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%_N_ZW_SINUMERIK_3X_MPF
$PATH=/_N_MPF_DIR
;[yyyy-mm-dd hh:mm:ss] 2020-12-04 12:43:28
N1 G54 G40 G17 G94 G90 G71
N2 ;Programmed by Author
N3 ;
N4 ;Tool 0 is 5 mm Flat Endmill.
N5 ;SHAPE PARAMETERS
N6 SUPA G91 G74 Z0.0
N7 SUPA G74 X0.0 Y0.0
N8 M05
N9 G90 T0 M06
N10 T0
N11 S1000 M03
N12 G64
N13 M08
N14 ;Operation - Profilecut 1
N15 ;Tactic - Profilecut 1
N16 ;Plan - G code gallery test part_CAM
N17 ;File - G code gallery test part.Z3
N18 G90 G00 X49. Y-30.
N19 Z100.
N20 Z52.5
N21 G01 Z50. F50.
N22 Y-23.5 F150.
N23 G17 G03 X42.5 Y-30. I0 J-6.5
N24 G02 X23.75 Y-40.8253 I-12.5 J0 F250.
N25 Y-19.1747 I6.25 J10.8253
N26 X42.5 Y-30. I6.25 J-10.8253
N27 G03 X49. Y-36.5 I6.5 J0 F750.
N28 G01 Y-30.
N29 G00 Z100.
N30 ;Operation - Profilecut 2
N31 ;Tactic - Profilecut 2
N32 ;Plan - G code gallery test part_CAM
N33 ;File - G code gallery test part.Z3
N34 X-35. Y-44.
N35 Z52.5
N36 G01 Z50. F50.
N37 X-28.5 F150.
N38 G03 X-35. Y-37.5 I-6.5 J0
N39 G02 X-37.5 Y-35. I0 J2.5 F250.
N40 G01 Y-25.
N41 G02 X-35. Y-22.5 I2.5 J0
N42 G01 X-25.
N43 G02 X-22.5 Y-25. I0 J-2.5
N44 G01 Y-35.
N45 G02 X-25. Y-37.5 I-2.5 J0
N46 G01 X-35.
N47 G03 X-41.5 Y-44. I0 J-6.5 F750.
N48 G01 X-35.
N49 G00 Z100.
N50 M09
N51 ;Tool 0 is 10 mm Flat Endmill.
N52 ;SHAPE PARAMETERS
N53 SUPA G91 G74 Z0.0
N54 SUPA G74 X0.0 Y0.0
N55 M05
N56 G90 G60

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N57 M06  
N58 T0  
N59 S1000 M03  
N60 G64  
N61 M08  
N62 ;Operation - Zigzagcut 1  
N63 ;Tactic - Zigzagcut 1  
N64 ;Plan - G code gallery test part\_CAM  
N65 ;File - G code gallery test part.Z3  
N66 G90 G00 X-38.3798 Y10.8563  
N67 Z100.  
N68 Z67.5  
N69 G01 Y6.5262 Z65. F50.  
N70 G17 G02 X-45. Y5.2786 I-11.6202 J43.4738  
N71 G01 Y45. F100.  
N72 X-38.3798 F250.  
N73 Y6.5262  
N74 G03 X-31.7596 Y8.8626 I-11.6202 J43.4738  
N75 G01 Y45.  
N76 X-25.1393  
N77 Y12.4907  
N78 G03 X-18.5191 Y17.8449 I-24.8607 J37.5093  
N79 G01 Y45.  
N80 X-11.8989  
N81 Y26.0562  
N82 G03 X-5.2786 Y45. I-38.1011 J23.9438  
N83 G01 X-11.8989  
N84 G00 Z100.  
N85 Z67.5  
N86 G01 Z65. F50.  
N87 X-45. F250.  
N88 Y5.2786  
N89 G03 X-5.2786 Y45. I-5. J44.7214  
N90 G01 X-15.8989  
N91 G03 X-22.3989 Y38.5 I0 J-6.5 F750.  
N92 G01 Y32.  
N93 G00 Z100.  
N94 ;Operation - Rough Plunge 1  
N95 ;Tactic - Rough Plunge 1  
N96 ;Plan - G code gallery test part\_CAM  
N97 ;File - G code gallery test part.Z3  
N98 X-6.9286 Y-6.9286  
N99 Z72.  
N100 G01 Z67. F50.  
N101 Z51. F250.  
N102 Z72.  
N103 Y0  
N104 Z67. F50.  
N105 Z51. F250.  
N106 Z72.  
N107 Y6.9286  
N108 Z67. F50.  
N109 Z51. F250.  
N110 Z72.  
N111 X0  
N112 Z67. F50.  
N113 Z51. F250.  
N114 Z72.  
N115 X6.9286

N116 Z67. F50.  
N117 Z51. F250.  
N118 Z72.  
N119 Y0  
N120 Z67. F50.  
N121 Z51. F250.  
N122 Z72.  
N123 X0  
N124 Z67. F50.  
N125 Z51. F250.  
N126 Z72.  
N127 X6.9286 Y-6.9286  
N128 Z67. F50.  
N129 Z51. F250.  
N130 Z72.  
N131 X0  
N132 Z67. F50.  
N133 Z51. F250.  
N134 G00 Z100.  
N135 ;Operation - InterPath 1  
N136 ;Tactic - InterPath 1  
N137 ;Plan - G code gallery test part\_CAM  
N138 ;File - G code gallery test part.Z3  
N139 G01 X145. Y3.528 F250.  
N140 X145.4358 Z99.981  
N141 X145.8682 Z99.924  
N142 X146.2941 Z99.8296  
N143 X146.7101 Z99.6985  
N144 X147.1131 Z99.5315  
N145 X147.5 Z99.3301  
N146 X147.8679 Z99.0958  
N147 X148.2139 Z98.8302  
N148 X148.5355 Z98.5355  
N149 X148.8302 Z98.2139  
N150 X149.0958 Z97.8679  
N151 X149.3301 Z97.5  
N152 X149.5315 Z97.1131  
N153 X149.6985 Z96.7101  
N154 X149.8296 Z96.2941  
N155 X149.924 Z95.8682  
N156 X149.981 Z95.4358  
N157 X150. Z95.  
N158 Z1.8698  
N159 ;Operation - Spiralcut 1  
N160 ;Tactic - Spiralcut 1  
N161 ;Plan - G code gallery test part\_CAM  
N162 ;File - G code gallery test part.Z3  
N163 G00 X87.5  
N164 G01 X87.2222 Y3.278 Z2.2799 F50.  
N165 X86.9444 Y2.9804 Z2.6571  
N166 X86.6667 Y2.6398 Z2.9958  
N167 X86.3889 Y2.2609 Z3.2911  
N168 X86.1111 Y1.8493 Z3.5388  
N169 X85.8333 Y1.4109 Z3.7353  
N170 X85.5556 Y.9521 Z3.8777  
N171 X85.2778 Y.4795 Z3.964  
N172 X85. Y0 Z4.  
N173 G19 G03 Y-3.4641 Z-2. J0 K-4. F100.  
N174 Y3.4641 J3.4641 K2.

N175 Y0 Z4. J-3.4641 K2.  
N176 G01 Z10. F250.  
N177 G03 Y-8.6603 Z-5. J0 K-10.  
N178 Y8.6603 J8.6603 K5.  
N179 Y0 Z10. J-8.6603 K5.  
N180 Y-3.8942 Z9.2106 J0 K-10.  
N181 Y-7.3499 Z.6925 J2.5312 K-5.9869 F750.  
N182 G01 Y-4.8186 Z-5.2944  
N183 G00 X150.  
N184 Y-6.5 Z3.  
N185 X87.5  
N186 G01 X85. F50.  
N187 Z-3.5 F150.  
N188 G03 Y0 Z-10. J6.5 K0  
N189 Y8.6603 Z-5. J0 K10. F250.  
N190 Y0 Z10. J-8.6603 K5.  
N191 Y-8.6603 Z-5. J0 K-10.  
N192 Y0 Z-10. J8.6603 K5.  
N193 Y3.8942 Z-9.2106 J0 K10.  
N194 Y7.3499 Z-.6925 J-2.5312 K5.9869 F750.  
N195 G01 Y4.8186 Z5.2944  
N196 G00 X150.  
N197 SUPA G91 G74 Z0.0  
N198 SUPA G74 X0.0 Y0.0  
N199 M05  
N200 M09  
N201 ;End of program.  
N202 M30  
%