

%
OZW_Hurco_3X
([yyyy-mm-dd hh:mm:ss] 2020-12-04 12:39:27)
N1G90G98G40G70G80G50G17G54M09M05
N2(PROGRAMMED BY AUTHOR)
N3(TOOL Ø IS 5 MM FLAT ENDMILL.)
N4(SHAPE PARAMETERS)
N5T0M06
N6T0
N7S1000M03
N8M08
N9(OPERATION - PROFILECUT 1)
N10(TACTIC - PROFILECUT 1)
N11(PLAN - G CODE GALLERY TEST PART_CAM)
N12(FILE - G CODE GALLERY TEST PART.Z3)
N13G90G00X49.0Y-30.0
N14Z100.0
N15Z52.5
N16G01Z50.0F50.0
N17Y-23.5F150.0
N18G17G03X42.5Y-30.0I0J-6.5
N19G02X23.75Y-40.825I-12.5J0F250.0
N20Y-19.175I6.25J10.825
N21X42.5Y-30.0I6.25J-10.825
N22G03X49.0Y-36.5I6.5J0F750.0
N23G01Y-30.0
N24G00Z100.0
N25(OPERATION - PROFILECUT 2)
N26(TACTIC - PROFILECUT 2)
N27(PLAN - G CODE GALLERY TEST PART_CAM)
N28(FILE - G CODE GALLERY TEST PART.Z3)
N29X-35.0Y-44.0
N30Z52.5
N31G01Z50.0F50.0
N32X-28.5F150.0
N33G03X-35.0Y-37.5I-6.5J0
N34G02X-37.5Y-35.0I0J2.5F250.0
N35G01Y-25.0
N36G02X-35.0Y-22.5I2.5J0
N37G01X-25.0
N38G02X-22.5Y-25.0I0J-2.5
N39G01Y-35.0
N40G02X-25.0Y-37.5I-2.5J0
N41G01X-35.0
N42G03X-41.5Y-44.0I0J-6.5F750.0
N43G01X-35.0
N44G00Z100.0
N45M09
N46(TOOL Ø IS 10 MM FLAT ENDMILL.)
N47(SHAPE PARAMETERS)
N48M05
N49M06
N50T0
N51S1000M03
N52M08
N53(OPERATION - ZIGZAGCUT 1)
N54(TACTIC - ZIGZAGCUT 1)
N55(PLAN - G CODE GALLERY TEST PART_CAM)
N56(FILE - G CODE GALLERY TEST PART.Z3)

N57G90G00X-38.38Y10.856
N58Z100.0
N59Z67.5
N60G01Y6.526Z65.0F50.0
N61G17G02X-45.0Y5.279I-11.62J43.474
N62G01Y45.0F100.0
N63X-38.38F250.0
N64Y6.526
N65G03X-31.76Y8.863I-11.62J43.474
N66G01Y45.0
N67X-25.139
N68Y12.491
N69G03X-18.519Y17.845I-24.861J37.509
N70G01Y45.0
N71X-11.899
N72Y26.056
N73G03X-5.279Y45.0I-38.101J23.944
N74G01X-11.899
N75G00Z100.0
N76Z67.5
N77G01Z65.0F50.0
N78X-45.0F250.0
N79Y5.279
N80G03X-5.279Y45.0I-5.0J44.721
N81G01X-15.899
N82G03X-22.399Y38.5I0J-6.5F750.0
N83G01Y32.0
N84G00Z100.0
N85(OPERATION - ROUGH PLUNGE 1)
N86(TACTIC - ROUGH PLUNGE 1)
N87(PPLAN - G CODE GALLERY TEST PART_CAM)
N88(FILE - G CODE GALLERY TEST PART.Z3)
N89X-6.929Y-6.929
N90Z72.0
N91G01Z67.0F50.0
N92Z51.0F250.0
N93Z72.0
N94Y0
N95Z67.0F50.0
N96Z51.0F250.0
N97Z72.0
N98Y6.929
N99Z67.0F50.0
N100Z51.0F250.0
N101Z72.0
N102X0
N103Z67.0F50.0
N104Z51.0F250.0
N105Z72.0
N106X6.929
N107Z67.0F50.0
N108Z51.0F250.0
N109Z72.0
N110Y0
N111Z67.0F50.0
N112Z51.0F250.0
N113Z72.0
N114X0
N115Z67.0F50.0

N116Z51.0F250.0
N117Z72.0
N118X6.929Y-6.929
N119Z67.0F50.0
N120Z51.0F250.0
N121Z72.0
N122X0
N123Z67.0F50.0
N124Z51.0F250.0
N125G00Z100.0
N126(OPERATION - INTERPATH 1)
N127(TACTIC - INTERPATH 1)
N128(PLAN - G CODE GALLERY TEST PART_CAM)
N129(FILE - G CODE GALLERY TEST PART.Z3)
N130G01X145.0Y3.528F250.0
N131X145.436Z99.981
N132X145.868Z99.924
N133X146.294Z99.83
N134X146.71Z99.698
N135X147.113Z99.532
N136X147.5Z99.33
N137X147.868Z99.096
N138X148.214Z98.83
N139X148.536Z98.536
N140X148.83Z98.214
N141X149.096Z97.868
N142X149.33Z97.5
N143X149.532Z97.113
N144X149.698Z96.71
N145X149.83Z96.294
N146X149.924Z95.868
N147X149.981Z95.436
N148X150.0Z95.0
N149Z1.87
N150(OPERATION - SPIRALCUT 1)
N151(TACTIC - SPIRALCUT 1)
N152(PLAN - G CODE GALLERY TEST PART_CAM)
N153(FILE - G CODE GALLERY TEST PART.Z3)
N154G00X87.5
N155G01X87.222Y3.278Z2.28F50.0
N156X86.944Y2.98Z2.657
N157X86.667Y2.64Z2.996
N158X86.389Y2.261Z3.291
N159X86.111Y1.849Z3.539
N160X85.833Y1.411Z3.735
N161X85.556Y.952Z3.878
N162X85.278Y.48Z3.964
N163X85.0Y0Z4.0
N164G19G03Y-3.464Z-2.0J0K-4.0F100.0
N165Y3.464J3.464K2.0
N166Y0Z4.0J-3.464K2.0
N167G01Z10.0F250.0
N168G03Y-8.66Z-5.0J0K-10.0
N169Y8.66J8.66K5.0
N170Y0Z10.0J-8.66K5.0
N171Y-3.894Z9.211J0K-10.0
N172Y-7.35Z.692J2.531K-5.987F750.0
N173G01Y-4.819Z-5.294
N174G00X150.0

N175Y-6.5Z3.0
N176X87.5
N177G01X85.0F50.0
N178Z-3.5F150.0
N179G03Y0Z-10.0J6.5K0
N180Y8.66Z-5.0J0K10.0F250.0
N181Y0Z10.0J-8.66K5.0
N182Y-8.66Z-5.0J0K-10.0
N183Y0Z-10.0J8.66K5.0
N184Y3.894Z-9.211J0K10.0
N185Y7.35Z-.692J-2.531K5.987F750.0
N186G01Y4.819Z5.294
N187G00X150.0
N188M05
N189M09
N190(END OF PROGRAM.)
N191T0M06
N192M30
N193M02
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