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BEGIN PGM TNC426_3X_Heidenhain MM
N1 ;Programmed by Author
N2 ;Tool 0 is 5 mm Flat Endmill.
N3 ;SHAPE PARAMETERS
N4 TOOL CALL 0 Z S1000 M06
N5 M08
N6 ;Operation - Profilecut 1
N7 ;Tactic - Profilecut 1
N8 ;Plan -
N9 ;File - G code gallery test part.Z3
N10 L X+49.000 Y-30.000 Z+100.000 FMAX
N11 L Z+52.500 FMAX
N12 L Z+50.000 F50.000
N13 L Y-23.500 F150.000
N14 CC X+49.000 Y-30.000 Z+50.000
N15 C X+42.500 Y-30.000 DR+
N16 CC X+30.000 Y-30.000 Z+50.000
N17 C X+23.750 Y-40.825 DR- F250.000
N18 CC X+30.000 Y-30.000 Z+50.000
N19 C X+23.750 Y-19.175 DR-
N20 CC X+30.000 Y-30.000 Z+50.000
N21 C X+42.500 Y-30.000 DR-
N22 CC X+49.000 Y-30.000 Z+50.000
N23 C X+49.000 Y-36.500 DR+ F750.000
N24 L Y-30.000
N25 L Z+100.000 FMAX
N26 ;Operation - Profilecut 2
N27 ;Tactic - Profilecut 2
N28 ;Plan -
N29 ;File - G code gallery test part.Z3
N30 L X-35.000 Y-44.000 FMAX
N31 L Z+52.500 FMAX
N32 L Z+50.000 F50.000
N33 L X-28.500 F150.000
N34 CC X-35.000 Y-44.000 Z+50.000
N35 C X-35.000 Y-37.500 DR+
N36 CC X-35.000 Y-35.000 Z+50.000
N37 C X-37.500 Y-35.000 DR- F250.000
N38 L Y-25.000
N39 CC X-35.000 Y-25.000 Z+50.000
N40 C X-35.000 Y-22.500 DR-
N41 L X-25.000
N42 CC X-25.000 Y-25.000 Z+50.000
N43 C X-22.500 Y-25.000 DR-
N44 L Y-35.000
N45 CC X-25.000 Y-35.000 Z+50.000
N46 C X-25.000 Y-37.500 DR-
N47 L X-35.000
N48 CC X-35.000 Y-44.000 Z+50.000
N49 C X-41.500 Y-44.000 DR+ F750.000
N50 L X-35.000
N51 L Z+100.000 FMAX
N52 M09
N53 ;Tool 0 is 10 mm Flat Endmill.
N54 ;SHAPE PARAMETERS
N55 TOOL CALL 0 Z S1000 M06
N56 M08
N57 ;Operation - Zigzagcut 1
N58 ;Tactic - Zigzagcut 1
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N59 ;Plan -
N60 ;File - G code gallery test part.Z3
N61 L X-38.380 Y+10.856 Z+100.000 FMAX
N62 L Z+67.500 FMAX
N63 L Y+6.526 Z+65.000 F50.000
N64 CC X-50.000 Y+50.000 Z+65.000
N65 C X-45.000 Y+5.279 DR-
N66 L Y+45.000 F100.000
N67 L X-38.380 F250.000
N68 L Y+6.526
N69 CC X-50.000 Y+50.000 Z+65.000
N70 C X-31.760 Y+8.863 DR+
N71 L Y+45.000
N72 L X-25.139
N73 L Y+12.491
N74 CC X-50.000 Y+50.000 Z+65.000
N75 C X-18.519 Y+17.845 DR+
N76 L Y+45.000
N77 L X-11.899
N78 L Y+26.056
N79 CC X-50.000 Y+50.000 Z+65.000
N80 C X-5.279 Y+45.000 DR+
N81 L X-11.899
N82 L Z+100.000 FMAX
N83 L Z+67.500 FMAX
N84 L Z+65.000 F50.000
N85 L X-45.000 F250.000
N86 L Y+5.279
N87 CC X-50.000 Y+50.000 Z+65.000
N88 C X-5.279 Y+45.000 DR+
N89 L X-15.899
N90 CC X-15.899 Y+38.500 Z+65.000
N91 C X-22.399 Y+38.500 DR+ F750.000
N92 L Y+32.000
N93 L Z+100.000 FMAX
N94 ;Operation - Rough Plunge 1
N95 ;Tactic - Rough Plunge 1
N96 ;Plan -
N97 ;File - G code gallery test part.Z3
N98 L X-6.929 Y-6.929 FMAX
N99 L Z+72.000 FMAX
N100 L Z+67.000 F50.000
N101 L Z+51.000 F250.000
N102 L Z+72.000
N103 L Y+0.0
N104 L Z+67.000 F50.000
N105 L Z+51.000 F250.000
N106 L Z+72.000
N107 L Y+6.929
N108 L Z+67.000 F50.000
N109 L Z+51.000 F250.000
N110 L Z+72.000
N111 L X+0.0
N112 L Z+67.000 F50.000
N113 L Z+51.000 F250.000
N114 L Z+72.000
N115 L X+6.929
N116 L Z+67.000 F50.000
N117 L Z+51.000 F250.000

N118 L Z+72.000
N119 L Y+0.0
N120 L Z+67.000 F50.000
N121 L Z+51.000 F250.000
N122 L Z+72.000
N123 L X+0.0
N124 L Z+67.000 F50.000
N125 L Z+51.000 F250.000
N126 L Z+72.000
N127 L X+6.929 Y-6.929
N128 L Z+67.000 F50.000
N129 L Z+51.000 F250.000
N130 L Z+72.000
N131 L X+0.0
N132 L Z+67.000 F50.000
N133 L Z+51.000 F250.000
N134 L Z+100.000 FMAX
N135 ;Operation - InterPath 1
N136 ;Tactic - InterPath 1
N137 ;Plan -
N138 ;File - G code gallery test part.Z3
N139 L X+145.000 Y+3.528 F250.000
N140 L X+145.436 Z+99.981
N141 L X+145.868 Z+99.924
N142 L X+146.294 Z+99.830
N143 L X+146.710 Z+99.698
N144 L X+147.113 Z+99.532
N145 L X+147.500 Z+99.330
N146 L X+147.868 Z+99.096
N147 L X+148.214 Z+98.830
N148 L X+148.536 Z+98.536
N149 L X+148.830 Z+98.214
N150 L X+149.096 Z+97.868
N151 L X+149.330 Z+97.500
N152 L X+149.532 Z+97.113
N153 L X+149.698 Z+96.710
N154 L X+149.830 Z+96.294
N155 L X+149.924 Z+95.868
N156 L X+149.981 Z+95.436
N157 L X+150.000 Z+95.000
N158 L Z+1.870
N159 ;Operation - Spiralcut 1
N160 ;Tactic - Spiralcut 1
N161 ;Plan -
N162 ;File - G code gallery test part.Z3
N163 L X+87.500 FMAX
N164 L X+87.222 Y+3.278 Z+2.280 F50.000
N165 L X+86.944 Y+2.980 Z+2.657
N166 L X+86.667 Y+2.640 Z+2.996
N167 L X+86.389 Y+2.261 Z+3.291
N168 L X+86.111 Y+1.849 Z+3.539
N169 L X+85.833 Y+1.411 Z+3.735
N170 L X+85.556 Y+.952 Z+3.878
N171 L X+85.278 Y+.480 Z+3.964
N172 L X+85.000 Y+0.0 Z+4.000
N173 CC X+85.000 Y+0.0 Z+0.0
N174 C Y-3.464 Z-2.000 DR+ F100.000
N175 CC X+85.000 Y+0.0 Z+0.0
N176 C Y+3.464 Z-2.000 DR+

N177 CC X+85.000 Y+0.0 Z+0.0
N178 C Y+0.0 Z+4.000 DR+
N179 L Z+10.000 F250.000
N180 CC X+85.000 Y+0.0 Z+0.0
N181 C Y-8.660 Z-5.000 DR+
N182 CC X+85.000 Y+0.0 Z+0.0
N183 C Y+8.660 Z-5.000 DR+
N184 CC X+85.000 Y+0.0 Z+0.0
N185 C Y+0.0 Z+10.000 DR+
N186 CC X+85.000 Y+0.0 Z+0.0
N187 C Y-3.894 Z+9.211 DR+
N188 CC X+85.000 Y-1.363 Z+3.224
N189 C Y-7.350 Z+.692 DR+ F750.000
N190 L Y-4.819 Z-5.294
N191 L X+150.000 FMAX
N192 L Y-6.500 Z+3.000 FMAX
N193 L X+87.500 FMAX
N194 L X+85.000 F50.000
N195 L Z-3.500 F150.000
N196 CC X+85.000 Y+0.0 Z-3.500
N197 C Y+0.0 Z-10.000 DR+
N198 CC X+85.000 Y+0.0 Z+0.0
N199 C Y+8.660 Z-5.000 DR+ F250.000
N200 CC X+85.000 Y+0.0 Z+0.0
N201 C Y+0.0 Z+10.000 DR+
N202 CC X+85.000 Y+0.0 Z+0.0
N203 C Y-8.660 Z-5.000 DR+
N204 CC X+85.000 Y+0.0 Z+0.0
N205 C Y+0.0 Z-10.000 DR+
N206 CC X+85.000 Y+0.0 Z+0.0
N207 C Y+3.894 Z-9.211 DR+
N208 CC X+85.000 Y+1.363 Z-3.224
N209 C Y+7.350 Z-.692 DR+ F750.000
N210 L Y+4.819 Z+5.294
N211 L X+150.000 FMAX
N212 M05
N213 M09
N214 ;End of program.
N215 L Z0 FMAX M92
N216 L X-Q92 Y0 FMAX M92
N217 L M02
END PGM TNC426_3X_Heidenhain MM