

```

%
N1 G90 G17 G49 G00
(Programmed by Author)
(Tool 0 is 5 mm Flat Endmill.)
(SHAPE PARAMETERS)
N2 T0 M06
N3 S1000 M03
(Operation - Profilecut 1)
(Tactic - Profilecut 1)
(Plan - )
(File - G code gallery test part.Z3)
N4 G90 G00 X49. Y-30.
N5 G43 Z100. H0 M08
N6 Z52.5
N7 G01 Z50. F1.969
N8 Y-23.5 F5.906
N9 G17 G03 X42.5 Y-30. I0 J-6.5
N10 G02 X23.75 Y-40.8253 I-12.5 J0 F9.843
N11 Y-19.1747 I6.25 J10.8253
N12 X42.5 Y-30. I6.25 J-10.8253
N13 G03 X49. Y-36.5 I6.5 J0 F29.528
N14 G01 Y-30.
N15 G00 Z100.
(Operation - Profilecut 2)
(Tactic - Profilecut 2)
(Plan - )
(File - G code gallery test part.Z3)
N16 X-35. Y-44.
N17 Z52.5
N18 G01 Z50. F1.969
N19 X-28.5 F5.906
N20 G03 X-35. Y-37.5 I-6.5 J0
N21 G02 X-37.5 Y-35. I0 J2.5 F9.843
N22 G01 Y-25.
N23 G02 X-35. Y-22.5 I2.5 J0
N24 G01 X-25.
N25 G02 X-22.5 Y-25. I0 J-2.5
N26 G01 Y-35.
N27 G02 X-25. Y-37.5 I-2.5 J0
N28 G01 X-35.
N29 G03 X-41.5 Y-44. I0 J-6.5 F29.528
N30 G01 X-35.
N31 G00 Z100.
N32 M09
(Tool 0 is 10 mm Flat Endmill.)
(SHAPE PARAMETERS)
N33 G91 G28 Z0
N34 G90
N35 T0 M06
N36 S1000 M03
(Operation - Zigzagcut 1)
(Tactic - Zigzagcut 1)
(Plan - )
(File - G code gallery test part.Z3)
N37 G90 G00 X-38.3798 Y10.8563
N38 G43 Z100. H0 M08
N39 Z67.5
N40 G01 Y6.5262 Z65. F1.969
N41 G17 G02 X-45. Y5.2786 I-11.6202 J43.4738

```

N42 G01 Y45. F3.937
N43 X-38.3798 F9.843
N44 Y6.5262
N45 G03 X-31.7596 Y8.8626 I-11.6202 J43.4738
N46 G01 Y45.
N47 X-25.1393
N48 Y12.4907
N49 G03 X-18.5191 Y17.8449 I-24.8607 J37.5093
N50 G01 Y45.
N51 X-11.8989
N52 Y26.0562
N53 G03 X-5.2786 Y45. I-38.1011 J23.9438
N54 G01 X-11.8989
N55 G00 Z100.
N56 Z67.5
N57 G01 Z65. F1.969
N58 X-45. F9.843
N59 Y5.2786
N60 G03 X-5.2786 Y45. I-5. J44.7214
N61 G01 X-15.8989
N62 G03 X-22.3989 Y38.5 I0 J-6.5 F29.528
N63 G01 Y32.
N64 G00 Z100.
(Operation - Rough Plunge 1)
(Tactic - Rough Plunge 1)
(Plan -)
(File - G code gallery test part.Z3)
N65 X-6.9286 Y-6.9286
N66 Z72.
N67 G01 Z67. F1.969
N68 Z51. F9.843
N69 Z72.
N70 Y0
N71 Z67. F1.969
N72 Z51. F9.843
N73 Z72.
N74 Y6.9286
N75 Z67. F1.969
N76 Z51. F9.843
N77 Z72.
N78 X0
N79 Z67. F1.969
N80 Z51. F9.843
N81 Z72.
N82 X6.9286
N83 Z67. F1.969
N84 Z51. F9.843
N85 Z72.
N86 Y0
N87 Z67. F1.969
N88 Z51. F9.843
N89 Z72.
N90 X0
N91 Z67. F1.969
N92 Z51. F9.843
N93 Z72.
N94 X6.9286 Y-6.9286
N95 Z67. F1.969
N96 Z51. F9.843

N97 Z72.
N98 X0
N99 Z67. F1.969
N100 Z51. F9.843
N101 G00 Z100.
(Operation - InterPath 1)
(Tactic - InterPath 1)
(Plan -)
(File - G code gallery test part.Z3)
N102 G01 X145. Y3.528 F9.843
N103 X145.4358 Z99.981
N104 X145.8682 Z99.924
N105 X146.2941 Z99.8296
N106 X146.7101 Z99.6985
N107 X147.1131 Z99.5315
N108 X147.5 Z99.3301
N109 X147.8679 Z99.0958
N110 X148.2139 Z98.8302
N111 X148.5355 Z98.5355
N112 X148.8302 Z98.2139
N113 X149.0958 Z97.8679
N114 X149.3301 Z97.5
N115 X149.5315 Z97.1131
N116 X149.6985 Z96.7101
N117 X149.8296 Z96.2941
N118 X149.924 Z95.8682
N119 X149.981 Z95.4358
N120 X150. Z95.
N121 Z1.8698
(Operation - Spiralcut 1)
(Tactic - Spiralcut 1)
(Plan -)
(File - G code gallery test part.Z3)
N122 G00 X87.5
N123 G01 X87.2222 Y3.278 Z2.2799 F1.969
N124 X86.9444 Y2.9804 Z2.6571
N125 X86.6667 Y2.6398 Z2.9958
N126 X86.3889 Y2.2609 Z3.2911
N127 X86.1111 Y1.8493 Z3.5388
N128 X85.8333 Y1.4109 Z3.7353
N129 X85.5556 Y.9521 Z3.8777
N130 X85.2778 Y.4795 Z3.964
N131 X85. Y0 Z4.
N132 G19 G03 Y-3.4641 Z-2. J0 K-4. F3.937
N133 Y3.4641 J3.4641 K2.
N134 Y0 Z4. J-3.4641 K2.
N135 G01 Z10. F9.843
N136 G03 Y-8.6603 Z-5. J0 K-10.
N137 Y8.6603 J8.6603 K5.
N138 Y0 Z10. J-8.6603 K5.
N139 Y-3.8942 Z9.2106 J0 K-10.
N140 Y-7.3499 Z.6925 J2.5312 K-5.9869 F29.528
N141 G01 Y-4.8186 Z-5.2944
N142 G00 X150.
N143 Y-6.5 Z3.
N144 X87.5
N145 G01 X85. F1.969
N146 Z-3.5 F5.906
N147 G03 Y0 Z-10. J6.5 K0

N148 Y8.6603 Z-5. J0 K10. F9.843
N149 Y0 Z10. J-8.6603 K5.
N150 Y-8.6603 Z-5. J0 K-10.
N151 Y0 Z-10. J8.6603 K5.
N152 Y3.8942 Z-9.2106 J0 K10.
N153 Y7.3499 Z-.6925 J-2.5312 K5.9869 F29.528
N154 G01 Y4.8186 Z5.2944
N155 G00 X150.
N156 G91 G28 Z0 M05
N157 G91 G28 X0 Y0 M09
(End of program.)
N158 M30
%