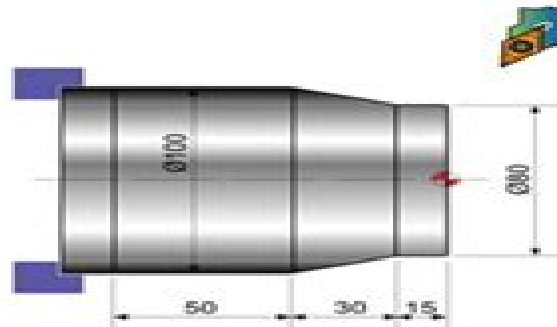


G01 PROGRAM

Example1)



O0001 :

```

N10 G50 S1500 T0100 M42 :
  G96 S180 M03 :
  G00 X100.5 Z5.0 T0101 M08 :
  G01 Z-95.0 F0.25 :
  G00 U2.0 Z0.5 :
  G01 X-1.6 F0.2 :
  G00 X95.0 W1.0 :
  G01 Z-37.3 F0.25 :
    X100.0 Z-45.5 :
  G00 Z1.0 :
    X90.0 :
  G01 Z-29.8 :
    X95.0 Z-37.3 :
  G00 Z1.0 :
    X85.0 :
  G01 Z-22.3 :
    X90.0 Z-29.8 :
  G00 Z1.0 :
    X80.5 :
  G01 Z-15.55 :
    X85.0 Z-22.3 :
  G00 X200.0 Z200.0 M09 T0100 :
  M01 :
```

```

N20 G50 S2000 T0300 :
  G96 S200 M03 :
  G00 X85.0 Z5.0 T0303 M08 :
  Z0 :
  G01 X-1.6 F0.2 :
  G00 X80.0 Z3.0 :
  G42 Z1.0 :
  G01 Z-15.0 F0.18 :
  X100.0 Z-45.0 :
  Z-95.0 :
  G40 U2.0 W1.0
  G00 X200.0 Z200.0 M09 T0300 :
  M30 :
```

G50 : Setting the rotating time of max. speed of main spindle

G96 : Constant surface speed control command

G40 : Compensation cancel

G42 : Right hand compensation

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Clifford Lane



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