G50 S2000

G96 S180 M3

T0100

G0 X60.0 Z5.0 T0101 M8

G90 X50.0 Z-40.0 F0.25

X45.0 Z-20.0

X40.0

X35.0

X30.0

X25.0

X20.0

G00 X200.0 Z200.0 T0100

M30

G71 G90

G92 X-15.0 Y-15.0 Z0.0 T01 F100 S1200

G41 G00 X0.0 Y0.0 Z2.0

G01 Z-15.0 M03

G01 X0.0 Y110.0

G02 X10.0 Y120.0 R10.0 (Go to C with clockwise circular interpolation with radius = 10

G01 X75.0

G01 X100.0 Y92.0

G01 Y10.0

N010 G02 X90.0 Y0.0 R10.0

G01 X0.0

Z2.0 M05

G40 G00 X-15.0 Y-15.0

M06 T02 F120

G00 X15.0 Y55.0

G01 Z-5.0 M03

Y80.0

X85.0

Y80.0

Z2.0 M05

G00 X-15.0 Y-15.0

M06 T03 F80

G00 X50.0 Y25.0

G01 Z-20.0 M03

Z2.0 M05

G00 X-15.0 Y-15.0

M30