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1 BEGIN PGM ZW_Heidenhain_3X MM
;[yyyy-mm-dd hh:mm:ss] 2020-12-04 12:29:15
;Programmed by Author
;Tool 0 is 5 mm Flat Endmill.
;SHAPE PARAMETERS
2 L M127
3 L M129
4 L Z0.0 FMAX M91
5 L X0.0 Y0.0 FMAX M91
6 TOOL CALL 0 Z S1000 DL+0 DR+0
7 M03
8 M08
;Operation - Profilecut 1
;Tactic - Profilecut 1
;Plan - G code gallery test part_CAM
;File - G code gallery test part.Z3
9 L X+49.000 Y-30.000 FMAX
10 L Z+100.000 FMAX
11 L Z+52.500 FMAX
12 L Z+50.000 F50
13 L Y-23.500 F150
14 CC X+49.000 Y-30.000
15 C X+42.500 Y-30.000 DR+
16 CC X+30.000 Y-30.000
17 C X+23.750 Y-40.825 DR- F250
18 CC X+30.000 Y-30.000
19 C X+23.750 Y-19.175 DR-
20 CC X+30.000 Y-30.000
21 C X+42.500 Y-30.000 DR-
22 CC X+49.000 Y-30.000
23 C X+49.000 Y-36.500 DR+ F750
24 L Y-30.000
25 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
26 L X-35.000 Y-44.000 FMAX
27 L Z+52.500 FMAX
28 L Z+50.000 F50
29 L X-28.500 F150
30 CC X-35.000 Y-44.000
31 C X-35.000 Y-37.500 DR+
32 CC X-35.000 Y-35.000
33 C X-37.500 Y-35.000 DR- F250
34 L Y-25.000
35 CC X-35.000 Y-25.000
36 C X-35.000 Y-22.500 DR-
37 L X-25.000
38 CC X-25.000 Y-25.000
39 C X-22.500 Y-25.000 DR-
40 L Y-35.000
41 CC X-25.000 Y-35.000
42 C X-25.000 Y-37.500 DR-
43 L X-35.000
44 CC X-35.000 Y-44.000
45 C X-41.500 Y-44.000 DR+ F750
46 L X-35.000
47 L Z+100.000 FMAX
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48 M09
;Tool 0 is 10 mm Flat Endmill.
;SHAPE PARAMETERS
49 L M127
50 L M129
51 L Z0.0 FMAX M91
52 L X0.0 Y0.0 FMAX M91
53 L M05
54 TOOL CALL 0 Z S1000 DL+0 DR+0
55 M03
56 M08
;Operation - Zigzagcut 1
;Tactic - Zigzagcut 1
;Plan - G code gallery test part_CAM
;File - G code gallery test part.Z3
57 L X-38.380 Y+10.856 FMAX
58 L Z+100.000 FMAX
59 L Z+67.500 FMAX
60 L Y+6.526 Z+65.000 F50
61 CC X-50.000 Y+50.000
62 C X-45.000 Y+5.279 DR-
63 L Y+45.000 F100
64 L X-38.380 F250
65 L Y+6.526
66 CC X-50.000 Y+50.000
67 C X-31.760 Y+8.863 DR+
68 L Y+45.000
69 L X-25.139
70 L Y+12.491
71 CC X-50.000 Y+50.000
72 C X-18.519 Y+17.845 DR+
73 L Y+45.000
74 L X-11.899
75 L Y+26.056
76 CC X-50.000 Y+50.000
77 C X-5.279 Y+45.000 DR+
78 L X-11.899
79 L Z+100.000 FMAX
80 L Z+67.500 FMAX
81 L Z+65.000 F50
82 L X-45.000 F250
83 L Y+5.279
84 CC X-50.000 Y+50.000
85 C X-5.279 Y+45.000 DR+
86 L X-15.899
87 CC X-15.899 Y+38.500
88 C X-22.399 Y+38.500 DR+ F750
89 L Y+32.000
90 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
91 L X-6.929 Y-6.929 FMAX
92 L Z+72.000 FMAX
93 L Z+67.000 F50
94 L Z+51.000 F250
95 L Z+72.000
96 L Y+0.0
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97 L Z+67.000 F50
98 L Z+51.000 F250
99 L Z+72.000
100 L Y+6.929
101 L Z+67.000 F50
102 L Z+51.000 F250
103 L Z+72.000
104 L X+0.0
105 L Z+67.000 F50
106 L Z+51.000 F250
107 L Z+72.000
108 L X+6.929
109 L Z+67.000 F50
110 L Z+51.000 F250
111 L Z+72.000
112 L Y+0.0
113 L Z+67.000 F50
114 L Z+51.000 F250
115 L Z+72.000
116 L X+0.0
117 L Z+67.000 F50
118 L Z+51.000 F250
119 L Z+72.000
120 L X+6.929 Y-6.929
121 L Z+67.000 F50
122 L Z+51.000 F250
123 L Z+72.000
124 L X+0.0
125 L Z+67.000 F50
126 L Z+51.000 F250
127 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
128 L X+145.000 Y+3.528 F250
129 L X+145.436 Z+99.981
130 L X+145.868 Z+99.924
131 L X+146.294 Z+99.830
132 L X+146.710 Z+99.698
133 L X+147.113 Z+99.532
134 L X+147.500 Z+99.330
135 L X+147.868 Z+99.096
136 L X+148.214 Z+98.830
137 L X+148.536 Z+98.536
138 L X+148.830 Z+98.214
139 L X+149.096 Z+97.868
140 L X+149.330 Z+97.500
141 L X+149.532 Z+97.113
142 L X+149.698 Z+96.710
143 L X+149.830 Z+96.294
144 L X+149.924 Z+95.868
145 L X+149.981 Z+95.436
146 L X+150.000 Z+95.000
147 L Z+1.870
;Operation - Spiralcut 1
;Tactic - Spiralcut 1
;Plan - G code gallery test part_CAM
;File - G code gallery test part.Z3
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148 L X+87.500 FMAX
149 L X+87.222 Y+3.278 Z+2.280 F50
150 L X+86.944 Y+2.980 Z+2.657
151 L X+86.667 Y+2.640 Z+2.996
152 L X+86.389 Y+2.261 Z+3.291
153 L X+86.111 Y+1.849 Z+3.539
154 L X+85.833 Y+1.411 Z+3.735
155 L X+85.556 Y+.952 Z+3.878
156 L X+85.278 Y+.480 Z+3.964
157 L X+85.000 Y+0.0 Z+4.000
158 CC Y+0.0 Z+0.0
159 C Y-3.464 Z-2.000 DR+ F100
160 CC Y+0.0 Z+0.0
161 C Y+3.464 Z-2.000 DR+
162 CC Y+0.0 Z+0.0
163 C Y+0.0 Z+4.000 DR+
164 L Z+10.000 F250
165 CC Y+0.0 Z+0.0
166 C Y-8.660 Z-5.000 DR+
167 CC Y+0.0 Z+0.0
168 C Y+8.660 Z-5.000 DR+
169 CC Y+0.0 Z+0.0
170 C Y+0.0 Z+10.000 DR+
171 CC Y+0.0 Z+0.0
172 C Y-3.894 Z+9.211 DR+
173 CC Y-1.363 Z+3.224
174 C Y-7.350 Z+.692 DR+ F750
175 L Y-4.819 Z-5.294
176 L X+150.000 FMAX
177 L Z+3.000 FMAX
178 L Y-6.500 FMAX
179 L X+87.500 FMAX
180 L X+85.000 F50
181 L Z-3.500 F150
182 CC Y+0.0 Z-3.500
183 C Y+0.0 Z-10.000 DR+
184 CC Y+0.0 Z+0.0
185 C Y+8.660 Z-5.000 DR+ F250
186 CC Y+0.0 Z+0.0
187 C Y+0.0 Z+10.000 DR+
188 CC Y+0.0 Z+0.0
189 C Y-8.660 Z-5.000 DR+
190 CC Y+0.0 Z+0.0
191 C Y+0.0 Z-10.000 DR+
192 CC Y+0.0 Z+0.0
193 C Y+3.894 Z-9.211 DR+
194 CC Y+1.363 Z-3.224
195 C Y+7.350 Z-.692 DR+ F750
196 L Y+4.819 Z+5.294
197 L X+150.000 FMAX
198 L M140 MB MAX
199 L Z0.0 FMAX M91
200 L X0.0 Y0.0 FMAX M91
201 M05
202 M09
;End of program.
203 M30
END PGM ZW_Heidenhain_3X MM