G50 T0200

G97 S250 M03

G00 X0 Z5.0 T0202 M08

G01 Z-5.0 F0.07

W1.0

Z-40.0 F0.25

G00 Z5.0

Z-39.0

G01 Z-60.0

G00 Z10.0

X200.0 Z200.0 T0200

M01

G50 S1500 T0100

G96 S180 M03

G00 X94.0 Z5.0 T0101 M08

G01 Z-14.8 F0.27

G00 U2.0 Z0.5

G01 X28.0 F0.23

G00 X87.0 W1.0

G01 Z-14.8 F0.27

G00 U2.0 Z1.0

X80.5

G01 Z-14.1

G02 X81.9 Z-14.8 R0.7

G00 X100.5 W1.0

G01 Z-29.8

G00 U2.0 Z-1.0

G01 X60.5 F0.23

G00 X82.0 W1.0

Z-2.4

G01 X60.5

X72.9

G03 X80.5 Z-6.2 R3.8

G00 U2.0 Z5.0

X200.0 Z200.0 T0100

M01

G50 S1500 T0400

G96 S180 M03

G00 X34.5 Z3.0 T0404 M08

G01 Z-41.8 F0.27

G00 U-0.5 Z1.0

X39.5

G01 Z-15.0

X34.5 Z-24.3

G00 Z10.0

X200.0 Z200.0 T0400

M01

NG50 S1800 T0500

G96 S200 M03

G00 X63.0 Z5.0 T0505 M08

Z0

G01 X38.0 F0.2

G00 X60.0 Z3.0

G42 Z1.0

G01 Z-2.5 F0.2

X74.0

G03 X80.0 Z-5.5 R3.0

G01 Z-13.5

G02 X83.0 Z-15.0 R1.5

G01 X100.0

Z-30.0

X102.0

G40 G00 U2.0 W1.0

G00 Z10.0

X200.0 Z200.0 T0500

M01

G50 S1800 T0600

G96 S200 M03

G00 X40.0 Z5.0 T0606 M08

G41 Z1.0

G01 Z-15.0 F0.2

X35.0 Z-24.33

Z-42.0

X29.0

G40 G00 Z10.0

X200.0 Z200.0 T0600 M09

M30