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%ZW_HNC-21_22M_3X
([yyyy-mm-dd hh:mm:ss] 2020-12-04 12:36:47)
N10 G90 G94 G17 G80
N20 (PROGRAMMED BY AUTHOR)
N30 (TOOL 0 IS 5 MM FLAT ENDMILL.)
N40 (SHAPE PARAMETERS)
N50 T0 M06
N60 T0
N70 (x= 0,y= 0,z= 500,Tool No= 0)
N80 S1000
N90 M03
N100 M08
N110 (OPERATION - PROFILECUT 1)
N120 (TACTIC - PROFILECUT 1)
N130 (PLAN - G CODE GALLERY TEST PART_CAM)
N140 (FILE - G CODE GALLERY TEST PART.Z3)
N150 G90 G00 X49.0 Y-30.0
N160 Z100.0
N170 Z52.5
N180 G01 Z50.0 F50.0
N190 Y-23.5 F150.0
N200 G17 G03 X42.5 Y-30.0 I0 J-6.5
N210 G02 X23.75 Y-40.825 I-12.5 J0 F250.0
N220 Y-19.175 I6.25 J10.825
N230 X42.5 Y-30.0 I6.25 J-10.825
N240 G03 X49.0 Y-36.5 I6.5 J0 F750.0
N250 G01 Y-30.0
N260 G00 Z100.0
N270 (OPERATION - PROFILECUT 2)
N280 (TACTIC - PROFILECUT 2)
N290 (PLAN - G CODE GALLERY TEST PART_CAM)
N300 (FILE - G CODE GALLERY TEST PART.Z3)
N310 X-35.0 Y-44.0
N320 Z52.5
N330 G01 Z50.0 F50.0
N340 X-28.5 F150.0
N350 G03 X-35.0 Y-37.5 I-6.5 J0
N360 G02 X-37.5 Y-35.0 I0 J2.5 F250.0
N370 G01 Y-25.0
N380 G02 X-35.0 Y-22.5 I2.5 J0
N390 G01 X-25.0
N400 G02 X-22.5 Y-25.0 I0 J-2.5
N410 G01 Y-35.0
N420 G02 X-25.0 Y-37.5 I-2.5 J0
N430 G01 X-35.0
N440 G03 X-41.5 Y-44.0 I0 J-6.5 F750.0
N450 G01 X-35.0
N460 G00 Z100.0
N470 M09
N480 (TOOL 0 IS 10 MM FLAT ENDMILL.)
N490 (SHAPE PARAMETERS)
N500 M05
N510 M06
N520 T0
N530 (x= -35,y= -44,z= 100,Tool No= 0)
N540 S1000
N550 M03
N560 M08
N570 (OPERATION - ZIGZAGCUT 1)
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N580 (TACTIC - ZIGZAGCUT 1)  
N590 (PLAN - G CODE GALLERY TEST PART\_CAM)  
N600 (FILE - G CODE GALLERY TEST PART.Z3)  
N610 G90 G00 X-38.38 Y10.856  
N620 Z100.0  
N630 Z67.5  
N640 G01 Y6.526 Z65.0 F50.0  
N650 G17 G02 X-45.0 Y5.279 I-11.62 J43.474  
N660 G01 Y45.0 F100.0  
N670 X-38.38 F250.0  
N680 Y6.526  
N690 G03 X-31.76 Y8.863 I-11.62 J43.474  
N700 G01 Y45.0  
N710 X-25.139  
N720 Y12.491  
N730 G03 X-18.519 Y17.845 I-24.861 J37.509  
N740 G01 Y45.0  
N750 X-11.899  
N760 Y26.056  
N770 G03 X-5.279 Y45.0 I-38.101 J23.944  
N780 G01 X-11.899  
N790 G00 Z100.0  
N800 Z67.5  
N810 G01 Z65.0 F50.0  
N820 X-45.0 F250.0  
N830 Y5.279  
N840 G03 X-5.279 Y45.0 I-5.0 J44.721  
N850 G01 X-15.899  
N860 G03 X-22.399 Y38.5 I0 J-6.5 F750.0  
N870 G01 Y32.0  
N880 G00 Z100.0  
N890 (OPERATION - ROUGH PLUNGE 1)  
N900 (TACTIC - ROUGH PLUNGE 1)  
N910 (PLAN - G CODE GALLERY TEST PART\_CAM)  
N920 (FILE - G CODE GALLERY TEST PART.Z3)  
N930 X-6.929 Y-6.929  
N940 Z72.0  
N950 G01 Z67.0 F50.0  
N960 Z51.0 F250.0  
N970 Z72.0  
N980 Y0  
N990 Z67.0 F50.0  
N1000 Z51.0 F250.0  
N1010 Z72.0  
N1020 Y6.929  
N1030 Z67.0 F50.0  
N1040 Z51.0 F250.0  
N1050 Z72.0  
N1060 X0  
N1070 Z67.0 F50.0  
N1080 Z51.0 F250.0  
N1090 Z72.0  
N1100 X6.929  
N1110 Z67.0 F50.0  
N1120 Z51.0 F250.0  
N1130 Z72.0  
N1140 Y0  
N1150 Z67.0 F50.0  
N1160 Z51.0 F250.0

N1170 Z72.0  
N1180 X0  
N1190 Z67.0 F50.0  
N1200 Z51.0 F250.0  
N1210 Z72.0  
N1220 X6.929 Y-6.929  
N1230 Z67.0 F50.0  
N1240 Z51.0 F250.0  
N1250 Z72.0  
N1260 X0  
N1270 Z67.0 F50.0  
N1280 Z51.0 F250.0  
N1290 G00 Z100.0  
N1300 (OPERATION - INTERPATH 1)  
N1310 (TACTIC - INTERPATH 1)  
N1320 (PLAN - G CODE GALLERY TEST PART\_CAM)  
N1330 (FILE - G CODE GALLERY TEST PART.Z3)  
N1340 G01 X145.0 Y3.528 F250.0  
N1350 X145.436 Z99.981  
N1360 X145.868 Z99.924  
N1370 X146.294 Z99.83  
N1380 X146.71 Z99.698  
N1390 X147.113 Z99.532  
N1400 X147.5 Z99.33  
N1410 X147.868 Z99.096  
N1420 X148.214 Z98.83  
N1430 X148.536 Z98.536  
N1440 X148.83 Z98.214  
N1450 X149.096 Z97.868  
N1460 X149.33 Z97.5  
N1470 X149.532 Z97.113  
N1480 X149.698 Z96.71  
N1490 X149.83 Z96.294  
N1500 X149.924 Z95.868  
N1510 X149.981 Z95.436  
N1520 X150.0 Z95.0  
N1530 Z1.87  
N1540 (OPERATION - SPIRALCUT 1)  
N1550 (TACTIC - SPIRALCUT 1)  
N1560 (PLAN - G CODE GALLERY TEST PART\_CAM)  
N1570 (FILE - G CODE GALLERY TEST PART.Z3)  
N1580 G00 X87.5  
N1590 G01 X87.222 Y3.278 Z2.28 F50.0  
N1600 X86.944 Y2.98 Z2.657  
N1610 X86.667 Y2.64 Z2.996  
N1620 X86.389 Y2.261 Z3.291  
N1630 X86.111 Y1.849 Z3.539  
N1640 X85.833 Y1.411 Z3.735  
N1650 X85.556 Y.952 Z3.878  
N1660 X85.278 Y.48 Z3.964  
N1670 X85.0 Y0 Z4.0  
N1680 G19 G03 Y-3.464 Z-2.0 J0 K-4.0 F100.0  
N1690 Y3.464 J3.464 K2.0  
N1700 Y0 Z4.0 J-3.464 K2.0  
N1710 G01 Z10.0 F250.0  
N1720 G03 Y-8.66 Z-5.0 J0 K-10.0  
N1730 Y8.66 J8.66 K5.0  
N1740 Y0 Z10.0 J-8.66 K5.0  
N1750 Y-3.894 Z9.211 J0 K-10.0

N1760 Y-7.35 Z.692 J2.531 K-5.987 F750.0  
N1770 G01 Y-4.819 Z-5.294  
N1780 G00 X150.0  
N1790 Y-6.5 Z3.0  
N1800 X87.5  
N1810 G01 X85.0 F50.0  
N1820 Z-3.5 F150.0  
N1830 G03 Y0 Z-10.0 J6.5 K0  
N1840 Y8.66 Z-5.0 J0 K10.0 F250.0  
N1850 Y0 Z10.0 J-8.66 K5.0  
N1860 Y-8.66 Z-5.0 J0 K-10.0  
N1870 Y0 Z-10.0 J8.66 K5.0  
N1880 Y3.894 Z-9.211 J0 K10.0  
N1890 Y7.35 Z-.692 J-2.531 K5.987 F750.0  
N1900 G01 Y4.819 Z5.294  
N1910 G00 X150.0  
N1920 M05  
N1930 M09  
N1940 (END OF PROGRAM.)  
N1950 M30  
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