

(POSITION TO LCS X0,Y0, Z50.0 IN GLOBAL COORDINATES)

G00 X225.0 Y0.0 Z93.301 A30.0 C90.0

G49 (CANCEL RTCP/TOOL LENGTH COMP- PARAMETERS SET TO NO MOUEMENT)

G68.3 P1 X200.0 Y0.0 Z50.0

(MILL CIRCLE W/CRC ON TILTED WORK PLANE)

G00 X100.0 Y109.525

(ACTIVATE TOOL LENGTH COMP IN TILTED WORK PLANE)

G43 H01 Z25.0

Z2.5

G01 Z-12.5 F1270.0

G41 D01 X109.525 F2540.0

G03 X100.0 Y119.05 R9.525

X80.95 Y100.0 R19.05

X100.0 Y80.95 R19.05

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X119.65 Y100.0 R19.05

X100.0 Y119.05 R19.05

X90.475 Y109.525 R9.525

G01 G49 X100.0

G00 Z50.9

G49(CANCEL RTCP/TOOL LENGTH COMP- PARAMETERS SET TO NO MOUEMENT)

G69(CANCEL TILTED WORK PLANE)