-9.2106 J0 K10.
N180 Y7.3499 Z-.6925 J-2.5312 K5.9869 F29.528
N181 G01 X3.3465 Y.1897 Z.2084
N182 G00 X5.9055
N183 G49 G90 G00 Z0 M05
N184 G91 G28 X0 Y0 M09
N185 (End of program.)
N186 G90
N187 M30
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