G15 H1 (H1表示使得机床上某个基准点，与工件坐标系原点对应)

G90 G17 (G90：绝对坐标编程；G17：XY平面)

M03 S1000 F200 (主轴正转，这里的主轴夹持的是刀具了；1000r/min)

G00 Z50 (非切削指令，机床速度；设定刀具的Z向水平初始高度)

X10.2 Y-22.9 (10.2,-22.9)

G01 Z-0.2 下刀

Y-34.2 (10.2,-34.2)↓

G02 X8.5 Y-43.4 R100 (8.5,-43.4)↙+凹=顺；

G00 Z2 提刀

X14.5 Y-42 (14.5,-42)↗

G01 Z-0.2 下刀

Y-44.1 (14.5,-44.1)↓

G02 X12 Y-45.1 R3.8 (12，-45.1)↙凹

X13.8 Y-48 R4.16 (13.8,-48)↘凸

G03 X12 Y-45.1 R4.16 (12,-45.1)↖凸 最少语句返回

G02 X8.1 Y-47.6 R8.3 (8.1,-47.6)↙凹

G01 X11.6 Y-50.1 (11.6,-50.1)↘

X8.1 Y-47.6 (8.1,-47.6)↖ 返回

G03 X7.4 Y-51.1 R4.9 (7.4,-51.1)↙凸

G01 X7.1 Y-58.6 (7.1,-58.6)↙

G03 X8.5 Y-64.2 R7.8 (8.5,-64.2)↘凹 \*

G00 Z2 提刀

X9.2 Y-52.9 (9.2,-52.9)↖

G01 Z-0.2 下刀

G02 X12 Y-52.6 R5.2 (12,-52.6)→凸

X9.2 Y-52.9 R5.2 (9.2,-52.9)←凹 返回

G00 Z2 提刀

X12.7 Y-57.1 (12.7,-57.1)↘

G01 Z-0.2 下刀

G03 X9.9 Y-59.3 R4.16 (9.9,-59.3)↙凸

G01 X8.5 Y-64.2 (8.5,-64.2)↙ 连接\*

X7.8 Y-66 (7.8,-66)↙

G03 X8.5 Y-69.8 R4.16 (8.5,-69.8)↘凹

X15.2 Y-72.7 R18.2 (15.2,-72.7)↘凹

G01 X22.9 Y-72.3 (22.9,-72.3)→

G00 Z2 提刀

X13.8 Y-74.8 (13.8,-74.8)↙

G01 Z-0.2 下刀

X49 Y-73.7 (49.-73.7)↗

G00 Z2 提刀

X60.7 Y-75.1 (60.7,-75.1)↘

G01 Z-0.2 下刀

G02 X65.3 Y-73.4 R41.6 (65.3,-73.4)↗凸

G01 X73.4 (73.4,-73.4)→

G00 Z2 提刀

X82.5 Y-72.3 (82.5,-72.3)↗

G01 Z-0.2 下刀

G02 X74.4 Y-62.4 R13 (74.4,-62.4)↖凹

G01 Y-65.3 (74.4,-65.3)↓

G02 X73 Y-71.3 R10.4 (73,-71.3)↙凹

X69.5 Y-71.3 R3.64 (69.5,-71.3)←凹

G01 X68.4 Y-64.6 (68.4,-64.6)↖

X68.1 Y-62.1 (68.1,-62.1)↖

X66.3 (66.3,-62.1)←

X64.6 Y-61.7 (64.6,-61.7)↖

X64.9 Y-56.1 (64.9,-56.1)↗

G03 X65.6 Y-48 R30 (65.6,-48)↖凸

G02 X67.4 Y-44.1 R7.8 (67.4,-44.1)↗凸

X69.8 Y-43 R3 (69.8,-43)↗凸

G01 X71.3 (71.3,-43)→

G00 Z2 提刀

X71.6 Y-41.3 (71.6,-41.3)↗

G01 Z-0.2 下刀

G03 X77.2 Y-45.1 R10 (77.2,-45.1)↘凹

G00 Z2 提刀

X75.1 Y-43.4 (75.1,-43.4)↖

G01 Z-0.2 下刀

G02 X77.2 Y-45.1 R5.5 (77.2,-45.1)↘凸

G01 X85.7 Y-55.7 (85.7,-55.7)↘

G03 X93.8 Y-61 R15.6 (93.8,-61)↘凹

G00 Z2 提刀

X73 Y-50.4 (73,-50.4)↖

G01 Z-0.2 下刀

G03 X74.8 Y-54.3 R15 (74.8,-54.3)↘凹

G02 X75.8 Y-58.9 R7 (75.8,-58.9)↘凸

G01 X76.9 Y-54.7 (76.9,-54.7)↗

X78 Y-53.3 (78,-53.3)↗

G00 Z2 提刀

X75.8 Y-58.9 (75.8,-58.9)↙

G01 Z-0.2 下刀

G02 X74.4 Y-62.1 R7.5 (74.4,-62.1)↙凹

G01 X66.3 Y-62.1 (66.3,-62.1)←

X66.7 Y-64.9 (66.7,-64.9)↘

G03 X68.4 Y-66.7 R2.6 (68.4,-66.7)↘凹

G01 X65.3 Y-66.7 (65.3,-66.7)←

G03 X64.6 Y-67.4 R2 (64.6,-67.4)↙凸

X62.4 Y-68.8 R2 (62.4,-68.8)↙凸

X60.7 Y-71.6 R3 (62.7,-71.6)↙凸

G01 X62.4 Y-70.5 (62.4,-70.5)↗

Y71.6 (62.4,-71.6)↓

X63.8 Y-70.5 (63.8,-70.5)↗

X64.6 Y-71.6 (64.6,-71.6)↘

X66.7 Y-69.5 (66.7,-69.5)↗

X65.3 Y-70.9 (65.3,-70.9)↙

Y-71.6 (65.3,-71.6)↓

X67 (67,-71.6)→

X68.8 Y-69.8 (68.8,-69.8)↗

G00 Z2 提刀

X25.7 Y-30 (25.7,-30)

G01 Z-0.2 下刀

G02 X29.3 Y-31.4 R4.16 (29.3,-31.4)↘凸

G01 X30.7 Y-33.5 (30.7,-33.5)↘

G02 X30.7 Y-36 R4 (30.3,-36)↙凹

G01 X27.5 Y-32.5 (27.5,-32.5)↖

X30.7 Y-36 (30.3,-36)↘

X28.6 Y-35.6 (28.6,-35.6)↖

G03 X28.2 Y-38.1 R5 (28.2,-35.1)↙凸

X29.6 Y-39.2 R1.6 (29.6,-39.2)↘凹

G01 Y-40.2 (29.6,-40.2)↓

X29.3 Y-40.6 (29.3,-40.6)↙

Y-42 (29.3,-42)↓

X28.9 Y-43.7 (28.9,-43.7)↙

X28.6 Y-44.1 (28.6,-44.1)↙

X27.5 (27.5,-44.1)←

G03 X25.7 Y-45.1 R1.6 (25.7,-45.1)↙凸

X25.4 Y-48.3 R4 (25.4,-48.3)↙凸

G00 Z2 提刀

X25.7 Y-45.9 (25.7,-45.9)

G01 Z-0.2 下刀

G02 X27.9 Y-46.2 R2.6 (27.9,-46.2)↘凸

G01 X31.4 Y-48.3 (31.4,-48.3)↘

X30.7 Y-52.6 ↙

X31.4 Y-48.3 ↗

G02 X32.8 Y-44.4 R8 (32.8,-44.4)↗凸

X33.9 Y-44.1 R3 (33.9,-44.1)↗凸

X37.7 Y-44.8 R20 (37.7,-44.8)↘凸

X38.8 Y-46.6 R2.5 (38.8,-46.6)↘凸

G01 X40.2 Y-54 (40.2,-54)↘

X39.9 Y-46.2 (39.9,-46.2)↖

G03 X46.6 Y-45.9 R15 (46.6,-45.9)↗凹

G01 X50.1 Y-44.8 (50.1,-44.8)↗

G02 X52.9 Y-44.4 R10 (52.9,-44.4)↗凸

X55.7 Y-44.4 R6 (55.7,-44.4)↘凸

G03 X58.2 Y-43 R1.8 (58.2,-43)↗凹

G01 X57.8 Y-39.9 (57.8,-39.9)↖

X58.2 Y-39.2 (58.2,-39.2)↗

Y-34.6 (58.2,-34.6)↑

X57.5 Y-33.5 (57.5,-33.5)↖

X57.1 Y-33.2 ↖

X56.4 Y-33.5 ↙

Y-35.6 ↓

G02 X55.4 Y-38.4 R4.7 (55.4,-38.4)↙凹

G01 X53.6 Y-40.9 ↙

X36.3 ←

G03 X33.5 Y-44.1 R4.7 ↙凸

G00 Z2 提刀

X58.2 Y-43 (58.2,-43)

G01 Z-0.2 下刀

X58.6 Y-43.7 ↘

X58.9 Y-44.4 ↘

X61 →

X63.1 Y-43 ↗

X61 Y-44.4 ↙

G02 X63.8 Y-46.2 R2.5 ↘凸

G03 X65.6 Y-48.3 R2 ↘凹

G00 Z2 提刀

X69.5 Y-42.7 (69.5,-42.7)

G01 Z-0.2 下刀

X66 Y-40.2 ↖

X65.3 Y-41.3 ↙

X66 Y-40.2 ↗

X66.3 Y-39.5 ↗

X67.7 Y-38.8 ↗

X68.4 Y-37.7 ↗

X68.4 Y-36.7 ↑

X68.1 Y-35.6 ↖

X67 ←

X65.6 Y-37.4 ↙

X65.3 Y-38.4 ↙

X64.9 Y-36.7 ↖

X62.4 Y-33.5 ↖

Y-34.9 ↓

X63.5 Y-36.7 ↘

X59.3 Y-33.9 ↖

G00 Z2 提刀

X57.1 Y-32.8 (57.1,-32.8)

G01 Z-0.2 下刀

G02 X60 Y-28.9 R5.2 ↗凸

G03 X56.4 Y-31.4 R10 ↙凸

G01 X59.3 Y-27.9 ↗

X56.4 Y-28.9 ↙

X58.6 Y-27.2 ↗

X60.3 Y-26.5 ↗

X62.4 Y-25.4 ↗

X65.6 →

X69.1 Y-27.2 ↘

X66.7 Y-25 ↖

X64.6 Y-24 ↖

X67.4 Y-24.7 ↘

X69.1 Y-25.7 ↘

X72.7 Y-29.3 ↘

G02 X74.4 Y-33.5 R5.7 ↘凸

G01 Y-34.2 ↓

X71.6 Y-31.4 ↖

X73.4 Y-33.2 ↘

Y-35.6 ↓

X73 Y-37.4 ↙

X72.3 Y-39.9 ↙

X71.6 Y-41.3 ↙

G00 Z2 提刀

X58.2 Y-35.6 (58.2,-35.6)

G01 Z-0.2 下刀

X60.7

G00 Z2 提刀

X58.6 Y-37 (58.6,-37)

G01 Z-0.2 下刀

X60.7

G00 Z2 提刀

X28.6 Y-35.6 (28.6,-35.6)

G01 Z-0.2 下刀

X27.5 Y-33.9 ↖

X27.9 Y-37.7 ↘

X27.2 Y-37 ↖

X26.1 Y-37 ←

X25.4 Y-37.7 ↙

X24.3 Y-39.5 ↙

X23.3 Y-40.2 ↙

X22.2 Y-41.3 ↙

X21.9 Y-40.6 ↖

X20.8 Y-40.2 ←

X20.5 Y-40.9 ↓

X21.2 Y-41.6 ↘

X22.2 Y-42.3 ↘

X23.3 Y-43.7 ↘

X23.6 Y-44.8 ↓

X22.6 Y-46.6 ↙

X27.5 Y-50.4 ↘

Y-48.7 ↑

Y-50.4 ↓

X30.7 Y-53.3 ↘

X32.5 Y-54 ↘

X33.9 Y-52.9 →

Y-50.4 ↑

X34.6 Y-49.4 ↗

X33.5 Y-48.7 ↖

G00 Z2 提刀

X33.9 Y-52.9 (33.9,-52.9)

G01 Z-0.2 下刀

X36.3 Y-53.3 →

X44.1 Y-56.1 ↘

X48 Y-58.6 ↘

X46.6 Y-60.7 ↙

X44.8 Y-61.0 ↙

X43.7 Y-58.6 ↖

X45.5 Y-60 ↘

G00 Z2 提刀

X44.1 Y-59.3 (44.4,-59.3)

G01 Z-0.2 下刀

X43.7 Y-60.3 ↙

X43 Y-60.7 ←

X42 Y-59.3 ↖

Y-57.8 ↑

X32.1 ←

X20.8 Y-52.6 ↖

G00 Z2 提刀

X22.6 Y-46.6 (22.6,-46.6)

G01 Z-0.2 下刀

X19.4 Y-45.1

X18 Y-45.5

X16.9 Y-47.3

Y-50.8

X19.4 Y-59.3

X24.3 Y-54.3

X19.4 Y-59.3

X26.5 Y-69.8 \*

X28.2 Y-67.4

X29.6 Y-57.1

Y-63.1

X31 Y-67.4

X33.5 Y-69.1

X36.3 Y-70.9

X38.1 Y-71.3

X39.9 Y-69.5

X40.6 Y-67.4

X39.9 Y-64.6

X38.8 Y-62.8

X35.3 Y-57.8

X39.5 Y-63.8

X40.6 Y-65.6

X41.6 Y-67

X43

X45.1 Y66

X46.6 Y-65.6

X47.6

X48.7 Y-64.6

X50.1 Y-63.5

Y-61

X48.7 Y-62.4

X43.4 Y-62.8

X42.3 Y-62.1

X40.9 Y-57.8

G00 Z2 提刀

X26.5 Y-69.8 (26.5,-69.8)

G01 Z-0.2 下刀

X28.9 Y-72.3

X32.1 Y-73

X35.6 Y-72.7

X37 Y-71.6

X37.7 Y-69.1

X38.1 Y-64.6

X37.7 Y-61

G00 Z2 提刀

X39.9 Y-51.9 (39.9,-51.9)

G01 Z-0.2 下刀

X42 Y-53.6

X40.6 Y-54.7

X42 Y-53.6

X43 Y-54

X41.6 Y-55

X43 Y-54

X45.5 Y-56.8

G00 Z2 提刀

X25.7 Y-30 (25.7,-30)

G01 Z-0.2 下刀

X23.6 Y-28.6

X19.8

X16.9 Y-30

X14.8 Y-32.5

X13.8 Y-34.9

X14.5 Y-39.2

X14.5 Y-44.1

X13.4 Y-50.1

X12.7 Y-55.4

Y-62.1

X14.1 Y-66.3

X15.9 Y-69.1

G00 Z2 提刀

X17.3 Y-69.1 (17.3,-69.1)

G01 Z-0.2 下刀

X16.2 Y-67.7

X15.5 Y-65.3

Y-59.3

X16.6 Y-53.3

X18.3 Y-59.6

X20.8 Y-65.3

X22.6 Y-67.4

G00 Z2 提刀

X16.6 Y-61.7 (16.6,-61.7)

G01 Z-0.2 下刀

X18.7 Y-68.1

X18.0 Y-64.6

Y-61.7

G00 Z2 提刀

X27.5 Y-38.8 (27.5,-38.8)

G01 Z-0.2 下刀

X27.2

X25.7 Y-39.5

G00 Z2 提刀

X28.2 Y-42 (28.2,-42)

G01 Z-0.2 下刀

X27.5

G00 Z50

M05

M30