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OZW_Fadal_3X
([yyyy-mm-dd hh:mm:ss] 2020-12-04 11:46:49)
N1 G90 G17 G49 G00
N2 (PROGRAMMED BY AUTHOR)
N3 (TOOL 0 IS 5 MM FLAT ENDMILL.)
N4 (SHAPE PARAMETERS)
N5 T0 M06
N6 G91 G28 Z0
N7 G90
N8 T0
N9 S1000 M03
N10 (OPERATION - PROFILECUT 1)
N11 (TACTIC - PROFILECUT 1)
N12 (PLAN -)
N13 (FILE - G CODE GALLERY TEST PART.Z3)
N14 G90 G00 X49. Y-30.
N15 Z100. H0 M08
N16 Z52.5
N17 G01 Z50. F50.
N18 Y-23.5 F150.
N19 G17 G03 X42.5 Y-30. I0 J-6.5
N20 G02 X23.75 Y-40.825 I-12.5 J0 F250.
N21 Y-19.175 I6.25 J10.825
N22 X42.5 Y-30. I6.25 J-10.825
N23 G03 X49. Y-36.5 I6.5 J0 F750.
N24 G01 Y-30.
N25 G00 Z100.
N26 (OPERATION - PROFILECUT 2)
N27 (TACTIC - PROFILECUT 2)
N28 (PLAN -)
N29 (FILE - G CODE GALLERY TEST PART.Z3)
N30 X-35. Y-44.
N31 Z52.5
N32 G01 Z50. F50.
N33 X-28.5 F150.
N34 G03 X-35. Y-37.5 I-6.5 J0
N35 G02 X-37.5 Y-35. I0 J2.5 F250.
N36 G01 Y-25.
N37 G02 X-35. Y-22.5 I2.5 J0
N38 G01 X-25.
N39 G02 X-22.5 Y-25. I0 J-2.5
N40 G01 Y-35.
N41 G02 X-25. Y-37.5 I-2.5 J0
N42 G01 X-35.
N43 G03 X-41.5 Y-44. I0 J-6.5 F750.
N44 G01 X-35.
N45 G00 Z100.
N46 M09
N47 (TOOL 0 IS 10 MM FLAT ENDMILL.)
N48 (SHAPE PARAMETERS)
N49 G91 G28 Z0
N50 G90
N51 T0 M06
N52 G91 G28 Z0
N53 G90
N54 T0
N55 S1000 M03
N56 (OPERATION - ZIGZAGCUT 1)

N57 (TACTIC - ZIGZAGCUT 1)
N58 (PLAN -)
N59 (FILE - G CODE GALLERY TEST PART.Z3)
N60 G90 G00 X-38.38 Y10.856
N61 Z100. H0 M08
N62 Z67.5
N63 G01 Y6.526 Z65. F50.
N64 G17 G02 X-45. Y5.279 I-11.62 J43.474
N65 G01 Y45. F100.
N66 X-38.38 F250.
N67 Y6.526
N68 G03 X-31.76 Y8.863 I-11.62 J43.474
N69 G01 Y45.
N70 X-25.139
N71 Y12.491
N72 G03 X-18.519 Y17.845 I-24.861 J37.509
N73 G01 Y45.
N74 X-11.899
N75 Y26.056
N76 G03 X-5.279 Y45. I-38.101 J23.944
N77 G01 X-11.899
N78 G00 Z100.
N79 Z67.5
N80 G01 Z65. F50.
N81 X-45. F250.
N82 Y5.279
N83 G03 X-5.279 Y45. I-5. J44.721
N84 G01 X-15.899
N85 G03 X-22.399 Y38.5 I0 J-6.5 F750.
N86 G01 Y32.
N87 G00 Z100.
N88 (OPERATION - ROUGH PLUNGE 1)
N89 (TACTIC - ROUGH PLUNGE 1)
N90 (PLAN -)
N91 (FILE - G CODE GALLERY TEST PART.Z3)
N92 X-6.929 Y-6.929
N93 Z72.
N94 G01 Z67. F50.
N95 Z51. F250.
N96 Z72.
N97 Y0
N98 Z67. F50.
N99 Z51. F250.
N100 Z72.
N101 Y6.929
N102 Z67. F50.
N103 Z51. F250.
N104 Z72.
N105 X0
N106 Z67. F50.
N107 Z51. F250.
N108 Z72.
N109 X6.929
N110 Z67. F50.
N111 Z51. F250.
N112 Z72.
N113 Y0
N114 Z67. F50.
N115 Z51. F250.

N116 Z72.
N117 X0
N118 Z67. F50.
N119 Z51. F250.
N120 Z72.
N121 X6.929 Y-6.929
N122 Z67. F50.
N123 Z51. F250.
N124 Z72.
N125 X0
N126 Z67. F50.
N127 Z51. F250.
N128 G00 Z100.
N129 (OPERATION - INTERPATH 1)
N130 (TACTIC - INTERPATH 1)
N131 (PLAN -)
N132 (FILE - G CODE GALLERY TEST PART.Z3)
N133 G01 X145. Y3.528 F250.
N134 X145.436 Z99.981
N135 X145.868 Z99.924
N136 X146.294 Z99.83
N137 X146.71 Z99.698
N138 X147.113 Z99.532
N139 X147.5 Z99.33
N140 X147.868 Z99.096
N141 X148.214 Z98.83
N142 X148.536 Z98.536
N143 X148.83 Z98.214
N144 X149.096 Z97.868
N145 X149.33 Z97.5
N146 X149.532 Z97.113
N147 X149.698 Z96.71
N148 X149.83 Z96.294
N149 X149.924 Z95.868
N150 X149.981 Z95.436
N151 X150. Z95.
N152 Z1.87
N153 (OPERATION - SPIRALCUT 1)
N154 (TACTIC - SPIRALCUT 1)
N155 (PLAN -)
N156 (FILE - G CODE GALLERY TEST PART.Z3)
N157 G00 X87.5
N158 G01 X87.222 Y3.278 Z2.28 F50.
N159 X86.944 Y2.98 Z2.657
N160 X86.667 Y2.64 Z2.996
N161 X86.389 Y2.261 Z3.291
N162 X86.111 Y1.849 Z3.539
N163 X85.833 Y1.411 Z3.735
N164 X85.556 Y.952 Z3.878
N165 X85.278 Y.48 Z3.964
N166 X85. Y0 Z4.
N167 G19 G03 Y-3.464 Z-2. J0 K-4. F100.
N168 Y3.464 J3.464 K2.
N169 Y0 Z4. J-3.464 K2.
N170 G01 Z10. F250.
N171 G03 Y-8.66 Z-5. J0 K-10.
N172 Y8.66 J8.66 K5.
N173 Y0 Z10. J-8.66 K5.
N174 Y-3.894 Z9.211 J0 K-10.

N175 Y-7.35 Z.692 J2.531 K-5.987 F750.
N176 G01 Y-4.819 Z-5.294
N177 G00 X150.
N178 Y-6.5 Z3.
N179 X87.5
N180 G01 X85. F50.
N181 Z-3.5 F150.
N182 G03 Y0 Z-10. J6.5 K0
N183 Y8.66 Z-5. J0 K10. F250.
N184 Y0 Z10. J-8.66 K5.
N185 Y-8.66 Z-5. J0 K-10.
N186 Y0 Z-10. J8.66 K5.
N187 Y3.894 Z-9.211 J0 K10.
N188 Y7.35 Z-.692 J-2.531 K5.987 F750.
N189 G01 Y4.819 Z5.294
N190 G00 X150.
N191 G91 G28 Z0 M05
N192 G91 G28 X0 Y0 M09
N193 (END OF PROGRAM.)
N194 M30
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