

%
OZW_GSK983M
([yyyy-mm-dd hh:mm:ss] 2020-12-04 12:11:02)
N1 G90 G94 G17
N2 (PROGRAMMED BY AUTHOR)
N3 (TOOL 0 IS 5 MM FLAT ENDMILL.)
N4 (SHAPE PARAMETERS)
N5 T0 M06
N6 T0
N7 (x= 0,y= 0,z= 500,Tool No= 0)
N8 S1000
N9 M03
N10 M08
N11 (OPERATION - PROFILECUT 1)
N12 (TACTIC - PROFILECUT 1)
N13 (PLAN - G CODE GALLERY TEST PART_CAM)
N14 (FILE - G CODE GALLERY TEST PART.Z3)
N15 G90 G00 X49.0 Y-30.0
N16 Z100.0
N17 Z52.5
N18 G01 Z50.0 F50.0
N19 Y-23.5 F150.0
N20 G17 G03 X42.5 Y-30.0 I0 J-6.5
N21 G02 X23.75 Y-40.825 I-12.5 J0 F250.0
N22 Y-19.175 I6.25 J10.825
N23 X42.5 Y-30.0 I6.25 J-10.825
N24 G03 X49.0 Y-36.5 I6.5 J0 F750.0
N25 G01 Y-30.0
N26 G00 Z100.0
N27 (OPERATION - PROFILECUT 2)
N28 (TACTIC - PROFILECUT 2)
N29 (PLAN - G CODE GALLERY TEST PART_CAM)
N30 (FILE - G CODE GALLERY TEST PART.Z3)
N31 X-35.0 Y-44.0
N32 Z52.5
N33 G01 Z50.0 F50.0
N34 X-28.5 F150.0
N35 G03 X-35.0 Y-37.5 I-6.5 J0
N36 G02 X-37.5 Y-35.0 I0 J2.5 F250.0
N37 G01 Y-25.0
N38 G02 X-35.0 Y-22.5 I2.5 J0
N39 G01 X-25.0
N40 G02 X-22.5 Y-25.0 I0 J-2.5
N41 G01 Y-35.0
N42 G02 X-25.0 Y-37.5 I-2.5 J0
N43 G01 X-35.0
N44 G03 X-41.5 Y-44.0 I0 J-6.5 F750.0
N45 G01 X-35.0
N46 G00 Z100.0
N47 M09
N48 (TOOL 0 IS 10 MM FLAT ENDMILL.)
N49 (SHAPE PARAMETERS)
N50 M05
N51 M06
N52 T0
N53 (x= -35,y= -44,z= 100,Tool No= 0)
N54 S1000
N55 M03
N56 M08

N57 (OPERATION - ZIGZAGCUT 1)
N58 (TACTIC - ZIGZAGCUT 1)
N59 (PLAN - G CODE GALLERY TEST PART_CAM)
N60 (FILE - G CODE GALLERY TEST PART.Z3)
N61 G90 G00 X-38.38 Y10.856
N62 Z100.0
N63 Z67.5
N64 G01 Y6.526 Z65.0 F50.0
N65 G17 G02 X-45.0 Y5.279 I-11.62 J43.474
N66 G01 Y45.0 F100.0
N67 X-38.38 F250.0
N68 Y6.526
N69 G03 X-31.76 Y8.863 I-11.62 J43.474
N70 G01 Y45.0
N71 X-25.139
N72 Y12.491
N73 G03 X-18.519 Y17.845 I-24.861 J37.509
N74 G01 Y45.0
N75 X-11.899
N76 Y26.056
N77 G03 X-5.279 Y45.0 I-38.101 J23.944
N78 G01 X-11.899
N79 G00 Z100.0
N80 Z67.5
N81 G01 Z65.0 F50.0
N82 X-45.0 F250.0
N83 Y5.279
N84 G03 X-5.279 Y45.0 I-5.0 J44.721
N85 G01 X-15.899
N86 G03 X-22.399 Y38.5 I0 J-6.5 F750.0
N87 G01 Y32.0
N88 G00 Z100.0
N89 (OPERATION - ROUGH PLUNGE 1)
N90 (TACTIC - ROUGH PLUNGE 1)
N91 (PLAN - G CODE GALLERY TEST PART_CAM)
N92 (FILE - G CODE GALLERY TEST PART.Z3)
N93 X-6.929 Y-6.929
N94 Z72.0
N95 G01 Z67.0 F50.0
N96 Z51.0 F250.0
N97 Z72.0
N98 Y0
N99 Z67.0 F50.0
N100 Z51.0 F250.0
N101 Z72.0
N102 Y6.929
N103 Z67.0 F50.0
N104 Z51.0 F250.0
N105 Z72.0
N106 X0
N107 Z67.0 F50.0
N108 Z51.0 F250.0
N109 Z72.0
N110 X6.929
N111 Z67.0 F50.0
N112 Z51.0 F250.0
N113 Z72.0
N114 Y0
N115 Z67.0 F50.0

N116 Z51.0 F250.0
N117 Z72.0
N118 X0
N119 Z67.0 F50.0
N120 Z51.0 F250.0
N121 Z72.0
N122 X6.929 Y-6.929
N123 Z67.0 F50.0
N124 Z51.0 F250.0
N125 Z72.0
N126 X0
N127 Z67.0 F50.0
N128 Z51.0 F250.0
N129 G00 Z100.0
N130 (OPERATION - INTERPATH 1)
N131 (TACTIC - INTERPATH 1)
N132 (PLAN - G CODE GALLERY TEST PART_CAM)
N133 (FILE - G CODE GALLERY TEST PART.Z3)
N134 G01 X145.0 Y3.528 F250.0
N135 X145.436 Z99.981
N136 X145.868 Z99.924
N137 X146.294 Z99.83
N138 X146.71 Z99.698
N139 X147.113 Z99.532
N140 X147.5 Z99.33
N141 X147.868 Z99.096
N142 X148.214 Z98.83
N143 X148.536 Z98.536
N144 X148.83 Z98.214
N145 X149.096 Z97.868
N146 X149.33 Z97.5
N147 X149.532 Z97.113
N148 X149.698 Z96.71
N149 X149.83 Z96.294
N150 X149.924 Z95.868
N151 X149.981 Z95.436
N152 X150.0 Z95.0
N153 Z1.87
N154 (OPERATION - SPIRALCUT 1)
N155 (TACTIC - SPIRALCUT 1)
N156 (PLAN - G CODE GALLERY TEST PART_CAM)
N157 (FILE - G CODE GALLERY TEST PART.Z3)
N158 G00 X87.5
N159 G01 X87.222 Y3.278 Z2.28 F50.0
N160 X86.944 Y2.98 Z2.657
N161 X86.667 Y2.64 Z2.996
N162 X86.389 Y2.261 Z3.291
N163 X86.111 Y1.849 Z3.539
N164 X85.833 Y1.411 Z3.735
N165 X85.556 Y.952 Z3.878
N166 X85.278 Y.48 Z3.964
N167 X85.0 Y0 Z4.0
N168 G19 G03 Y-3.464 Z-2.0 J0 K-4.0 F100.0
N169 Y3.464 J3.464 K2.0
N170 Y0 Z4.0 J-3.464 K2.0
N171 G01 Z10.0 F250.0
N172 G03 Y-8.66 Z-5.0 J0 K-10.0
N173 Y8.66 J8.66 K5.0
N174 Y0 Z10.0 J-8.66 K5.0

N175 Y-3.894 Z9.211 J0 K-10.0
N176 Y-7.35 Z.692 J2.531 K-5.987 F750.0
N177 G01 Y-4.819 Z-5.294
N178 G00 X150.0
N179 Y-6.5 Z3.0
N180 X87.5
N181 G01 X85.0 F50.0
N182 Z-3.5 F150.0
N183 G03 Y0 Z-10.0 J6.5 K0
N184 Y8.66 Z-5.0 J0 K10.0 F250.0
N185 Y0 Z10.0 J-8.66 K5.0
N186 Y-8.66 Z-5.0 J0 K-10.0
N187 Y0 Z-10.0 J8.66 K5.0
N188 Y3.894 Z-9.211 J0 K10.0
N189 Y7.35 Z-.692 J-2.531 K5.987 F750.0
N190 G01 Y4.819 Z5.294
N191 G00 X150.0
N192 M05
N193 M09
N194 (END OF PROGRAM.)
N195 M30
N196 M02
%