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%_N_ZW_Turning_SINUMERIK_802D_MPF;  
;$PATH=/_N_MPF_DIR;  
;[yyyy-mm-dd hh:mm:ss] 2021-02-05 10:13:11  
N1 ;PROGRAMMED BY AUTHOR  
N2 ;TOOL 0 IS TOOL 1.  
N3 ;SHAPE PARAMETERS  
N4 T0 D1  
N5 S1000 M03  
N6 M08  
N7 ;OPERATION - ROUGH TURN 1  
N8 ;TACTIC - ROUGH TURN 1  
N9 ;PLAN - G CODE TURNING TEST PART_CAM  
N10 ;FILE - G CODE TURNING TEST PART.Z3  
N11 G94 G01 X83.228 Z103.2 F50.0  
N12 X76.65  
N13 Z101.2 F150.0  
N14 Z45.2 F250.0  
N15 X80.4  
N16 Z0  
N17 X83.228 Z1.414 F750.0  
N18 Z103.2 F250.0  
N19 X79.878 F50.0  
N20 X72.9  
N21 Z101.2 F150.0  
N22 Z45.2 F250.0  
N23 X77.05  
N24 X79.878 Z46.614 F750.0  
N25 Z103.2 F250.0  
N26 X76.128 F50.0  
N27 X69.15  
N28 Z101.2 F150.0  
N29 Z45.2 F250.0  
N30 X73.3  
N31 X76.128 Z46.614 F750.0  
N32 Z103.2 F250.0  
N33 X72.378 F50.0  
N34 X65.4  
N35 Z101.2 F150.0  
N36 Z45.2 F250.0  
N37 X69.55  
N38 X72.378 Z46.614 F750.0  
N39 Z103.2 F250.0  
N40 X68.628 F50.0  
N41 X61.65  
N42 Z101.2 F150.0  
N43 Z45.2 F250.0  
N44 X65.8  
N45 X68.628 Z46.614 F750.0  
N46 Z103.2 F250.0  
N47 X64.878 F50.0  
N48 X57.9  
N49 Z101.2 F150.0  
N50 Z54.743 F250.0  
N51 G03 X60.4 Z49.8 CR= 10.4001  
N52 G01 Z45.2  
N53 X62.05  
N54 X64.878 Z46.614 F750.0  
N55 Z103.2 F250.0  
N56 X61.128 F50.0
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N57 X54.15
N58 Z101.2 F150.0
N59 Z57.232 F250.0
N60 G03 X58.3 Z54.354 CR= 10.4001
N61 G01 X61.128 Z55.768 F750.0
N62 Z103.2 F250.0
N63 X57.378 F50.0
N64 X50.4
N65 Z101.2 F150.0
N66 Z58.688 F250.0
N67 G03 X54.55 Z57.031 CR= 10.4001
N68 G01 X57.378 Z58.445 F750.0
N69 Z103.2 F250.0
N70 X53.628 F50.0
N71 X46.65
N72 Z101.2 F150.0
N73 Z59.584 F250.0
N74 G03 X50.8 Z58.564 CR= 10.4001
N75 G01 X53.628 Z59.978 F750.0
N76 Z103.2 F250.0
N77 X49.878 F50.0
N78 X42.9
N79 Z101.2 F150.0
N80 Z60.068 F250.0
N81 G03 X47.05 Z59.51 CR= 10.4001
N82 G01 X49.878 Z60.924 F750.0
N83 Z103.2 F250.0
N84 X46.128 F50.0
N85 X39.15
N86 Z101.2 F150.0
N87 Z60.2 F250.0
N88 X39.6
N89 G03 X43.3 Z60.034 CR= 10.4001
N90 G01 X46.128 Z61.448 F750.0
N91 Z103.2 F250.0
N92 X42.378 F50.0
N93 X35.4
N94 Z101.2 F150.0
N95 Z60.2 F250.0
N96 X39.55
N97 X42.378 Z61.614 F750.0
N98 Z103.2 F250.0
N99 X38.628 F50.0
N100 X31.65
N101 Z101.2 F150.0
N102 Z60.2 F250.0
N103 X35.8
N104 X38.628 Z61.614 F750.0
N105 Z103.2 F250.0
N106 X34.878 F50.0
N107 X27.9
N108 Z101.2 F150.0
N109 Z76.216 F250.0
N110 X30.4 Z74.966
N111 Z60.2
N112 X32.05
N113 X34.878 Z61.614 F750.0
N114 Z103.2 F250.0
N115 X31.128 F50.0

N116 X24.15
N117 Z101.2 F150.0
N118 Z78.091 F250.0
N119 X28.3 Z76.016
N120 X31.128 Z77.43 F750.0
N121 Z103.2 F250.0
N122 X27.378 F50.0
N123 X20.4
N124 Z101.2 F150.0
N125 Z100.2 F250.0
N126 Z89.39
N127 Z84.8
N128 Z79.966
N129 X24.55 Z77.891
N130 X27.378 Z79.305 F750.0
N131 Z103.2 F250.0
N132 X83.228
N133 ;OPERATION - FINISH TURN 1
N134 ;TACTIC - FINISH TURN 1
N135 ;PLAN - G CODE TURNING TEST PART_CAM
N136 ;FILE - G CODE TURNING TEST PART.Z3
N137 X82.828 Z102.0 F50.0
N138 X-.8
N139 Z100.0 F150.0
N140 X20.0 F250.0
N141 Z79.766
N142 X30.0 Z74.766
N143 Z60.0
N144 X39.209
N145 G03 X60.0 Z49.604 CR= 10.3997
N146 G01 Z45.0
N147 X80.0
N148 Z-.311
N149 X82.828 Z1.103 F750.0
N150 Z102.0 F250.0
N151 M09
N152 ;TOOL 0 IS TOOL 2.
N153 ;SHAPE PARAMETERS
N154 T0 D1
N155 S1000 M03
N156 M08
N157 ;OPERATION - TURN GROOVE 1
N158 ;TACTIC - TURN GROOVE 1
N159 ;PLAN - G CODE TURNING TEST PART_CAM
N160 ;FILE - G CODE TURNING TEST PART.Z3
N161 G01 X22.4 Z85.8 F250.0
N162 X10.4
N163 X22.4
N164 Z85.2 F150.0
N165 X10.4 F250.0
N166 X10.8 Z85.4
N167 X22.4
N168 X24.0
N169 Z85.0
N170 X20.0 F150.0
N171 X10.0 F250.0
N172 Z86.0
N173 X20.0
N174 X24.0

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N175 M05  
N176 M09  
N177 ;END OF PROGRAM.  
N178 M30  
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