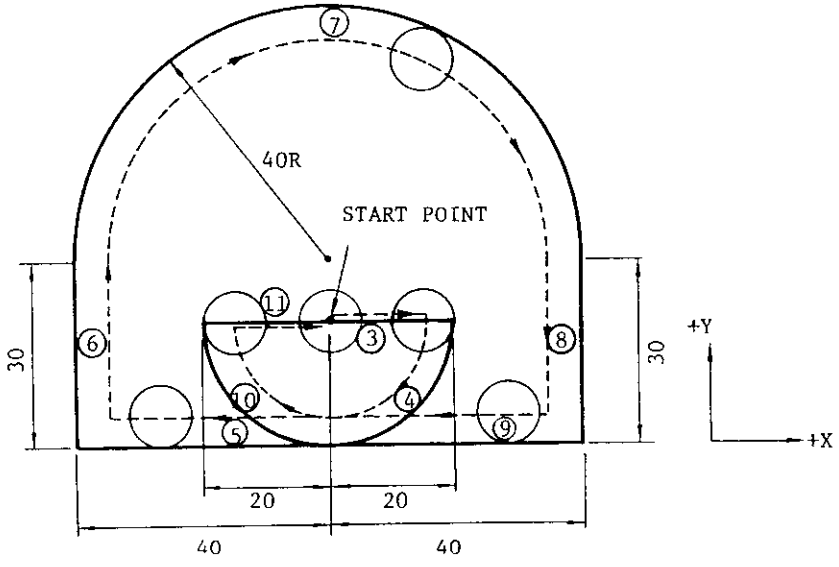
EXAMPLE B



(G40)

① G91 G01 Z-2500 F150 ;
② G17 F300 ;
③ G42 D20 X2000 ;
④ G02 X-2000 Y-2000 I-2000 ;
⑤ G01 X-4000 ;
⑥ Y3000 ;
⑦ G02 X8000 I4000 ;
⑧ G01 Y-3000 ;
⑨ X-4000 ;
⑩ G02 X-2000 Y2000 J2000 ;
⑪ G40 G01 X2000 ;
⑫ Z2500 ;

With the inner cutting in EXAMPLE A, the double cutting allowance at the cutting start and cutting end varies with the tool radius. An inner cutting case with zero double cutting allowance regardless of the cutter radius is shown in EXAMPLE B.

Fig. 2.60