

## Upload/Step\_Turn.MPF

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1 G90G18G710G40;      (Parameter Settings)
2 G74X0Z0;              (Return tool at home Position)
3 M03S200;              (Spindel rotate clockwise at 200 rpm)
4 G00X31                (Rapid travel of tool near workpiece at a safe distance
first in X)
5 Z2;                  (then in Z)
6 (First making 20 mm diameter for 70mm length of shaft)
7 X28;                 (Position of cut)
8 G01Z-70F0.1;         (Cutting in z with feed rate in mm/min)
9 G00Z-68X29;          (Retrieval of Tool)
10 Z2;                 (Rapid travel of tool near workpiece in Z)
11 X26;                 (Position of cut)
12 G01Z-70;             (Cutting)
13 G00Z-68X29;          (Ret. of Tool)
14 Z2;                 (Rapid travel of tool near workpiece in Z)
15 X24;                 (Position of cut)
16 G01Z-70;             (Cutting)
17 G00Z-68X29;          (Ret. of tool)
18 Z2;                 (Rapid travel of tool near workpiece in Z)
19 X22;                 (Position of Tool)
20 G01Z-70;             (Cutting)
21 G00Z-68X29;          (Ret. of tool)
22 Z2;                 (Rapid travel of tool near workpiece in Z)
23 X20;                 (Position of tool)
24 G01Z-70;             (Cutting)
25 G00Z-68X28;          (Ret. of tool)
26 (Now making 25 mm diameter for 80mm length of shaft)
27 G01Z-150;            (Cutting)
28 G00Z-148X29;         (Ret. of tool)
29 Z-68;                (Rapid travel of tool near workpiece in Z)
30 X26;                 (Position of cut)
31 G01Z-150;            (Cutting)
32 G00Z-148X29;         (Ret. of tool)
33 Z-68;                (Rapid travel of tool near workpiece in Z)
34 X25;                 (Position of cut)
35 G01Z-150;            (Cutting)
36 G00Z-148X29;         (Ret. of tool)
37 Z2;                 (Rapid travel of tool near workpiece in Z)
38 G74X0Z0;             (Return tool at home Position)
39 M05;                 (Spindle stop)
40 M30;                 (End of Program)
41
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