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%_N_ZW_SINUMERIK_4X_A_MPF
$PATH=/_N_MPF_DIR
;[yyyy-mm-dd hh:mm:ss] 2020-12-04 12:46:44
N1 G54 G40 G17 G94 G90 G71
N2 ;Programmed by Author
N3 ;
N4 ;Tool 0 is 5 mm Flat Endmill.
N5 ;SHAPE PARAMETERS
N6 TRAF00F
N7 SUPA G91 G74 Z0.0
N8 SUPA G74 X0.0 Y0.0
N9 G90 A0.0 C0.0
N10 M05
N11 T0 M06
N12 T0
N13 G64
N14 SOFT
N15 TRAORI
N16 TCOFR
N17 S1000 M03
N18 G64
N19 M08
N20 ;Operation - Profilecut 1
N21 ;Tactic - Profilecut 1
N22 ;Plan - G code gallery test part_CAM
N23 ;File - G code gallery test part.Z3
N24 ORIWKS
N25 ORIAxes
N26 G90 G00 X49. Y-30.
N27 Z100.
N28 Z52.5
N29 G01 Z50. F50.
N30 Y-23.5 F150.
N31 G17 G03 X42.5 Y-30. I0 J-6.5
N32 G02 X23.75 Y-40.8253 I-12.5 J0 F250.
N33 Y-19.1747 I6.25 J10.8253
N34 X42.5 Y-30. I6.25 J-10.8253
N35 G03 X49. Y-36.5 I6.5 J0 F750.
N36 G01 Y-30.
N37 G00 Z100.
N38 ;Operation - Profilecut 2
N39 ;Tactic - Profilecut 2
N40 ;Plan - G code gallery test part_CAM
N41 ;File - G code gallery test part.Z3
N42 X-35. Y-44.
N43 Z52.5
N44 G01 Z50. F50.
N45 X-28.5 F150.
N46 G03 X-35. Y-37.5 I-6.5 J0
N47 G02 X-37.5 Y-35. I0 J2.5 F250.
N48 G01 Y-25.
N49 G02 X-35. Y-22.5 I2.5 J0
N50 G01 X-25.
N51 G02 X-22.5 Y-25. I0 J-2.5
N52 G01 Y-35.
N53 G02 X-25. Y-37.5 I-2.5 J0
N54 G01 X-35.
N55 G03 X-41.5 Y-44. I0 J-6.5 F750.
N56 G01 X-35.
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N57 G00 Z100.
N58 M09
N59 ;Tool Ø is 10 mm Flat Endmill.
N60 ;SHAPE PARAMETERS
N61 TRAF00F
N62 SUPA G91 G74 Z0.0
N63 SUPA G74 X0.0 Y0.0
N64 M05
N65 G90 G60
N66 M06
N67 T0
N68 G64
N69 SOFT
N70 TRAORI
N71 TCOFR
N72 S1000 M03
N73 G64
N74 M08
N75 ;Operation - Zigzagcut 1
N76 ;Tactic - Zigzagcut 1
N77 ;Plan - G code gallery test part_CAM
N78 ;File - G code gallery test part.Z3
N79 G90 G00 X-38.3798 Y10.8563
N80 Z100.
N81 Z67.5
N82 G01 Y6.5262 Z65. F50.
N83 G17 G02 X-45. Y5.2786 I-11.6202 J43.4738
N84 G01 Y45. F100.
N85 X-38.3798 F250.
N86 Y6.5262
N87 G03 X-31.7596 Y8.8626 I-11.6202 J43.4738
N88 G01 Y45.
N89 X-25.1393
N90 Y12.4907
N91 G03 X-18.5191 Y17.8449 I-24.8607 J37.5093
N92 G01 Y45.
N93 X-11.8989
N94 Y26.0562
N95 G03 X-5.2786 Y45. I-38.1011 J23.9438
N96 G01 X-11.8989
N97 G00 Z100.
N98 Z67.5
N99 G01 Z65. F50.
N100 X-45. F250.
N101 Y5.2786
N102 G03 X-5.2786 Y45. I-5. J44.7214
N103 G01 X-15.8989
N104 G03 X-22.3989 Y38.5 I0 J-6.5 F750.
N105 G01 Y32.
N106 G00 Z100.
N107 ;Operation - Rough Plunge 1
N108 ;Tactic - Rough Plunge 1
N109 ;Plan - G code gallery test part_CAM
N110 ;File - G code gallery test part.Z3
N111 X-6.9286 Y-6.9286
N112 Z72.
N113 G01 Z67. F50.
N114 Z51. F250.
N115 Z72.
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N116 Y0
N117 Z67. F50.
N118 Z51. F250.
N119 Z72.
N120 Y6.9286
N121 Z67. F50.
N122 Z51. F250.
N123 Z72.
N124 X0
N125 Z67. F50.
N126 Z51. F250.
N127 Z72.
N128 X6.9286
N129 Z67. F50.
N130 Z51. F250.
N131 Z72.
N132 Y0
N133 Z67. F50.
N134 Z51. F250.
N135 Z72.
N136 X0
N137 Z67. F50.
N138 Z51. F250.
N139 Z72.
N140 X6.9286 Y-6.9286
N141 Z67. F50.
N142 Z51. F250.
N143 Z72.
N144 X0
N145 Z67. F50.
N146 Z51. F250.
N147 G00 Z100.
N148 ;Operation - InterPath 1
N149 ;Tactic - InterPath 1
N150 ;Plan - G code gallery test part_CAM
N151 ;File - G code gallery test part.Z3
N152 G01 X145. Y3.528 F250.
N153 X145.4358 Z99.981 A-5.0003 C-90.
N154 X145.8682 Z99.924 A-10.0001
N155 X146.2941 Z99.8296 A-15.
N156 X146.7101 Z99.6985 A-20.
N157 X147.1131 Z99.5315 A-25.
N158 X147.5 Z99.3301 A-29.9999
N159 X147.8679 Z99.0958 A-35.0002
N160 X148.2139 Z98.8302 A-40.0003
N161 X148.5355 Z98.5355 A-45.
N162 X148.8302 Z98.2139 A-49.9997
N163 X149.0958 Z97.8679 A-54.9998
N164 X149.3301 Z97.5 A-60.0001
N165 X149.5315 Z97.1131 A-65.
N166 X149.6985 Z96.7101 A-70.
N167 X149.8296 Z96.2941 A-75.
N168 X149.924 Z95.8682 A-79.9999
N169 X149.981 Z95.4358 A-84.9997
N170 X150. Z95. A-90.
N171 Z1.8698
N172 ;Operation - Spiralcut 1
N173 ;Tactic - Spiralcut 1
N174 ;Plan - G code gallery test part_CAM

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N175 ;File - G code gallery test part.Z3
N176 G00 X87.5
N177 G01 X87.2222 Y3.278 Z2.2799 F50.
N178 X86.9444 Y2.9804 Z2.6571
N179 X86.6667 Y2.6398 Z2.9958
N180 X86.3889 Y2.2609 Z3.2911
N181 X86.1111 Y1.8493 Z3.5388
N182 X85.8333 Y1.4109 Z3.7353
N183 X85.5556 Y.9521 Z3.8777
N184 X85.2778 Y.4795 Z3.964
N185 X85. Y0 Z4.
N186 G19 G03 Y-3.4641 Z-2. J0 K-4. F100.
N187 Y3.4641 J3.4641 K2.
N188 Y0 Z4. J-3.4641 K2.
N189 G01 Z10. F250.
N190 G03 Y-8.6603 Z-5. J0 K-10.
N191 Y8.6603 J8.6603 K5.
N192 Y0 Z10. J-8.6603 K5.
N193 Y-3.8942 Z9.2106 J0 K-10.
N194 Y-7.3499 Z.6925 J2.5312 K-5.9869 F750.
N195 G01 Y-4.8186 Z-5.2944
N196 G00 X150.
N197 Y-6.5 Z3.
N198 X87.5
N199 G01 X85. F50.
N200 Z-3.5 F150.
N201 G03 Y0 Z-10. J6.5 K0
N202 Y8.6603 Z-5. J0 K10. F250.
N203 Y0 Z10. J-8.6603 K5.
N204 Y-8.6603 Z-5. J0 K-10.
N205 Y0 Z-10. J8.6603 K5.
N206 Y3.8942 Z-9.2106 J0 K10.
N207 Y7.3499 Z-.6925 J-2.5312 K5.9869 F750.
N208 G01 Y4.8186 Z5.2944
N209 G00 X150.
N210 SUPA G91 G74 Z0.0
N211 SUPA G74 X0.0 Y0.0
N212 SUPA G74 A0.0 C0.0
N213 TRAF00F
N214 SOFT
N215 G64
N216 G60
N217 M05
N218 M09
N219 ;End of program.
N220 M30
%
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