

G21 G98  
G28 U0 W0  
M06 T01  
M03 S1500  
G00 X51 Z01  
G71 U1 R1  
G71 P01 Q02 U0.1 W0.1 F30  
N01 G01 X20 Z0  
X20 Z-20  
G02 X30 Z-30 R20  
G01 Z-40  
N02 G03 X50 Z-55 R20  
G70 P01 Q02 F25  
M06 T02  
M03 S300  
G00 X21 Z-19  
G01 X20 F20  
G75 R1  
G75 X15 Z-20 P100 Q1000 F20  
M06 T03  
M03 S300  
G00 X21 Z1  
G01 X20 F80  
G76 P041560 Q20 R0.01  
G76 X17.548 Z-17 P0613 Q150 F2  
G28 U0 W0  
M05  
M30