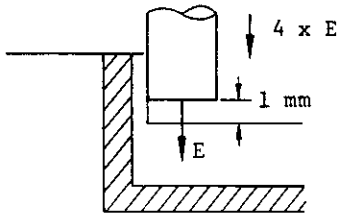
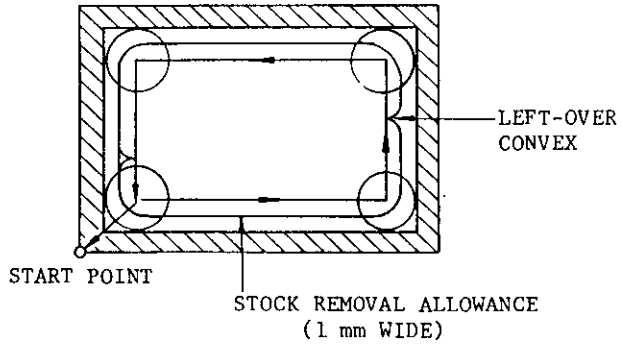


The stock removal allowance (1 mm) inside the finish allowance is all cut by a single operation in the final process as shown below. Then, the tool returns to the start point, completing the cycle.



C. User Macro Body

```
O9061 ;
#10 = # [2000 + #7]; ··· Tool radius
#11 = #6 + 1.0 + #10 ;
#12 = #5 - 2 * #11 ;
#13 = 2 * #10 * #20/100 ; ··· Cut width
#14 = FUP [#12/#13] ; ··· X-axis cut count: -1
#27 = #24 + #11 ; ···   } X, Y coordinates of
#28 = #25 + #11 ; ···   } machining start point
#29 = #26 + #6 ; ··· Z-axis coordinates of
                     cut bottom
#30 = #24 + #4 - #11 ;
#15 = #4003 ; ··· Read of G90/G91
G90 ; ··· Absolute command
G00 X#27 Y#28 ;
G00 Z#18 ;
#32 = #18 ; ··· #32: Cut bottom in execution
DO 1 ;
#32 = #32 - #17 ;
IF [#32 GT#29] GO TO 1 ;
#32 = #29 ;
N1 G01 Z#32 F#8 ;
G01 X#30 F#9 ;
#33 = 1 ;
WHILE [#33 LE#14] DO 2 ;
IF [#33 EQ#14] GO TO 2 ;
G01 Y [#28 + #33 * #13] F#9 ;
GO TO 3 ;
N2 G01 Y [#25 + #5 - #11] ;
N3 IF [#33 AND 1 EQ 0] GOTO 4 ;
G01 X#27 ;
GO TO 5 ;
N4 G01 X#30 ;
N5 #33 = #33 + 1 ;
END 2 ;
G00 Z#18 ;
IF [#32 LE#29] GO TO 6 ;
G00 X#27 Y#28 ;
G01 Z [#32 + 1.0] F [4 * #8] ;
END 1 ;
N6 #11 = #11 - 1.0 ;
#27 = #27 - 1.0 ;
#28 = #28 - 1.0 ;
#30 = #30 + 1.0 ;
#31 = #25 + #5 - #11
G00 X#27 Y#28 ;
G01 Z#32 F#8 ;
G01 X#30 F#9 ;
    Y#31 ;
    X#27 ;
    Y#28 ;
G00 Z#18 ;
G00 X#24 Y#25 ; ··· Return to start point
G#15 ; ··· Restore of G90/G91
M99 ;
```

α cut loop

Stock removal cycle