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BEGIN PGM ZW_Heidenhain530 MM
;[yyyy-mm-dd hh:mm:ss] 2020-12-04 12:27:09
;Programmed by Author
;Tool 0 is 5 mm Flat Endmill.
;SHAPE PARAMETERS
TOOL CALL 0 Z S1000 DL+0 DR+0
CYCL DEF 247 DATUM SETTING ~
  Q339= 1 ;DATUM NUMBER
M03
M08
;Operation - Profilecut 1
;Tactic - Profilecut 1
;Plan - G code gallery test part_CAM
;File - G code gallery test part.Z3
L X+49.000 Y-30.000 FMAX
L Z+100.000 FMAX
L Z+52.500 FMAX
L Z+50.000 F50
L Y-23.500 F150
CC X+49.000 Y-30.000 Z+50.000
C X+42.500 Y-30.000 DR+
CC X+30.000 Y-30.000 Z+50.000
C X+23.750 Y-40.825 DR- F250
CC X+30.000 Y-30.000 Z+50.000
C X+23.750 Y-19.175 DR-
CC X+30.000 Y-30.000 Z+50.000
C X+42.500 Y-30.000 DR-
CC X+49.000 Y-30.000 Z+50.000
C X+49.000 Y-36.500 DR+ F750
L Y-30.000
L Z+100.000 FMAX
;Operation - Profilecut 2
;Tactic - Profilecut 2
;Plan - G code gallery test part_CAM
;File - G code gallery test part.Z3
L X-35.000 Y-44.000 FMAX
L Z+52.500 FMAX
L Z+50.000 F50
L X-28.500 F150
CC X-35.000 Y-44.000 Z+50.000
C X-35.000 Y-37.500 DR+
CC X-35.000 Y-35.000 Z+50.000
C X-37.500 Y-35.000 DR- F250
L Y-25.000
CC X-35.000 Y-25.000 Z+50.000
C X-35.000 Y-22.500 DR-
L X-25.000
CC X-25.000 Y-25.000 Z+50.000
C X-22.500 Y-25.000 DR-
L Y-35.000
CC X-25.000 Y-35.000 Z+50.000
C X-25.000 Y-37.500 DR-
L X-35.000
CC X-35.000 Y-44.000 Z+50.000
C X-41.500 Y-44.000 DR+ F750
L X-35.000
L Z+100.000 FMAX
M09
;Tool 0 is 10 mm Flat Endmill.

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;SHAPE PARAMETERS
M05
TOOL CALL 0 Z S1000 DL+0 DR+0
CYCL DEF 247 DATUM SETTING ~
  Q339= 1 ;DATUM NUMBER
M03
M08
;Operation - Zigzagcut 1
;Tactic - Zigzagcut 1
;Plan - G code gallery test part_CAM
;File - G code gallery test part.Z3
L X-38.380 Y+10.856 FMAX
L Z+100.000 FMAX
L Z+67.500 FMAX
L Y+6.526 Z+65.000 F50
CC X-50.000 Y+50.000 Z+65.000
C X-45.000 Y+5.279 DR-
L Y+45.000 F100
L X-38.380 F250
L Y+6.526
CC X-50.000 Y+50.000 Z+65.000
C X-31.760 Y+8.863 DR+
L Y+45.000
L X-25.139
L Y+12.491
CC X-50.000 Y+50.000 Z+65.000
C X-18.519 Y+17.845 DR+
L Y+45.000
L X-11.899
L Y+26.056
CC X-50.000 Y+50.000 Z+65.000
C X-5.279 Y+45.000 DR+
L X-11.899
L Z+100.000 FMAX
L Z+67.500 FMAX
L Z+65.000 F50
L X-45.000 F250
L Y+5.279
CC X-50.000 Y+50.000 Z+65.000
C X-5.279 Y+45.000 DR+
L X-15.899
CC X-15.899 Y+38.500 Z+65.000
C X-22.399 Y+38.500 DR+ F750
L Y+32.000
L Z+100.000 FMAX
;Operation - Rough Plunge 1
;Tactic - Rough Plunge 1
;Plan - G code gallery test part_CAM
;File - G code gallery test part.Z3
L X-6.929 Y-6.929 FMAX
L Z+72.000 FMAX
L Z+67.000 F50
L Z+51.000 F250
L Z+72.000
L Y+0.0
L Z+67.000 F50
L Z+51.000 F250
L Z+72.000
L Y+6.929

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L Z+67.000 F50
L Z+51.000 F250
L Z+72.000
L X+0.0
L Z+67.000 F50
L Z+51.000 F250
L Z+72.000
L X+6.929
L Z+67.000 F50
L Z+51.000 F250
L Z+72.000
L Y+0.0
L Z+67.000 F50
L Z+51.000 F250
L Z+72.000
L X+0.0
L Z+67.000 F50
L Z+51.000 F250
L Z+72.000
L X+6.929 Y-6.929
L Z+67.000 F50
L Z+51.000 F250
L Z+72.000
L X+0.0
L Z+67.000 F50
L Z+51.000 F250
L Z+100.000 FMAX
;Operation - InterPath 1
;Tactic - InterPath 1
;Plan - G code gallery test part_CAM
;File - G code gallery test part.Z3
L X+145.000 Y+3.528 F250
L X+145.436 Z+99.981
L X+145.868 Z+99.924
L X+146.294 Z+99.830
L X+146.710 Z+99.698
L X+147.113 Z+99.532
L X+147.500 Z+99.330
L X+147.868 Z+99.096
L X+148.214 Z+98.830
L X+148.536 Z+98.536
L X+148.830 Z+98.214
L X+149.096 Z+97.868
L X+149.330 Z+97.500
L X+149.532 Z+97.113
L X+149.698 Z+96.710
L X+149.830 Z+96.294
L X+149.924 Z+95.868
L X+149.981 Z+95.436
L X+150.000 Z+95.000
L Z+1.870
;Operation - Spiralcut 1
;Tactic - Spiralcut 1
;Plan - G code gallery test part_CAM
;File - G code gallery test part.Z3
L X+87.500 FMAX
L X+87.222 Y+3.278 Z+2.280 F50
L X+86.944 Y+2.980 Z+2.657
L X+86.667 Y+2.640 Z+2.996
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L X+86.389 Y+2.261 Z+3.291
L X+86.111 Y+1.849 Z+3.539
L X+85.833 Y+1.411 Z+3.735
L X+85.556 Y+.952 Z+3.878
L X+85.278 Y+.480 Z+3.964
L X+85.000 Y+0.0 Z+4.000
CC X+85.000 Y+0.0 Z+0.0
C Y-3.464 Z-2.000 DR+ F100
CC X+85.000 Y+0.0 Z+0.0
C Y+3.464 Z-2.000 DR+
CC X+85.000 Y+0.0 Z+0.0
C Y+0.0 Z+4.000 DR+
L Z+10.000 F250
CC X+85.000 Y+0.0 Z+0.0
C Y-8.660 Z-5.000 DR+
CC X+85.000 Y+0.0 Z+0.0
C Y+8.660 Z-5.000 DR+
CC X+85.000 Y+0.0 Z+0.0
C Y+0.0 Z+10.000 DR+
CC X+85.000 Y+0.0 Z+0.0
C Y-3.894 Z+9.211 DR+
CC X+85.000 Y-1.363 Z+3.224
C Y-7.350 Z+.692 DR+ F750
L Y-4.819 Z-5.294
L X+150.000 FMAX
L Z+3.000 FMAX
L Y-6.500 FMAX
L X+87.500 FMAX
L X+85.000 F50
L Z-3.500 F150
CC X+85.000 Y+0.0 Z-3.500
C Y+0.0 Z-10.000 DR+
CC X+85.000 Y+0.0 Z+0.0
C Y+8.660 Z-5.000 DR+ F250
CC X+85.000 Y+0.0 Z+0.0
C Y+0.0 Z+10.000 DR+
CC X+85.000 Y+0.0 Z+0.0
C Y-8.660 Z-5.000 DR+
CC X+85.000 Y+0.0 Z+0.0
C Y+0.0 Z-10.000 DR+
CC X+85.000 Y+0.0 Z+0.0
C Y+3.894 Z-9.211 DR+
CC X+85.000 Y+1.363 Z-3.224
C Y+7.350 Z-.692 DR+ F750
L Y+4.819 Z+5.294
L X+150.000 FMAX
M05
M09
;End of program.
END PGM ZW_Heidenhain530 MM