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%
OZW_Haas_3X
([yyyy-mm-dd hh:mm:ss] 2020-12-04 12:14:53)
N0 G90 G94 G17
N1 (PROGRAMMED BY AUTHOR)
N2 (TOOL 0 IS 5 MM FLAT ENDMILL.)
N3 (SHAPE PARAMETERS)
N4 M06 T0
N5 (x= 0,y= 0,z= 500,Tool No= 0)
N6 S1000
N7 M03
N8 M08
N9 (OPERATION - PROFILECUT 1)
N10 (TACTIC - PROFILECUT 1)
N11 (PLAN - G CODE GALLERY TEST PART_CAM)
N12 (FILE - G CODE GALLERY TEST PART.Z3)
N13 G90 G00 X49. Y-30.
N14 G43 Z100. H0
N15 Z52.5
N16 G01 Z50. F50.
N17 Y-23.5 F150.
N18 G17 G03 X42.5 Y-30. I0 J-6.5
N19 G02 X23.75 Y-40.825 I-12.5 J0 F250.
N20 Y-19.175 I6.25 J10.825
N21 X42.5 Y-30. I6.25 J-10.825
N22 G03 X49. Y-36.5 I6.5 J0 F750.
N23 G01 Y-30.
N24 G00 Z100.
N25 (OPERATION - PROFILECUT 2)
N26 (TACTIC - PROFILECUT 2)
N27 (PLAN - G CODE GALLERY TEST PART_CAM)
N28 (FILE - G CODE GALLERY TEST PART.Z3)
N29 X-35. Y-44.
N30 Z52.5
N31 G01 Z50. F50.
N32 X-28.5 F150.
N33 G03 X-35. Y-37.5 I-6.5 J0
N34 G02 X-37.5 Y-35. I0 J2.5 F250.
N35 G01 Y-25.
N36 G02 X-35. Y-22.5 I2.5 J0
N37 G01 X-25.
N38 G02 X-22.5 Y-25. I0 J-2.5
N39 G01 Y-35.
N40 G02 X-25. Y-37.5 I-2.5 J0
N41 G01 X-35.
N42 G03 X-41.5 Y-44. I0 J-6.5 F750.
N43 G01 X-35.
N44 G00 Z100.
N45 M09
N46 (TOOL 0 IS 10 MM FLAT ENDMILL.)
N47 (SHAPE PARAMETERS)
N48 M05
N49 M06 T0
N50 (x= -35,y= -44,z= 100,Tool No= 0)
N51 S1000
N52 M03
N53 M08
N54 (OPERATION - ZIGZAGCUT 1)
N55 (TACTIC - ZIGZAGCUT 1)
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N56 (PLAN - G CODE GALLERY TEST PART\_CAM)  
N57 (FILE - G CODE GALLERY TEST PART.Z3)  
N58 G90 G00 X-38.38 Y10.856  
N59 G43 Z100. H0  
N60 Z67.5  
N61 G01 Y6.526 Z65. F50.  
N62 G17 G02 X-45. Y5.279 I-11.62 J43.474  
N63 G01 Y45. F100.  
N64 X-38.38 F250.  
N65 Y6.526  
N66 G03 X-31.76 Y8.863 I-11.62 J43.474  
N67 G01 Y45.  
N68 X-25.139  
N69 Y12.491  
N70 G03 X-18.519 Y17.845 I-24.861 J37.509  
N71 G01 Y45.  
N72 X-11.899  
N73 Y26.056  
N74 G03 X-5.279 Y45. I-38.101 J23.944  
N75 G01 X-11.899  
N76 G00 Z100.  
N77 Z67.5  
N78 G01 Z65. F50.  
N79 X-45. F250.  
N80 Y5.279  
N81 G03 X-5.279 Y45. I-5. J44.721  
N82 G01 X-15.899  
N83 G03 X-22.399 Y38.5 I0 J-6.5 F750.  
N84 G01 Y32.  
N85 G00 Z100.  
N86 (OPERATION - ROUGH PLUNGE 1)  
N87 (TACTIC - ROUGH PLUNGE 1)  
N88 (PLAN - G CODE GALLERY TEST PART\_CAM)  
N89 (FILE - G CODE GALLERY TEST PART.Z3)  
N90 X-6.929 Y-6.929  
N91 Z72.  
N92 G01 Z67. F50.  
N93 Z51. F250.  
N94 Z72.  
N95 Y0  
N96 Z67. F50.  
N97 Z51. F250.  
N98 Z72.  
N99 Y6.929  
N100 Z67. F50.  
N101 Z51. F250.  
N102 Z72.  
N103 X0  
N104 Z67. F50.  
N105 Z51. F250.  
N106 Z72.  
N107 X6.929  
N108 Z67. F50.  
N109 Z51. F250.  
N110 Z72.  
N111 Y0  
N112 Z67. F50.  
N113 Z51. F250.  
N114 Z72.

N115 X0  
N116 Z67. F50.  
N117 Z51. F250.  
N118 Z72.  
N119 X6.929 Y-6.929  
N120 Z67. F50.  
N121 Z51. F250.  
N122 Z72.  
N123 X0  
N124 Z67. F50.  
N125 Z51. F250.  
N126 G00 Z100.  
N127 (OPERATION - INTERPATH 1)  
N128 (TACTIC - INTERPATH 1)  
N129 (PLAN - G CODE GALLERY TEST PART\_CAM)  
N130 (FILE - G CODE GALLERY TEST PART.Z3)  
N131 G01 X145. Y3.528 F250.  
N132 X145.436 Z99.981  
N133 X145.868 Z99.924  
N134 X146.294 Z99.83  
N135 X146.71 Z99.698  
N136 X147.113 Z99.532  
N137 X147.5 Z99.33  
N138 X147.868 Z99.096  
N139 X148.214 Z98.83  
N140 X148.536 Z98.536  
N141 X148.83 Z98.214  
N142 X149.096 Z97.868  
N143 X149.33 Z97.5  
N144 X149.532 Z97.113  
N145 X149.698 Z96.71  
N146 X149.83 Z96.294  
N147 X149.924 Z95.868  
N148 X149.981 Z95.436  
N149 X150. Z95.  
N150 Z1.87  
N151 (OPERATION - SPIRALCUT 1)  
N152 (TACTIC - SPIRALCUT 1)  
N153 (PLAN - G CODE GALLERY TEST PART\_CAM)  
N154 (FILE - G CODE GALLERY TEST PART.Z3)  
N155 G00 X87.5  
N156 G01 X87.222 Y3.278 Z2.28 F50.  
N157 X86.944 Y2.98 Z2.657  
N158 X86.667 Y2.64 Z2.996  
N159 X86.389 Y2.261 Z3.291  
N160 X86.111 Y1.849 Z3.539  
N161 X85.833 Y1.411 Z3.735  
N162 X85.556 Y.952 Z3.878  
N163 X85.278 Y.48 Z3.964  
N164 X85. Y0 Z4.  
N165 G19 G03 Y-3.464 Z-2. J0 K-4. F100.  
N166 Y3.464 J3.464 K2.  
N167 Y0 Z4. J-3.464 K2.  
N168 G01 Z10. F250.  
N169 G03 Y-8.66 Z-5. J0 K-10.  
N170 Y8.66 J8.66 K5.  
N171 Y0 Z10. J-8.66 K5.  
N172 Y-3.894 Z9.211 J0 K-10.  
N173 Y-7.35 Z.692 J2.531 K-5.987 F750.

N174 G01 Y-4.819 Z-5.294  
N175 G00 X150.  
N176 Y-6.5 Z3.  
N177 X87.5  
N178 G01 X85. F50.  
N179 Z-3.5 F150.  
N180 G03 Y0 Z-10. J6.5 K0  
N181 Y8.66 Z-5. J0 K10. F250.  
N182 Y0 Z10. J-8.66 K5.  
N183 Y-8.66 Z-5. J0 K-10.  
N184 Y0 Z-10. J8.66 K5.  
N185 Y3.894 Z-9.211 J0 K10.  
N186 Y7.35 Z-.692 J-2.531 K5.987 F750.  
N187 G01 Y4.819 Z5.294  
N188 G00 X150.  
N189 M05  
N190 M09  
N191 (END OF PROGRAM.)  
N192 M30  
N193 M02  
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