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%_N_ZW_Turning_SINUMERIK_802D_MPF;  
;$PATH=/_N_MPF_DIR;  
;[yyyy-mm-dd hh:mm:ss] 2020-12-04 12:49:07  
N1 ;PROGRAMMED BY AUTHOR  
N2 ;TOOL 0 IS 5 MM FLAT ENDMILL.  
N3 ;SHAPE PARAMETERS  
N4 T0 D1  
N5 S1000 M03  
N6 M08  
N7 ;OPERATION - PROFILECUT 1  
N8 ;TACTIC - PROFILECUT 1  
N9 ;PLAN - G CODE GALLERY TEST PART_CAM  
N10 ;FILE - G CODE GALLERY TEST PART.Z3  
N11 G98 G00 X-60.0 Z49.0  
N12 G94 G01 F50.0  
N13 X-47.0 F150.0  
N14 G03 X-60.0 Z42.5 CR= 6.5  
N15 G02 X-81.651 Z23.75 CR= 12.5  
N16 X-38.349 CR= 12.5  
N17 X-60.0 Z42.5 CR= 12.5  
N18 G03 X-73.0 Z49.0 CR= 6.5  
N19 G01 X-60.0  
N20 G00  
N21 ;OPERATION - PROFILECUT 2  
N22 ;TACTIC - PROFILECUT 2  
N23 ;PLAN - G CODE GALLERY TEST PART_CAM  
N24 ;FILE - G CODE GALLERY TEST PART.Z3  
N25 X-88.0 Z-35.0  
N26 G01 F50.0  
N27 Z-28.5 F150.0  
N28 G03 X-75.0 Z-35.0 CR= 6.5  
N29 G02 X-70.0 Z-37.5 CR= 2.5  
N30 G01 X-50.0  
N31 G02 X-45.0 Z-35.0 CR= 2.5  
N32 G01 Z-25.0  
N33 G02 X-50.0 Z-22.5 CR= 2.5  
N34 G01 X-70.0  
N35 G02 X-75.0 Z-25.0 CR= 2.5  
N36 G01 Z-35.0  
N37 G03 X-88.0 Z-41.5 CR= 6.5  
N38 G01 Z-35.0  
N39 G00  
N40 M09  
N41 ;TOOL 0 IS 10 MM FLAT ENDMILL.  
N42 ;SHAPE PARAMETERS  
N43 T0 D1  
N44 S1000 M03  
N45 M08  
N46 ;OPERATION - ZIGZAGCUT 1  
N47 ;TACTIC - ZIGZAGCUT 1  
N48 ;PLAN - G CODE GALLERY TEST PART_CAM  
N49 ;FILE - G CODE GALLERY TEST PART.Z3  
N50 G00 X21.713 Z-38.38  
N51 G01 X13.052 F50.0  
N52 G02 X10.557 Z-45.0 CR= 45  
N53 G01 X90.0 F100.0  
N54 Z-38.38 F250.0  
N55 X13.052  
N56 G03 X17.725 Z-31.76 CR= 45
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N57 G01 X90.0
N58 Z-25.139
N59 X24.981
N60 G03 X35.69 Z-18.519 CR= 45
N61 G01 X90.0
N62 Z-11.899
N63 X52.112
N64 G03 X90.0 Z-5.279 CR= 45
N65 G01 Z-11.899
N66 G00
N67 G01 F50.0
N68 Z-45.0 F250.0
N69 X10.557
N70 G03 X90.0 Z-5.279 CR= 45
N71 G01 Z-15.899
N72 G03 X77.0 Z-22.399 CR= 6.5
N73 G01 X64.0
N74 G00
N75 ;OPERATION - ROUGH PLUNGE 1
N76 ;TACTIC - ROUGH PLUNGE 1
N77 ;PLAN - G CODE GALLERY TEST PART_CAM
N78 ;FILE - G CODE GALLERY TEST PART.Z3
N79 X-13.857 Z-6.929
N80 G01 F50.0
N81 F250.0
N82 X0
N83 F50.0
N84 F250.0
N85 X13.857
N86 F50.0
N87 F250.0
N88 Z0
N89 F50.0
N90 F250.0
N91 Z6.929
N92 F50.0
N93 F250.0
N94 X0
N95 F50.0
N96 F250.0
N97 Z0
N98 F50.0
N99 F250.0
N100 X-13.857 Z6.929
N101 F50.0
N102 F250.0
N103 Z0
N104 F50.0
N105 F250.0
N106 G00
N107 ;OPERATION - INTERPATH 1
N108 ;TACTIC - INTERPATH 1
N109 ;PLAN - G CODE GALLERY TEST PART_CAM
N110 ;FILE - G CODE GALLERY TEST PART.Z3
N111 G01 X7.056 Z145.0 F250.0
N112 Z145.436
N113 Z145.868
N114 Z146.294
N115 Z146.71

N116 Z147.113
N117 Z147.5
N118 Z147.868
N119 Z148.214
N120 Z148.536
N121 Z148.83
N122 Z149.096
N123 Z149.33
N124 Z149.532
N125 Z149.698
N126 Z149.83
N127 Z149.924
N128 Z149.981
N129 Z150.0
N130 ;OPERATION - SPIRALCUT 1
N131 ;TACTIC - SPIRALCUT 1
N132 ;PLAN - G CODE GALLERY TEST PART_CAM
N133 ;FILE - G CODE GALLERY TEST PART.Z3
N134 G00 Z87.5
N135 G01 X6.556 Z87.222 F50.0
N136 X5.961 Z86.944
N137 X5.28 Z86.667
N138 X4.522 Z86.389
N139 X3.699 Z86.111
N140 X2.822 Z85.833
N141 X1.904 Z85.556
N142 X.959 Z85.278
N143 X0 Z85.0
N144 G03 X-6.928 CR= 4
N145 X6.928 CR= 4
N146 X0 CR= 4
N147 G01 F250.0
N148 G03 X-17.321 CR= 10
N149 X17.321 CR= 10
N150 X0 CR= 10
N151 X-7.788 CR= 10
N152 X-14.7 CR= 6.5
N153 G01 X-9.637
N154 G00 Z150.0
N155 X-13.0
N156 Z87.5
N157 G01 Z85.0 F50.0
N158 F150.0
N159 G03 X0 CR= 6.5
N160 X17.321 CR= 10
N161 X0 CR= 10
N162 X-17.321 CR= 10
N163 X0 CR= 10
N164 X7.788 CR= 10
N165 X14.7 CR= 6.5
N166 G01 X9.637
N167 G00 Z150.0
N168 M05
N169 M09
N170 ;END OF PROGRAM.
N171 M30
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