

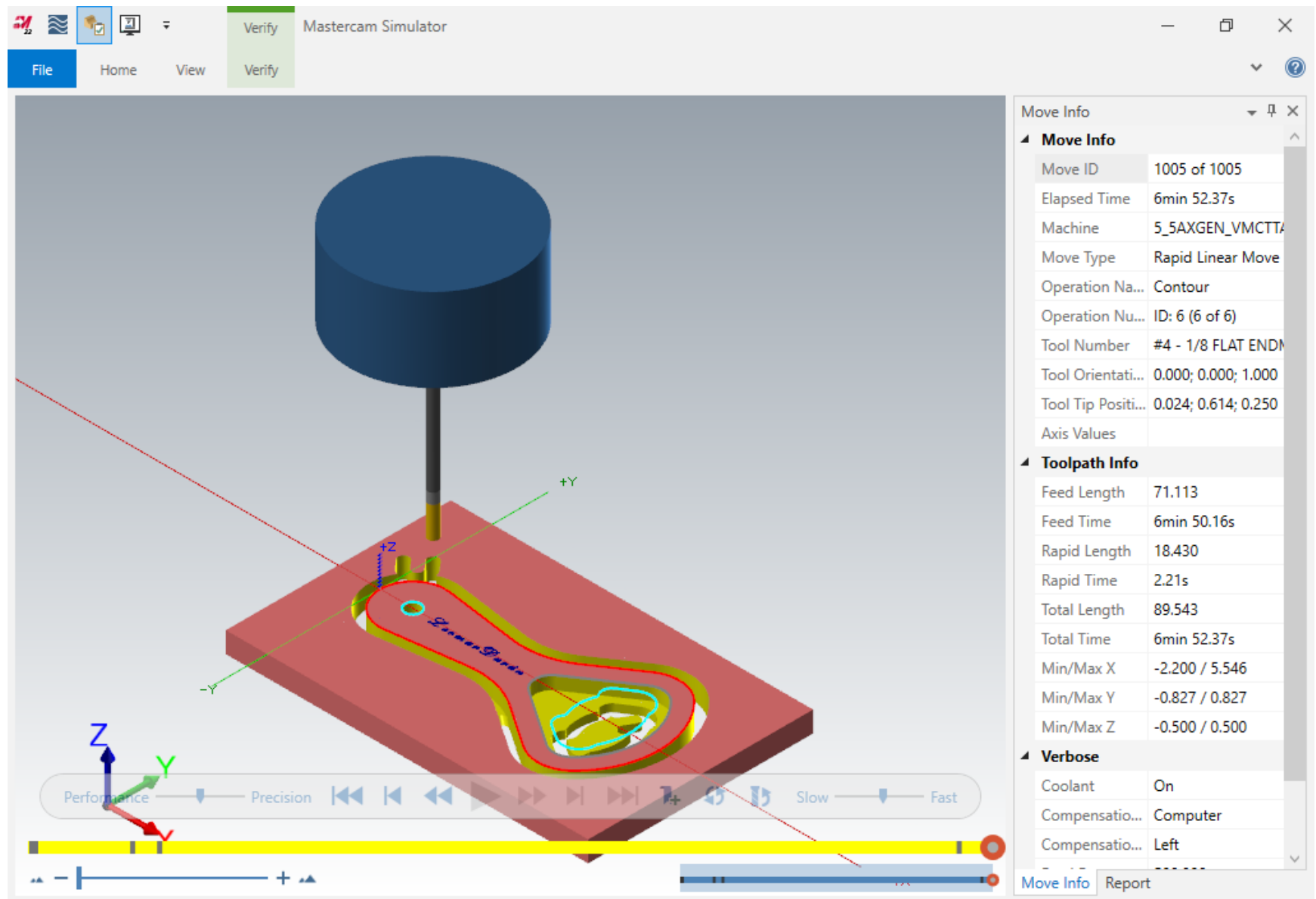
ENGT 3652 Project 4:
Bottle opener-Milling

Leomar Durán

3rd April 2023

Chapter 1

Verification of operations in Mastercam



Chapter 2

Gcode

```
%
O88928(BOTTLE OPENER TOP)
( DATE=DD-MM-YY - 03-04-23 TIME=HH:MM -
  ↪ 19:57)
(MATERIAL - ALUMINUM INCH - 6061)
( T1 | 2" FACE MILL (SFM 600.0) | H1 )
( T2 | 3/16 DRILL (SFM 200.0) | H2 )
( T3 | 5/16 FLAT ENDMILL | H3 )
( T4 | 1/8 FLAT ENDMILL | H4 )
( T5 | 1/4 INCH ENGRAVING TOOL 60 DEGREE X
  ↪ .001 TIP | H5 )
N100 G20
N110 G0 G17 G40 G49 G80 G90
N120 T1 M6
N130 G0 G90 G54 X-2.2 Y0. . S1146 M3
N140 G43 H1 Z.25 M8
N150 Z.2
N160 G1 Z0. F.76
N170 X5.5464 F2.29
N180 G0 Z.25
N190 M5
N200 G91 G28 Z0. M9
N210 .
N220 M01
N230 T2 M6
N240 G0 G90 G17 G54 X.3937 Y0. . S4074 M3
N250 G43 H2 Z.5 M8
N260 G99 G81 Z-.5 R.5 F7.82
N270 G80
N280 M5
N290 G91 G28 Z0. M9
N300 .
N310 M01
N320 T3 M6
N330 G0 G90 G17 G54 X2.5077 Y-.2201 . S6723
  ↪ M3
N340 G43 H3 Z.25 M8
N350 Z.2
N360 G1 Z.1 F12.12
N370 G2 X2.3763 Y0. Z.0859 I.1186 J.2201
  ↪ F33.35
N380 X2.6263 Y.25 Z.0653 I.25 J0.
N390 X2.8763 Y0. Z.0447 I0. J-.25
N400 X2.6263 Y-.25 Z.0242 I-.25 J0.
N410 X2.5077 Y-.2201 Z.0177 I0. J.25
N420 X2.3763 Y0. Z.0036 I.1186 J.2201
N430 X2.6263 Y.25 Z-.017 I.25 J0.
N440 X2.8763 Y0. Z-.0376 I0. J-.25
N450 X2.6263 Y-.25 Z-.0581 I-.25 J0.
N460 X2.5077 Y-.2201 Z-.0646 I0. J.25
N470 X2.3763 Y0. Z-.0788 I.1186 J.2201
N480 G1 X2.6049
N490 G3 X2.5463 Y.0586 I-.0586 J0.
N500 X2.4877 Y0. I0. J-.0586
N510 X2.6244 Y-.1367 I.1367 J0.
N520 X2.7611 Y0. I0. J.1367
N530 X2.5463 Y.2148 I-.2148 J0.
N540 X2.3314 Y0. I0. J-.2148
N550 X2.6244 Y-.293 I.293 J0.
N560 X2.9174 Y0. I0. J.293
N570 X2.5499 Y.3711 I-.3711 J0.
N580 G1 X2.2002 Y.134
N590 G3 X2.1752 Y0. I.3461 J-.134
N600 X2.1944 Y-.1301 I.4492 J0.
N610 G1 X2.6628 Y-.4476
N620 G3 X2.8624 Y-.381 I-.0384 J.4476
N630 G1 X2.7884 Y.4685
N640 G3 X2.7516 Y.4857 I-.2421 J-.4685
N650 X2.7416 Y.4864 I-.01 J-.0692
N660 X2.7023 Y.4744 I0. J-.0699
N670 G1 X2.0399 Y.0253
N680 G3 X2.0265 Y0. I.0171 J-.0253
N690 X2.0399 Y-.0253 I.0305 J0.
N700 G1 X2.7023 Y-.4744
N710 G3 X2.7416 Y-.4865 I.0393 J.0579
N720 X2.7892 Y-.4677 I0. J.07
N730 X2.9834 Y0. I-.4664 J.4677
N740 X2.7892 Y.4677 I-.6606 J0.
N750 X2.7516 Y.4857 I-.0476 J-.0512
N760 G1 Z.1212 F12.12
N770 G0 Z.1713
N780 X2.5077 Y-.2201
```

N790 Z.1212
 N800 G1 Z.0213 F12.12
 N810 G2 X2.3763 Y0. Z.0072 I.1186 J.2201
 ↪ F33.35
 N820 X2.6263 Y.25 Z-.0134 I.25 J0.
 N830 X2.8763 Y0. Z-.034 I0. J-.25
 N840 X2.6263 Y-.25 Z-.0546 I-.25 J0.
 N850 X2.5077 Y-.2201 Z-.0611 I0. J.25
 N860 X2.3763 Y0. Z-.0752 I.1186 J.2201
 N870 X2.6263 Y.25 Z-.0958 I.25 J0.
 N880 X2.8763 Y0. Z-.1164 I0. J-.25
 N890 X2.6263 Y-.25 Z-.1369 I-.25 J0.
 N900 X2.5077 Y-.2201 Z-.1434 I0. J.25
 N910 X2.3763 Y0. Z-.1575 I.1186 J.2201
 N920 G1 X2.6049
 N930 G3 X2.5463 Y.0586 I-.0586 J0.
 N940 X2.4877 Y0. I0. J-.0586
 N950 X2.6244 Y-.1367 I.1367 J0.
 N960 X2.7611 Y0. I0. J.1367
 N970 X2.5463 Y.2148 I-.2148 J0.
 N980 X2.3314 Y0. I0. J-.2148
 N990 X2.6244 Y-.293 I.293 J0.
 N1000 X2.9174 Y0. I0. J.293
 N1010 X2.5499 Y.3711 I-.3711 J0.
 N1020 G1 X2.2002 Y.134
 N1030 G3 X2.1752 Y0. I.3461 J-.134
 N1040 X2.1944 Y-.1301 I.4492 J0.
 N1050 G1 X2.6628 Y-.4476
 N1060 G3 X2.8624 Y-.381 I-.0384 J.4476
 N1070 G1 X2.7884 Y.4685
 N1080 G3 X2.7516 Y.4857 I-.2421 J-.4685
 N1090 X2.7416 Y.4864 I-.01 J-.0692
 N1100 X2.7023 Y.4744 I0. J-.0699
 N1110 G1 X2.0399 Y.0253
 N1120 G3 X2.0265 Y0. I.0171 J-.0253
 N1130 X2.0399 Y-.0253 I.0305 J0.
 N1140 G1 X2.7023 Y-.4744
 N1150 G3 X2.7416 Y-.4865 I.0393 J.0579
 N1160 X2.7892 Y-.4677 I0. J.07
 N1170 X2.9834 Y0. I-.4664 J.4677
 N1180 X2.7892 Y.4677 I-.6606 J0.
 N1190 X2.7516 Y.4857 I-.0476 J-.0512
 N1200 G1 Z.0425 F12.12
 N1210 G0 Z.0925
 N1220 Z.2
 N1230 X2.9749 Y-.0839
 N1240 G1 Z-.0788 F12.12
 N1250 X2.7995 Y.1748 F33.35
 N1260 G3 X2.5408 Y.312 I-.2587 J-.1753
 N1270 X2.3655 Y.2581 I0. J-.3125
 N1280 G1 X2.0342 Y.0336
 N1290 G3 X2.0164 Y0. I.0228 J-.0336
 N1300 X2.0342 Y-.0336 I.0406 J0.
 N1310 G1 X2.6967 Y-.4827

N1320 G3 X2.7416 Y-.4965 I.0449 J.0662
 N1330 X2.7962 Y-.4749 I0. J.08
 N1340 X2.9933 Y0. I-.4734 J.4749
 N1350 X2.7962 Y.4749 I-.6705 J0.
 N1360 X2.7416 Y.4964 I-.0546 J-.0584
 N1370 X2.6967 Y.4827 I0. J-.0799
 N1380 G1 X2.3655 Y.2581
 N1390 G3 X2.2284 Y-.0005 I.1753 J-.2586
 N1400 X2.2822 Y-.1759 I.3124 J0.
 N1410 G1 X2.2993 Y-.2012
 N1420 Z.1212 F12.12
 N1430 G0 Z.1713
 N1440 X2.9749 Y-.0839
 N1450 Z.1212
 N1460 G1 Z-.1575 F12.12
 N1470 X2.7995 Y.1748 F33.35
 N1480 G3 X2.5408 Y.312 I-.2587 J-.1753
 N1490 X2.3655 Y.2581 I0. J-.3125
 N1500 G1 X2.0342 Y.0336
 N1510 G3 X2.0164 Y0. I.0228 J-.0336
 N1520 X2.0342 Y-.0336 I.0406 J0.
 N1530 G1 X2.6967 Y-.4827
 N1540 G3 X2.7416 Y-.4965 I.0449 J.0662
 N1550 X2.7962 Y-.4749 I0. J.08
 N1560 X2.9933 Y0. I-.4734 J.4749
 N1570 X2.7962 Y.4749 I-.6705 J0.
 N1580 X2.7416 Y.4964 I-.0546 J-.0584
 N1590 X2.6967 Y.4827 I0. J-.0799
 N1600 G1 X2.3655 Y.2581
 N1610 G3 X2.2284 Y-.0005 I.1753 J-.2586
 N1620 X2.2822 Y-.1759 I.3124 J0.
 N1630 G1 X2.2993 Y-.2012
 N1640 Z.0425 F12.12
 N1650 G0 Z.25
 N1660 M5
 N1670 G91 G28 Z0. M9
 N1680 .
 N1690 M01
 N1700 T4 M6
 N1710 G0 G90 G17 G54 X2.5509 Y.2894 . S8862
 ↪ M3
 N1720 G43 H4 Z.0925 M8
 N1730 Z.0425
 N1740 G1 Z-.28 F11.74
 N1750 X2.614 Y.3973 F14.44
 N1760 G2 X2.7219 Y.4592 I.1079 J-.0631
 N1770 X2.785 Y.4422 I0. J-.125
 N1780 X2.8516 Y.3262 I-.0678 J-.116
 N1790 X2.8513 Y.3182 I-.1344 J0.
 N1800 G1 X2.8502 Y.3006
 N1810 X2.8585 Y.2851
 N1820 G2 X2.9296 Y0. I-.5357 J-.2851
 N1830 X2.8585 Y-.2851 I-.6068 J0.
 N1840 G1 X2.8502 Y-.3006

N1850	X2.8513	Y-.3182							N2370	Z.25
N1860	G2	X2.8515	Y-.3262	I-.1341	J-.008				N2380	X.7072 Y.0596
N1870	X2.7172	Y-.4605	I-.1343	J0.					N2390	Z.2
N1880	X2.6444	Y-.439	I0.	J.1343					N2400	G1 Z-.001 F12.22
N1890	G1	X2.4731	Y-.3285						N2410	X.6874 Y.065 F30.56
N1900	G2	X2.4477	Y-.2819	I.0301	J.0466				N2420	X.683 Y.0652
N1910	X2.4646	Y-.242	I.0555	J0.					N2430	X.6722 Y.0642
N1920	G3	X2.4837	Y-.197	I-.0434	J.045				N2440	X.6559 Y.0568
N1930	X2.4789	Y-.173	I-.0625	J0.					N2450	X.6552 Y.0563
N1940	G2	X2.4443	Y0.	I.4147	J.173				N2460	X.6471 Y.0464
N1950	X2.4789	Y.173	I.4493	J0.					N2470	X.6444 Y.0348
N1960	G3	X2.4837	Y.197	I-.0577	J.024				N2480	X.6484 Y.0224
N1970	X2.4646	Y.242	I-.0625	J0.					N2490	X.6557 Y.0158
N1980	G2	X2.4477	Y.2819	I.0386	J.0399				N2500	X.673 Y.0095
N1990	X2.4731	Y.3285	I.0555	J0.					N2510	X.6849 Y.0086
N2000	G1	X2.6444	Y.439						N2520	X.6924 Y.0089
N2010	G2	X2.7172	Y.4605	I.0728	J-.1128				N2530	X.7018 Y.0103
N2020	X2.785	Y.4422	I0.	J-.1343					N2540	X.7144 Y.0288
N2030	X2.847	Y.3342	I-.0631	J-.108					N2550	X.7272 Y.0438
N2040	X2.8298	Y.2712	I-.1251	J0.					N2560	X.7116 Y.0572
N2050	G1	X2.7668	Y.1632						N2570	X.7072 Y.0596
N2060	Z-.08	F11.74							N2580	Z.199 F12.22
N2070	G0	Z.0925							N2590	G0 Z.249
N2080	M5								N2600	Z.25
N2090	G91	G28	Z0.	M9					N2610	X.7082 Y.0614
N2100	.								N2620	Z.2
N2110	M01								N2630	G1 Z-.001 F12.22
N2120	T5	M6							N2640	X.6963 Y.0655 F30.56
N2130	G0	G90	G17	G54	X.7395	Y.0275	.	S7640	N2650	X.6839 Y.0669
	↪	M3							N2660	X.6668 Y.0644
N2140	G43	H5	Z.25	M8					N2670	X.653 Y.0569
N2150	Z.2								N2680	X.644 Y.0456
N2160	G1	Z-.001	F12.22						N2690	X.641 Y.0317
N2170	G3	X.735	Y.0339	I-.2076	J-.1392				N2700	X.6437 Y.0195
	↪	F30.56							N2710	X.6518 Y.01
N2180	G1	X.7309	Y.0397						N2720	X.6644 Y.0038
N2190	X.7225	Y.0265							N2730	X.6807 Y.0017
N2200	X.7157	Y.013							N2740	X.6891 Y.002
N2210	X.7421	Y.0259							N2750	X.6981 Y.0027
N2220	X.751	Y.0324							N2760	X.6804 Y-.027
N2230	X.7611	Y.0433							N2770	X.6705 Y-.0385
N2240	X.7644	Y.0534							N2780	X.651 Y-.0339
N2250	X.7628	Y.0584							N2790	X.6385 Y-.0325
N2260	X.7579	Y.06							N2800	X.6275 Y-.0349
N2270	X.7476	Y.056							N2810	X.6266 Y-.0355
N2280	X.7462	Y.0551							N2820	X.6233 Y-.0387
N2290	X.7325	Y.0417							N2830	X.6222 Y-.0426
N2300	X.7372	Y.0353							N2840	X.6262 Y-.0496
N2310	X.7387	Y.0315							N2850	X.6274 Y-.0503
N2320	X.7384	Y.031							N2860	X.6413 Y-.0531
N2330	X.7378	Y.0309							N2870	X.6544 Y-.0511
N2340	X.735	Y.0339							N2880	X.669 Y-.0443
N2350	Z.199	F12.22							N2890	X.69 Y-.0512
N2360	G0	Z.249							N2900	X.7028 Y-.0531

N2910 X.7173 Y-.0491
 N2920 X.7179 Y-.0488
 N2930 X.7355 Y-.0366
 N2940 X.7401 Y-.0313
 N2950 X.7422 Y-.0283
 N2960 X.7418 Y-.0278
 N2970 X.7414 Y-.0274
 N2980 X.7381 Y-.0304
 N2990 X.7359 Y-.0334
 N3000 X.722 Y-.0433
 N3010 X.7082 Y-.0463
 N3020 X.6931 Y-.0445
 N3030 X.676 Y-.0401
 N3040 X.6954 Y-.0208
 N3050 X.7124 Y.0069
 N3060 X.7385 Y.0197
 N3070 X.7517 Y.0297
 N3080 X.7625 Y.0423
 N3090 X.7662 Y.0536
 N3100 X.7638 Y.0594
 N3110 X.7578 Y.0617
 N3120 X.7459 Y.0578
 N3130 X.729 Y.0455
 N3140 X.7109 Y.06
 N3150 X.7082 Y.0614
 N3160 Z.199 F12.22
 N3170 GO Z.249
 N3180 Z.25
 N3190 X.7884 Y-.0295
 N3200 Z.2
 N3210 G1 Z-.001 F12.22
 N3220 X.7867 Y-.0321 F30.56
 N3230 X.7869 Y-.0325
 N3240 X.7873
 N3250 X.7885 Y-.0316
 N3260 X.7908 Y-.0288
 N3270 X.7903 Y-.0323
 N3280 X.7902 Y-.0357
 N3290 X.7926 Y-.0463
 N3300 X.794 Y-.0484
 N3310 X.7984 Y-.0519
 N3320 X.8042 Y-.0531
 N3330 X.8147 Y-.0502
 N3340 X.8279 Y-.0402
 N3350 X.8348 Y-.0328
 N3360 X.8364 Y-.0302
 N3370 X.836 Y-.0296
 N3380 X.8352 Y-.0291
 N3390 X.8317 Y-.033
 N3400 X.8262 Y-.04
 N3410 X.8145 Y-.0487
 N3420 X.8049 Y-.0514
 N3430 X.8005 Y-.0495
 N3440 X.7987 Y-.0441

N3450 X.7988 Y-.042
 N3460 X.7993 Y-.0374
 N3470 X.8199 Y-.0301
 N3480 X.8238 Y-.0278
 N3490 X.8307 Y-.0214
 N3500 X.833 Y-.0147
 N3510 X.8305 Y-.0091
 N3520 X.8234 Y-.0068
 N3530 X.8097 Y-.0108
 N3540 X.8086 Y-.0115
 N3550 X.7928 Y-.0239
 N3560 X.7884 Y-.0295
 N3570 Z.199 F12.22
 N3580 GO Z.249
 N3590 Z.25
 N3600 X.8196 Y-.0254
 N3610 Z.2
 N3620 G1 Z-.001 F12.22
 N3630 X.8271 Y-.0158 F30.56
 N3640 X.8279 Y-.0119
 N3650 X.8267 Y-.0098
 N3660 X.8247 Y-.0085
 N3670 X.8158 Y-.0125
 N3680 X.8119 Y-.0162
 N3690 X.8015 Y-.0325
 N3700 X.8005 Y-.0351
 N3710 X.8162 Y-.028
 N3720 X.8196 Y-.0254
 N3730 Z.199 F12.22
 N3740 GO Z.249
 N3750 Z.25
 N3760 X.8572 Y-.0325
 N3770 Z.2
 N3780 G1 Z-.001 F12.22
 N3790 X.8576 F30.56
 N3800 X.8588 Y-.0321
 N3810 X.8613 Y-.0301
 N3820 X.8606 Y-.0339
 N3830 X.8604 Y-.0372
 N3840 X.8627 Y-.0484
 N3850 X.8632 Y-.0492
 N3860 X.8666 Y-.0521
 N3870 X.8712 Y-.0531
 N3880 X.8814 Y-.0501
 N3890 X.8931 Y-.041
 N3900 X.8943 Y-.0411
 N3910 X.8967
 N3920 X.9052 Y-.039
 N3930 X.9129 Y-.0325
 N3940 X.9146 Y-.0307
 N3950 X.915 Y-.0305
 N3960 X.9153 Y-.0302
 N3970 X.9149 Y-.0295
 N3980 X.9143 Y-.0291

N3990 X.9139 Y-.0295
 N4000 X.9129 Y-.03
 N4010 X.9111 Y-.0319
 N4020 X.9046 Y-.0374
 N4030 X.8974 Y-.0394
 N4040 X.8955 Y-.0392
 N4050 X.8951 Y-.039
 N4060 X.9026 Y-.0283
 N4070 X.905 Y-.0188
 N4080 X.9018 Y-.0101
 N4090 X.8933 Y-.0068
 N4100 X.8802 Y-.0108
 N4110 X.879 Y-.0115
 N4120 X.8639 Y-.0237
 N4130 X.8581 Y-.0302
 N4140 X.857 Y-.0321
 N4150 X.8572 Y-.0325
 N4160 Z.199 F12.22
 N4170 G0 Z.249
 N4180 Z.25
 N4190 X.8684 Y-.0501
 N4200 Z.2
 N4210 G1 Z-.001 F12.22
 N4220 X.8718 Y-.0514 F30.56
 N4230 X.8792 Y-.0487
 N4240 X.888 Y-.0419
 N4250 X.8966 Y-.0293
 N4260 X.8999 Y-.017
 N4270 X.8982 Y-.0109
 N4280 X.8933 Y-.0085
 N4290 X.8855 Y-.0119
 N4300 X.8763 Y-.0222
 N4310 X.8695 Y-.0348
 N4320 X.8673 Y-.0457
 N4330 X.8684 Y-.0501
 N4340 Z.199 F12.22
 N4350 G0 Z.249
 N4360 Z.25
 N4370 X.9378 Y-.0324
 N4380 Z.2
 N4390 G1 Z-.001 F12.22
 N4400 X.9381 Y-.0325 F30.56
 N4410 X.9418 Y-.029
 N4420 X.9463 Y-.0246
 N4430 X.9591 Y-.0119
 N4440 X.9658 Y-.0085
 N4450 X.9678 Y-.0092
 N4460 X.9684 Y-.0111
 N4470 X.9644 Y-.0188
 N4480 X.9637 Y-.0199
 N4490 X.9626 Y-.0212
 N4500 X.9413 Y-.0531
 N4510 X.9524 Y-.0523
 N4520 X.9574 Y-.046

N4530 X.9821 Y-.0179
 N4540 X.9912 Y-.01
 N4550 X.9948 Y-.0085
 N4560 X.9969 Y-.0091
 N4570 X.9976 Y-.011
 N4580 X.9964 Y-.0141
 N4590 X.9918 Y-.0212
 N4600 X.9704 Y-.0531
 N4610 X.9823 Y-.0523
 N4620 X1.0084 Y-.0203
 N4630 X1.0173 Y-.0115
 N4640 X1.0226 Y-.0085
 N4650 X1.0241 Y-.0094
 N4660 X1.025 Y-.011
 N4670 X1.021 Y-.0176
 N4680 X1.0202 Y-.0185
 N4690 X1.0175 Y-.0217
 N4700 X1.0097 Y-.0342
 N4710 X1.0079 Y-.042
 N4720 X1.0098 Y-.0501
 N4730 X1.0151 Y-.0531
 N4740 X1.0215 Y-.05
 N4750 X1.0325 Y-.0394
 N4760 X1.0336 Y-.0388
 N4770 X1.0404 Y-.0306
 N4780 Y-.0302
 N4790 X1.04 Y-.0296
 N4800 X1.0392 Y-.0291
 N4810 X1.0362 Y-.0323
 N4820 X1.0323 Y-.0374
 N4830 X1.0215 Y-.0478
 N4840 X1.0153 Y-.0514
 N4850 X1.0134 Y-.0509
 N4860 X1.013 Y-.0489
 N4870 X1.0143 Y-.0439
 N4880 X1.0202 Y-.035
 N4890 X1.022 Y-.032
 N4900 X1.0294 Y-.0192
 N4910 X1.0302 Y-.015
 N4920 X1.0285 Y-.0092
 N4930 X1.0238 Y-.0068
 N4940 X1.0155 Y-.0108
 N4950 X1.0142 Y-.0119
 N4960 X.9951 Y-.0318
 N4970 X1.001 Y-.0224
 N4980 X1.0027 Y-.0136
 N4990 X1.0006 Y-.009
 N5000 X.9959 Y-.0068
 N5010 X.9866 Y-.0108
 N5020 X.9844 Y-.0126
 N5030 X.9661 Y-.032
 N5040 X.9719 Y-.0225
 N5050 X.9736 Y-.0148
 N5060 X.9715 Y-.009

N5070 X.9669 Y-.0068
 N5080 X.9592 Y-.0098
 N5090 X.9466 Y-.0204
 N5100 X.9413 Y-.0265
 N5110 X.9381 Y-.0302
 N5120 X.9376 Y-.032
 N5130 X.9378 Y-.0324
 N5140 Z.199 F12.22
 N5150 G0 Z.249
 N5160 Z.25
 N5170 X1.0629
 N5180 Z.2
 N5190 G1 Z-.001 F12.22
 N5200 X1.0634 Y-.0325 F30.56
 N5210 X1.065 Y-.0316
 N5220 X1.0668 Y-.029
 N5230 X1.0663 Y-.0329
 N5240 X1.0662 Y-.0369
 N5250 X1.0684 Y-.0487
 N5260 X1.0712 Y-.052
 N5270 X1.0752 Y-.0531
 N5280 X1.0852 Y-.0497
 N5290 X1.0957 Y-.0401
 N5300 X1.0954 Y-.0434
 N5310 X1.0953 Y-.0457
 N5320 X1.0971 Y-.0512
 N5330 X1.1022 Y-.0531
 N5340 X1.1101 Y-.0505
 N5350 X1.1232 Y-.0391
 N5360 X1.1292 Y-.033
 N5370 X1.1313 Y-.0301
 N5380 X1.1308 Y-.0295
 N5390 X1.1301 Y-.0291
 N5400 X1.1271 Y-.0323
 N5410 X1.122 Y-.0374
 N5420 X1.1098 Y-.0483
 N5430 X1.1028 Y-.0521
 N5440 X1.1008 Y-.0514
 N5450 X1.1004 Y-.0492
 N5460 X1.1016 Y-.0449
 N5470 X1.108 Y-.0358
 N5480 X1.1264 Y-.0078
 N5490 X1.115 Y-.0082
 N5500 X1.1081 Y-.0178
 N5510 X1.1087 Y-.0158
 N5520 X1.109 Y-.0144
 N5530 X1.1066 Y-.009
 N5540 X1.0997 Y-.0068
 N5550 X1.0864 Y-.0108
 N5560 X1.086 Y-.011
 N5570 X1.0702 Y-.0232
 N5580 X1.0647 Y-.0292
 N5590 X1.0627 Y-.0321
 N5600 X1.0629 Y-.0324

N5610 Z.199 F12.22
 N5620 G0 Z.249
 N5630 Z.25
 N5640 X1.074 Y-.0502
 N5650 Z.2
 N5660 G1 Z-.001 F12.22
 N5670 X1.0769 Y-.0514 F30.56
 N5680 X1.0838 Y-.0487
 N5690 X1.0925 Y-.0409
 N5700 X1.1033 Y-.0266
 N5710 X1.1073 Y-.0144
 N5720 X1.1056 Y-.0101
 N5730 X1.1013 Y-.0085
 N5740 X1.0924 Y-.0124
 N5750 X1.0825 Y-.0222
 N5760 X1.0756 Y-.0355
 N5770 X1.073 Y-.0462
 N5780 X1.074 Y-.0502
 N5790 Z.199 F12.22
 N5800 G0 Z.249
 N5810 Z.25
 N5820 X1.152 Y-.0324
 N5830 Z.2
 N5840 G1 Z-.001 F12.22
 N5850 X1.1524 Y-.0325 F30.56
 N5860 X1.1561 Y-.029
 N5870 X1.1606 Y-.0247
 N5880 X1.1733 Y-.012
 N5890 X1.18 Y-.0085
 N5900 X1.1821 Y-.0092
 N5910 X1.1827 Y-.0112
 N5920 X1.1787 Y-.0188
 N5930 X1.1779 Y-.0199
 N5940 X1.1769 Y-.0212
 N5950 X1.1557 Y-.0531
 N5960 X1.1667 Y-.0524
 N5970 X1.181 Y-.0357
 N5980 X1.1923 Y-.0251
 N5990 X1.1915 Y-.0301
 N6000 X1.1913 Y-.0333
 N6010 X1.1931 Y-.038
 N6020 X1.1983 Y-.0394
 N6030 X1.2069 Y-.0358
 N6040 X1.2119 Y-.0302
 N6050 X1.2114 Y-.0299
 N6060 X1.2106 Y-.0291
 N6070 X1.2061 Y-.0334
 N6080 X1.1971 Y-.0377
 N6090 X1.1941 Y-.0366
 N6100 X1.193 Y-.0335
 N6110 X1.1944 Y-.0266
 N6120 X1.2001 Y-.0204
 N6130 X1.2023 Y-.0187
 N6140 X1.2115 Y-.0107

N6150 X1.2119 Y-.0096
 N6160 X1.2106 Y-.0076
 N6170 X1.2076 Y-.0068
 N6180 X1.2004 Y-.0099
 N6190 X1.1941 Y-.0204
 N6200 X1.1796 Y-.0339
 N6210 X1.1795 Y-.034
 N6220 X1.1863 Y-.0222
 N6230 X1.1879 Y-.0143
 N6240 X1.1858 Y-.009
 N6250 X1.1812 Y-.0068
 N6260 X1.1735 Y-.0098
 N6270 X1.1609 Y-.0204
 N6280 X1.1556 Y-.0266
 N6290 X1.1524 Y-.0303
 N6300 X1.1519 Y-.0321
 N6310 X1.152 Y-.0324
 N6320 Z.199 F12.22
 N6330 G0 Z.249
 N6340 Z.25
 N6350 X1.236 Y.0142
 N6360 Z.2
 N6370 G1 Z-.001 F12.22
 N6380 X1.2397 Y.0282 F30.56
 N6390 X1.2502 Y.0463
 N6400 X1.2594 Y.0553
 N6410 X1.2725 Y.0627
 N6420 X1.2867 Y.0652
 N6430 X1.2968 Y.0637
 N6440 X1.305 Y.0593
 N6450 X1.2804 Y.0492
 N6460 X1.2673 Y.0384
 N6470 X1.2566 Y.0227
 N6480 X1.253 Y.0059
 N6490 X1.254 Y-.0018
 N6500 X1.2593 Y-.0108
 N6510 X1.2666 Y-.0155
 N6520 X1.276 Y-.0171
 N6530 X1.2906 Y-.0136
 N6540 X1.3038 Y-.0042
 N6550 X1.3157 Y.0136
 N6560 X1.3199 Y.0333
 N6570 X1.3178 Y.0458
 N6580 X1.312 Y.0569
 N6590 X1.3189 Y.0578
 N6600 X1.3252 Y.0583
 N6610 X1.3443 Y.0552
 N6620 X1.3596 Y.0468
 N6630 X1.3359 Y.0194
 N6640 X1.3169 Y-.0109
 N6650 X1.3117 Y-.02
 N6660 X1.298 Y-.039
 N6670 X1.2946 Y-.0422
 N6680 X1.2862 Y-.0475

N6690 X1.2778 Y-.0493
 N6700 X1.2656 Y-.0469
 N6710 X1.2503 Y-.0445
 N6720 X1.2447 Y-.0457
 N6730 X1.2427 Y-.0479
 N6740 X1.2467 Y-.0518
 N6750 X1.2471 Y-.0519
 N6760 X1.2589 Y-.0531
 N6770 X1.269 Y-.053
 N6780 X1.2762
 N6790 X1.2862
 N6800 X1.2966 Y-.0531
 N6810 X1.3222 Y-.0503
 N6820 X1.3247 Y-.0496
 N6830 X1.3475 Y-.039
 N6840 X1.3649 Y-.0214
 N6850 X1.3688 Y-.0152
 N6860 X1.3745 Y-.0009
 N6870 X1.3764 Y.014
 N6880 X1.3735 Y.0305
 N6890 X1.365 Y.0453
 N6900 X1.3768 Y.0548
 N6910 X1.3833 Y.0591
 N6920 X1.3829 Y.0593
 N6930 X1.3821 Y.06
 N6940 X1.3738 Y.0569
 N6950 X1.3615 Y.0485
 N6960 X1.345 Y.0581
 N6970 X1.344 Y.0584
 N6980 X1.3218 Y.0617
 N6990 X1.3156 Y.0613
 N7000 X1.3084 Y.0604
 N7010 X1.2982 Y.0653
 N7020 X1.2874 Y.0669
 N7030 X1.2687 Y.0629
 N7040 X1.2619 Y.0592
 N7050 X1.2512 Y.0501
 N7060 X1.2428 Y.038
 N7070 X1.2363 Y.0223
 N7080 X1.2342 Y.009
 N7090 X1.2344 Y.0073
 N7100 X1.2348 Y.0069
 N7110 X1.236 Y.0142
 N7120 Z.199 F12.22
 N7130 G0 Z.249
 N7140 Z.25
 N7150 X1.2653 Y-.0117
 N7160 Z.2
 N7170 G1 Z-.001 F12.22
 N7180 X1.2748 Y-.0154 F30.56
 N7190 X1.2763
 N7200 X1.2898 Y-.0126
 N7210 X1.3017 Y-.0044
 N7220 X1.313 Y.0116

N7230	X1.3139	Y.0135	
N7240	X1.3182	Y.0333	
N7250	Y.0336		
N7260	X1.3159	Y.0458	
N7270	X1.3089	Y.056	
N7280	X1.2885	Y.0457	
N7290	X1.2754	Y.0329	
N7300	X1.265	Y.0159	
N7310	X1.2616	Y-.001	
N7320	X1.264	Y-.0101	
N7330	X1.2653	Y-.0117	
N7340	Z.199	F12.22	
N7350	G0	Z.249	
N7360	Z.25		
N7370	X1.2926	Y-.0513	
N7380	Z.2		
N7390	G1	Z-.001	F12.22
N7400	X1.2996	Y-.0514	F30.56
N7410	X1.3229	Y-.0486	
N7420	X1.3253	Y-.0479	
N7430	X1.3464	Y-.0376	
N7440	X1.3466	Y-.0375	
N7450	X1.3633	Y-.021	
N7460	X1.3672	Y-.0147	
N7470	X1.3743	Y.0064	
N7480	X1.3747	Y.0129	
N7490	X1.3717	Y.0293	
N7500	X1.3633	Y.0434	
N7510	X1.3485	Y.0226	
N7520	X1.3444	Y.0154	
N7530	X1.3292	Y-.011	
N7540	X1.3091	Y-.0356	
N7550	X1.307	Y-.0376	
N7560	X1.2873	Y-.05	
N7570	X1.2847	Y-.0509	
N7580	X1.2926	Y-.0513	
N7590	Z.199	F12.22	
N7600	G0	Z.249	
N7610	Z.25		
N7620	X1.4057	Y-.0325	
N7630	Z.2		
N7640	G1	Z-.001	F12.22
N7650	X1.4061	F30.56	
N7660	X1.4106	Y-.0278	
N7670	X1.4114	Y-.027	
N7680	X1.42	Y-.0167	
N7690	X1.4186	Y-.0184	
N7700	X1.4083	Y-.0381	
N7710	X1.4073	Y-.0428	
N7720	X1.4096	Y-.0504	
N7730	X1.4164	Y-.0531	
N7740	X1.4259	Y-.0493	
N7750	X1.4386	Y-.0385	
N7760	X1.4383	Y-.0411	
N7770	X1.4382	Y-.0426	
N7780	X1.4401	Y-.0503	
N7790	X1.4456	Y-.0531	
N7800	X1.4536	Y-.0494	
N7810	X1.4659	Y-.0383	
N7820	X1.4711	Y-.0322	
N7830	X1.4724	Y-.0301	
N7840	X1.472	Y-.0295	
N7850	X1.4712	Y-.0291	
N7860	X1.4679	Y-.0322	
N7870	X1.4639	Y-.0372	
N7880	X1.4519	Y-.0483	
N7890	X1.4456	Y-.0514	
N7900	X1.4437	Y-.0509	
N7910	X1.4433	Y-.0489	
N7920	X1.4473	Y-.0393	
N7930	X1.4475	Y-.039	
N7940	X1.4677	Y-.0068	
N7950	X1.4562	Y-.0078	
N7960	X1.4372	Y-.035	
N7970	X1.4327	Y-.0399	
N7980	X1.4227	Y-.0485	
N7990	X1.4148	Y-.0514	
N8000	X1.413	Y-.0505	
N8010	X1.4124	Y-.0489	
N8020	X1.4164	Y-.0402	
N8030	X1.4197	Y-.0351	
N8040	X1.421	Y-.0334	
N8050	X1.4384	Y-.0068	
N8060	X1.4254	Y-.0078	
N8070	X1.4104	Y-.0252	
N8080	X1.4056	Y-.0322	
N8090	X1.4057	Y-.0325	
N8100	Z.199	F12.22	
N8110	G0	Z.249	
N8120	Z.25		
N8130	X1.4932	Y-.0324	
N8140	Z.2		
N8150	G1	Z-.001	F12.22
N8160	X1.4936	Y-.0325	F30.56
N8170	X1.4972	Y-.029	
N8180	X1.5017	Y-.0247	
N8190	X1.5145	Y-.012	
N8200	X1.5212	Y-.0085	
N8210	X1.5232	Y-.0092	
N8220	X1.5239	Y-.0112	
N8230	X1.5199	Y-.0188	
N8240	X1.5191	Y-.0199	
N8250	X1.5181	Y-.0212	
N8260	X1.4969	Y-.0531	
N8270	X1.5078	Y-.0524	
N8280	X1.5221	Y-.0357	
N8290	X1.5334	Y-.0251	
N8300	X1.5327	Y-.0301	

N8310	X1.5324	Y-.0333	N8850	X1.64	Y-.033
N8320	X1.5342	Y-.038	N8860	X1.6422	Y-.0301
N8330	X1.5395	Y-.0394	N8870	X1.6417	Y-.0295
N8340	X1.5481	Y-.0358	N8880	X1.6409	Y-.0291
N8350	X1.553	Y-.0302	N8890	X1.6379	Y-.0323
N8360	X1.5526	Y-.0299	N8900	X1.6328	Y-.0374
N8370	X1.5517	Y-.0291	N8910	X1.6207	Y-.0483
N8380	X1.5473	Y-.0334	N8920	X1.6137	Y-.0521
N8390	X1.5382	Y-.0377	N8930	X1.6117	Y-.0514
N8400	X1.5353	Y-.0366	N8940	X1.6113	Y-.0492
N8410	X1.5342	Y-.0335	N8950	X1.6125	Y-.0449
N8420	X1.5356	Y-.0266	N8960	X1.6188	Y-.0358
N8430	X1.5413	Y-.0204	N8970	X1.6373	Y-.0078
N8440	X1.5434	Y-.0187	N8980	X1.6259	Y-.0082
N8450	X1.5526	Y-.0107	N8990	X1.619	Y-.0178
N8460	X1.553	Y-.0096	N9000	X1.6195	Y-.0158
N8470	X1.5517	Y-.0076	N9010	X1.6199	Y-.0144
N8480	X1.5488	Y-.0068	N9020	X1.6174	Y-.009
N8490	X1.5416	Y-.0099	N9030	X1.6106	Y-.0068
N8500	X1.5352	Y-.0204	N9040	X1.5972	Y-.0108
N8510	X1.5207	Y-.0339	N9050	X1.5968	Y-.011
N8520	X1.5206	Y-.034	N9060	X1.581	Y-.0232
N8530	X1.5274	Y-.0222	N9070	X1.5756	Y-.0292
N8540	X1.529	Y-.0143	N9080	X1.5736	Y-.0321
N8550	X1.5269	Y-.009	N9090	X1.5737	Y-.0324
N8560	X1.5223	Y-.0068	N9100	Z.199	F12.22
N8570	X1.5146	Y-.0098	N9110	G0	Z.249
N8580	X1.502	Y-.0204	N9120	Z.25	
N8590	X1.4967	Y-.0266	N9130	X1.5849	Y-.0502
N8600	X1.4935	Y-.0303	N9140	Z.2	
N8610	X1.493	Y-.0321	N9150	G1	Z-.001 F12.22
N8620	X1.4932	Y-.0324	N9160	X1.5877	Y-.0514 F30.56
N8630	Z.199	F12.22	N9170	X1.5947	Y-.0487
N8640	G0	Z.249	N9180	X1.6034	Y-.0409
N8650	Z.25		N9190	X1.6142	Y-.0266
N8660	X1.5737		N9200	X1.6182	Y-.0144
N8670	Z.2		N9210	X1.6165	Y-.0101
N8680	G1	Z-.001 F12.22	N9220	X1.6121	Y-.0085
N8690	X1.5742	Y-.0325 F30.56	N9230	X1.6033	Y-.0124
N8700	X1.5759	Y-.0316	N9240	X1.5934	Y-.0222
N8710	X1.5777	Y-.029	N9250	X1.5865	Y-.0355
N8720	X1.5772	Y-.0329	N9260	X1.5839	Y-.0462
N8730	X1.577	Y-.0369	N9270	X1.5849	Y-.0502
N8740	X1.5792	Y-.0487	N9280	Z.199	F12.22
N8750	X1.5821	Y-.052	N9290	G0	Z.249
N8760	X1.5861	Y-.0531	N9300	Z.25	
N8770	X1.596	Y-.0497	N9310	X1.6161	Y-.0024
N8780	X1.6066	Y-.0401	N9320	Z.2	
N8790	X1.6062	Y-.0434	N9330	G1	Z-.001 F12.22
N8800	Y-.0457		N9340	X1.6244	Y.002 F30.56
N8810	X1.6079	Y-.0512	N9350	X1.6364	Y.0103
N8820	X1.6131	Y-.0531	N9360	X1.6404	Y.0191
N8830	X1.621	Y-.0505	N9370	X1.639	Y.0226
N8840	X1.6341	Y-.0391	N9380	X1.6354	Y.024

N9390 X1.6297 Y.02
 N9400 X1.6278 Y.0161
 N9410 X1.6251 Y.0095
 N9420 X1.6165 Y.0019
 N9430 X1.6113 Y-.0026
 N9440 X1.6115 Y-.0032
 N9450 X1.6122 Y-.0034
 N9460 X1.6161 Y-.0024
 N9470 Z.199 F12.22
 N9480 G0 Z.249
 N9490 Z.25
 N9500 X1.6629 Y-.0324
 N9510 Z.2
 N9520 G1 Z-.001 F12.22
 N9530 X1.6633 Y-.0325 F30.56
 N9540 X1.6669 Y-.029
 N9550 X1.6714 Y-.0246
 N9560 X1.6842 Y-.0119
 N9570 X1.6909 Y-.0085
 N9580 X1.6929 Y-.0092
 N9590 X1.6936 Y-.0111
 N9600 X1.6896 Y-.0188
 N9610 X1.6891 Y-.0196
 N9620 X1.6878 Y-.0212
 N9630 X1.6666 Y-.0531
 N9640 X1.6775 Y-.0523
 N9650 X1.7052 Y-.0207
 N9660 X1.7147 Y-.0121
 N9670 X1.7203 Y-.0092
 N9680 X1.7222 Y-.0095
 N9690 X1.7227 Y-.011
 N9700 X1.7187 Y-.0176
 N9710 X1.7179 Y-.0185
 N9720 X1.7152 Y-.0217
 N9730 X1.7074 Y-.0342
 N9740 X1.7056 Y-.042
 N9750 X1.7075 Y-.0501
 N9760 X1.7128 Y-.0531
 N9770 X1.7193 Y-.05
 N9780 X1.7302 Y-.0394
 N9790 X1.7314 Y-.0388
 N9800 X1.7381 Y-.0306
 N9810 X1.7382 Y-.0302
 N9820 X1.7377 Y-.0296
 N9830 X1.7369 Y-.0291
 N9840 X1.7339 Y-.0323
 N9850 X1.7301 Y-.0374
 N9860 X1.7193 Y-.0478
 N9870 X1.713 Y-.0514
 N9880 X1.7111 Y-.0509
 N9890 X1.7107 Y-.0489
 N9900 X1.712 Y-.0439
 N9910 X1.7179 Y-.035
 N9920 X1.7198 Y-.032

N9930 X1.7271 Y-.0192
 N9940 X1.7279 Y-.015
 N9950 X1.7262 Y-.0095
 N9960 X1.7215 Y-.0075
 N9970 X1.7127 Y-.0115
 N9980 X1.7109 Y-.0129
 N9990 X1.6912 Y-.032
 N100 X1.6971 Y-.0225
 N110 X1.6987 Y-.0148
 N120 X1.6967 Y-.009
 N130 X1.692 Y-.0068
 N140 X1.6843 Y-.0098
 N150 X1.6717 Y-.0204
 N160 X1.6665 Y-.0265
 N170 X1.6632 Y-.0302
 N180 X1.6627 Y-.032
 N190 X1.6629 Y-.0324
 N200 Z.199 F12.22
 N210 G0 Z.249
 N220 Z.25
 N230 X.6475 Y-.0374
 N240 Z.2
 N250 G1 Z-.001 F12.22
 N260 X.6368 Y-.036 F30.56
 N270 X.6285 Y-.0381
 N280 X.6256 Y-.0428
 N290 X.6296 Y-.0489
 N300 X.6301 Y-.0492
 N310 X.6414 Y-.0514
 N320 X.6531 Y-.0493
 N330 X.6644 Y-.0427
 N340 X.6475 Y-.0374
 N350 Z.199 F12.22
 N360 G0 Z.25
 N370 M5
 N380 G91 G28 Z0. M9
 N390 .
 N400 M01
 N410 T4 M6
 N420 G0 G90 G17 G54 X-.1647 Y.4501 . S8862
 ↪ M3
 N430 G43 H4 Z.25 M8
 N440 Z.2
 N450 G1 Z-.26 F11.74
 N460 X-.0825 Y.3559 F14.44
 N470 G3 X.0117 Y.313 I.0942 J.0821
 N480 X.0939 Y.3438 I0. J.125
 N490 G2 X.3937 Y.4562 I.2998 J-.3438
 N500 X.4557 Y.452 I0. J-.4562
 N510 G1 X.8532 Y.3974
 N520 X.9255 Y.3875 Z-.187
 N530 X1.3305 Y.3319
 N540 G3 X1.4004 Y.3251 I.12 J.8742
 N550 X1.4505 Y.3237 Z-.2371 I.0501 J.881

N560 X1.4733 Y.324 Z-.26 I0. J.8824
 N570 X1.9455 Y.4756 I-.0228 J.8821
 N580 G1 X2.4637 Y.8267
 N590 G2 X2.7416 Y.912 I.2779 J-.4102
 N600 X3.0995 Y.7592 I0. J-.4955
 N610 X3.3253 Y.418 I-.7767 J-.7592
 N620 X3.3511 Y.3497 Z-.187 I-1.0025 J-.418
 N630 X3.4089 Y0. I-1.0283 J-.3497
 N640 X3.4019 Y-.1227 I-1.0861 J0.
 N650 X3.3913 Y-.1949 Z-.26 I-1.0791 J.1227
 N660 X3.0995 Y-.7592 I-1.0685 J.1949
 N670 X2.7416 Y-.912 I-.3579 J.3427
 N680 X2.4637 Y-.8267 I0. J.4955
 N690 G1 X1.9502 Y-.4788
 N700 X1.9455 Y-.4756 Z-.2542
 N710 G3 X1.8884 Y-.44 Z-.187 I-.495 J-.7305
 N720 X1.4505 Y-.3237 I-.4379 J-.7661
 N730 X1.4297 Y-.3239 I0. J-.8824
 N740 X1.3569 Y-.3287 Z-.26 I.0208 J-.8822
 N750 X1.3305 Y-.3319 I.0936 J-.8774
 N760 G1 X.4557 Y-.452
 N770 G2 X.3937 Y-.4562 I-.062 J.452
 N780 X-.0625 Y0. I0. J.4562
 N790 X.0939 Y.3438 I.4562 J0.
 N800 G3 X.1367 Y.438 I-.0822 J.0942
 N810 X.1059 Y.5202 I-.125 J0.
 N820 G1 X.0237 Y.6144
 N830 Z-.06 F11.74
 N840 G0 Z.25
 N850 M5
 N860 G91 G28 Z0. M9
 N870 G28 X0. Y0. .
 N880 M30
 %

Chapter 2

Plot in NCViewer

GCode File

```

1036 N460 X-.0825 Y.3559 F14.44
1037 N470 G3 X.0117 Y.313 I.0942 J.0821
1038 N480 X.0939 Y.3438 I0. J.125
1039 N490 G2 X.3937 Y.4562 I.2998 J-.3438
1040 N500 X.4557 Y.452 I0. J-.4562
1041 N510 G1 X.8532 Y.3974
1042 N520 X.9255 Y.3875 Z-.187
1043 N530 X1.3305 Y.3319
1044 N540 G3 X1.4004 Y.3251 I.12 J.8742
1045 N550 X1.4505 Y.3237 Z-.2371 I.0501 J.881
1046 N560 X1.4733 Y.324 Z-.26 I0. J.8824
1047 N570 X1.9455 Y.4756 I-.0228 J.8821
1048 N580 G1 X2.4637 Y.8267
1049 N590 G2 X2.7416 Y.912 I.2779 J-.4102
1050 N600 X3.0995 Y.7592 I0. J-.4955
1051 N610 X3.3253 Y.418 I-.7767 J-.7592
1052 N620 X3.3511 Y.3497 Z-.187 I-1.0025 J-.418
1053 N630 X3.4089 Y0. I-1.0283 J-.3497
1054 N640 X3.4019 Y-.1227 I-1.0861 J0.
1055 N650 X3.3913 Y-.1949 Z-.26 I-1.0791 J.1227
1056 N660 X3.0995 Y-.7592 I-1.0685 J.1949
1057 N670 X2.7416 Y-.912 I-.3579 J.3427
1058 N680 X2.4637 Y-.8267 I0. J.4955
1059 N690 G1 X1.9502 Y-.4788
1060 N700 X1.9455 Y-.4756 Z-.2542
1061 N710 G3 X1.8884 Y-.44 Z-.187 I-.495 J-.7305
1062 N720 X1.4505 Y-.3237 I-.4379 J-.7661
1063 N730 X1.4297 Y-.3239 I0. J-.8824
1064 N740 X1.3569 Y-.3287 Z-.26 I.0208 J-.8822
1065 N750 X1.3305 Y-.3319 I.0936 J-.8774
1066 N760 G1 X.4557 Y-.452
1067 N770 G2 X.3937 Y-.4562 I-.062 J.452
1068 N780 X-.0625 Y0. I0. J.4562
1069 N790 X.0939 Y.3438 I.4562 J0.
1070 N800 G3 X.1367 Y.438 I-.0822 J.0942
1071 N810 X.1059 Y.5202 I-.125 J0.
1072 N820 G1 X.0237 Y.6144
1073 N830 Z-.06 F11.74
1074 N840 G0 Z.25
1075 N850 M5
1076 N860 G91 G28 Z0. M9
1077 N870 G28 X0. Y0. .
1078 N880 M30
1079 %
1080

```

PLOT



Digital Read Out

Machine Options

