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%
OZW_Haas_3X_IN
([yyyy-mm-dd hh:mm:ss] 2020-12-04 12:15:30)
N1 G40 G17 G94 G49 G21 G54
N2 (PROGRAMMED BY AUTHOR)
N3 (TOOL 0 IS 5 MM FLAT ENDMILL.)
N4 (SHAPE PARAMETERS)
N5 G91 G28 Z0.0
N6 G28 X0.0 Y0.0
N7 T0 M06
N8 S1000 M03
N9 M08
N10 S1000
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-40.8253 I-12.5 J0 F250.0
N22 Y-19.1747 I6.25 J10.8253
N23 X42.5 Y-30.0 I6.25 J-10.8253
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 G49
N52 G91 G28 Z0.0
N53 G28 X0.0 Y0.0
N54 M06
N55 S1000 M03
N56 M08
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N57 S1000
N58 (OPERATION - ZIGZAGCUT 1)
N59 (TACTIC - ZIGZAGCUT 1)
N60 (PLAN - G CODE GALLERY TEST PART_CAM)
N61 (FILE - G CODE GALLERY TEST PART.Z3)
N62 G90 G00 X-38.3798 Y10.8563
N63 Z100.0
N64 Z67.5
N65 G01 Y6.5262 Z65.0 F50.0
N66 G17 G02 X-45.0 Y5.2786 I-11.6202 J43.4738
N67 G01 Y45.0 F100.0
N68 X-38.3798 F250.0
N69 Y6.5262
N70 G03 X-31.7596 Y8.8626 I-11.6202 J43.4738
N71 G01 Y45.0
N72 X-25.1393
N73 Y12.4907
N74 G03 X-18.5191 Y17.8449 I-24.8607 J37.5093
N75 G01 Y45.0
N76 X-11.8989
N77 Y26.0562
N78 G03 X-5.2786 Y45.0 I-38.1011 J23.9438
N79 G01 X-11.8989
N80 G00 Z100.0
N81 Z67.5
N82 G01 Z65.0 F50.0
N83 X-45.0 F250.0
N84 Y5.2786
N85 G03 X-5.2786 Y45.0 I-5.0 J44.7214
N86 G01 X-15.8989
N87 G03 X-22.3989 Y38.5 I0 J-6.5 F750.0
N88 G01 Y32.0
N89 G00 Z100.0
N90 (OPERATION - ROUGH PLUNGE 1)
N91 (TACTIC - ROUGH PLUNGE 1)
N92 (PLAN - G CODE GALLERY TEST PART_CAM)
N93 (FILE - G CODE GALLERY TEST PART.Z3)
N94 X-6.9286 Y-6.9286
N95 Z72.0
N96 G01 Z67.0 F50.0
N97 Z51.0 F250.0
N98 Z72.0
N99 Y0
N100 Z67.0 F50.0
N101 Z51.0 F250.0
N102 Z72.0
N103 Y6.9286
N104 Z67.0 F50.0
N105 Z51.0 F250.0
N106 Z72.0
N107 X0
N108 Z67.0 F50.0
N109 Z51.0 F250.0
N110 Z72.0
N111 X6.9286
N112 Z67.0 F50.0
N113 Z51.0 F250.0
N114 Z72.0
N115 Y0

N116 Z67.0 F50.0
N117 Z51.0 F250.0
N118 Z72.0
N119 X0
N120 Z67.0 F50.0
N121 Z51.0 F250.0
N122 Z72.0
N123 X6.9286 Y-6.9286
N124 Z67.0 F50.0
N125 Z51.0 F250.0
N126 Z72.0
N127 X0
N128 Z67.0 F50.0
N129 Z51.0 F250.0
N130 G00 Z100.0
N131 (OPERATION - INTERPATH 1)
N132 (TACTIC - INTERPATH 1)
N133 (PLAN - G CODE GALLERY TEST PART_CAM)
N134 (FILE - G CODE GALLERY TEST PART.Z3)
N135 G01 X145.0 Y3.528 F250.0
N136 X145.4358 Z99.981
N137 X145.8682 Z99.924
N138 X146.2941 Z99.8296
N139 X146.7101 Z99.6985
N140 X147.1131 Z99.5315
N141 X147.5 Z99.3301
N142 X147.8679 Z99.0958
N143 X148.2139 Z98.8302
N144 X148.5355 Z98.5355
N145 X148.8302 Z98.2139
N146 X149.0958 Z97.8679
N147 X149.3301 Z97.5
N148 X149.5315 Z97.1131
N149 X149.6985 Z96.7101
N150 X149.8296 Z96.2941
N151 X149.924 Z95.8682
N152 X149.981 Z95.4358
N153 X150.0 Z95.0
N154 Z1.8698
N155 (OPERATION - SPIRALCUT 1)
N156 (TACTIC - SPIRALCUT 1)
N157 (PLAN - G CODE GALLERY TEST PART_CAM)
N158 (FILE - G CODE GALLERY TEST PART.Z3)
N159 G00 X87.5
N160 G01 X87.2222 Y3.278 Z2.2799 F50.0
N161 X86.9444 Y2.9804 Z2.6571
N162 X86.6667 Y2.6398 Z2.9958
N163 X86.3889 Y2.2609 Z3.2911
N164 X86.1111 Y1.8493 Z3.5388
N165 X85.8333 Y1.4109 Z3.7353
N166 X85.5556 Y.9521 Z3.8777
N167 X85.2778 Y.4795 Z3.964
N168 X85.0 Y0 Z4.0
N169 G19 G03 Y-3.4641 Z-2.0 J0 K-4.0 F100.0
N170 Y3.4641 J3.4641 K2.0
N171 Y0 Z4.0 J-3.4641 K2.0
N172 G01 Z10.0 F250.0
N173 G03 Y-8.6603 Z-5.0 J0 K-10.0
N174 Y8.6603 J8.6603 K5.0

N175 Y0 Z10.0 J-8.6603 K5.0
N176 Y-3.8942 Z9.2106 J0 K-10.0
N177 Y-7.3499 Z.6925 J2.5312 K-5.9869 F750.0
N178 G01 Y-4.8186 Z-5.2944
N179 G00 X150.0
N180 Y-6.5 Z3.0
N181 X87.5
N182 G01 X85.0 F50.0
N183 Z-3.5 F150.0
N184 G03 Y0 Z-10.0 J6.5 K0
N185 Y8.6603 Z-5.0 J0 K10.0 F250.0
N186 Y0 Z10.0 J-8.6603 K5.0
N187 Y-8.6603 Z-5.0 J0 K-10.0
N188 Y0 Z-10.0 J8.6603 K5.0
N189 Y3.8942 Z-9.2106 J0 K10.0
N190 Y7.3499 Z-.6925 J-2.5312 K5.9869 F750.0
N191 G01 Y4.8186 Z5.2944
N192 G00 X150.0
N193 G91 G28 Z0.0
N194 G28 X0.0 Y0.0
N195 G49
N196 M05
N197 M09
N198 (END OF PROGRAM.)
N199 G29 Z0
N200 G28 Y0
N201 M30
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