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BEGIN PGM ZW_Heidenhain_3Darc MM
;[yyyy-mm-dd hh:mm:ss] 2020-12-04 12:28:38
;Programmed by Author
;Tool 0 is 5 mm Flat Endmill.
;SHAPE PARAMETERS
;CUTTER_DIAM : 5
1 M8
;Operation - Profilecut 1
;Tactic - Profilecut 1
;Plan - G code gallery test part_CAM
;File - G code gallery test part.Z3
2 L X+49.000 Y-30.000 FMAX M3
3 L Z+100.000 FMAX
4 L Z+52.500 FMAX
5 L Z+50.000 F50
6 L Y-23.500 F150
7 CC X+49.000 Y-30.000
8 C X+42.500 Y-30.000 DR+
9 CC X+30.000 Y-30.000
10 C X+23.750 Y-40.825 DR- F250
11 C X+23.750 Y-19.175 DR-
12 C X+42.500 Y-30.000 DR-
13 CC X+49.000 Y-30.000
14 C X+49.000 Y-36.500 DR+ F750
15 L Y-30.000
16 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
17 L X-35.000 Y-44.000 FMAX
18 L Z+52.500 FMAX
19 L Z+50.000 F50
20 L X-28.500 F150
21 CC X-35.000 Y-44.000
22 C X-35.000 Y-37.500 DR+
23 CC X-35.000 Y-35.000
24 C X-37.500 Y-35.000 DR- F250
25 L Y-25.000
26 CC X-35.000 Y-25.000
27 C X-35.000 Y-22.500 DR-
28 L X-25.000
29 CC X-25.000 Y-25.000
30 C X-22.500 Y-25.000 DR-
31 L Y-35.000
32 CC X-25.000 Y-35.000
33 C X-25.000 Y-37.500 DR-
34 L X-35.000
35 CC X-35.000 Y-44.000
36 C X-41.500 Y-44.000 DR+ F750
37 L X-35.000
38 L Z+100.000 FMAX
39 M9
;Tool 0 is 10 mm Flat Endmill.
;SHAPE PARAMETERS
;CUTTER_DIAM : 10
40 M8
;Operation - Zigzagcut 1
;Tactic - Zigzagcut 1
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;Plan - G code gallery test part_CAM
;File - G code gallery test part.Z3
41 L X-38.380 Y+10.856 FMAX
42 L Z+67.500 FMAX
43 L Y+6.526 Z+65.000 F50
44 CC X-50.000 Y+50.000
45 C X-45.000 Y+5.279 DR-
46 L Y+45.000 F100
47 L X-38.380 F250
48 L Y+6.526
49 C X-31.760 Y+8.863 DR+
50 L Y+45.000
51 L X-25.139
52 L Y+12.491
53 C X-18.519 Y+17.845 DR+
54 L Y+45.000
55 L X-11.899
56 L Y+26.056
57 C X-5.279 Y+45.000 DR+
58 L X-11.899
59 L Z+100.000 FMAX
60 L Z+67.500 FMAX
61 L Z+65.000 F50
62 L X-45.000 F250
63 L Y+5.279
64 C X-5.279 Y+45.000 DR+
65 L X-15.899
66 CC X-15.899 Y+38.500
67 C X-22.399 Y+38.500 DR+ F750
68 L Y+32.000
69 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
70 L X-6.929 Y-6.929 FMAX
71 L Z+72.000 FMAX
72 L Z+67.000 F50
73 L Z+51.000 F250
74 L Z+72.000
75 L Y+0.0
76 L Z+67.000 F50
77 L Z+51.000 F250
78 L Z+72.000
79 L Y+6.929
80 L Z+67.000 F50
81 L Z+51.000 F250
82 L Z+72.000
83 L X+0.0
84 L Z+67.000 F50
85 L Z+51.000 F250
86 L Z+72.000
87 L X+6.929
88 L Z+67.000 F50
89 L Z+51.000 F250
90 L Z+72.000
91 L Y+0.0
92 L Z+67.000 F50
93 L Z+51.000 F250
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94 L Z+72.000
95 L X+0.0
96 L Z+67.000 F50
97 L Z+51.000 F250
98 L Z+72.000
99 L X+6.929 Y-6.929
100 L Z+67.000 F50
101 L Z+51.000 F250
102 L Z+72.000
103 L X+0.0
104 L Z+67.000 F50
105 L Z+51.000 F250
106 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
107 L X+145.000 Y+3.528 F250
108 L X+145.436 Z+99.981
109 L X+145.868 Z+99.924
110 L X+146.294 Z+99.830
111 L X+146.710 Z+99.698
112 L X+147.113 Z+99.532
113 L X+147.500 Z+99.330
114 L X+147.868 Z+99.096
115 L X+148.214 Z+98.830
116 L X+148.536 Z+98.536
117 L X+148.830 Z+98.214
118 L X+149.096 Z+97.868
119 L X+149.330 Z+97.500
120 L X+149.532 Z+97.113
121 L X+149.698 Z+96.710
122 L X+149.830 Z+96.294
123 L X+149.924 Z+95.868
124 L X+149.981 Z+95.436
125 L X+150.000 Z+95.000
126 L Z+1.870
;Operation - Spiralcut 1
;Tactic - Spiralcut 1
;Plan - G code gallery test part_CAM
;File - G code gallery test part.Z3
127 L X+87.500 FMAX
128 L X+87.222 Y+3.278 Z+2.280 F50
129 L X+86.944 Y+2.980 Z+2.657
130 L X+86.667 Y+2.640 Z+2.996
131 L X+86.389 Y+2.261 Z+3.291
132 L X+86.111 Y+1.849 Z+3.539
133 L X+85.833 Y+1.411 Z+3.735
134 L X+85.556 Y+.952 Z+3.878
135 L X+85.278 Y+.480 Z+3.964
136 L X+85.000 Y+0.0 Z+4.000
137 CC X+85.000 Y+0.0
138 C Y-3.464 Z-2.000 DR+ F100
139 C Y+3.464 Z-2.000 DR+
140 C Y+0.0 Z+4.000 DR+
141 L Z+10.000 F250
142 C Y-8.660 Z-5.000 DR+
143 C Y+8.660 Z-5.000 DR+
144 C Y+0.0 Z+10.000 DR+
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145 C Y-3.894 Z+9.211 DR+  
146 CC X+85.000 Y-1.363  
147 C Y-7.350 Z+.692 DR+ F750  
148 L Y-4.819 Z-5.294  
149 L X+150.000 FMAX  
150 L Z+3.000 FMAX  
151 L Y-6.500 FMAX  
152 L X+87.500 FMAX  
153 L X+85.000 F50  
154 L Z-3.500 F150  
155 CC X+85.000 Y+0.0  
156 C Y+0.0 Z-10.000 DR+  
157 C Y+8.660 Z-5.000 DR+ F250  
158 C Y+0.0 Z+10.000 DR+  
159 C Y-8.660 Z-5.000 DR+  
160 C Y+0.0 Z-10.000 DR+  
161 C Y+3.894 Z-9.211 DR+  
162 CC X+85.000 Y+1.363  
163 C Y+7.350 Z-.692 DR+ F750  
164 L Y+4.819 Z+5.294  
165 L X+150.000 FMAX  
166 M9  
;End of program.  
167 M5  
168 L Z-88 FMAX M92  
169 L Y+0 FMAX M92  
END PGM ZW\_Heidenhain\_3Darc MM