

Part Zero Change

The program will use G52 command - local coordinate system - and temporarily transfers part zero from the part corner to the bolt hole circle center:

```
N1 G20
N2 G17 G40 G80
N3 G90 G54 G00 X1.5 Y1.0 S1900 M03
N4 G43 Z1.0 H01 M08
N5 G52 X1.5 Y1.0
N6 G99 G81 X0.63 Y0 R0.1 Z-0.681 F4.0
N7 X0.4455 Y0.4455
N8 X0 Y0.63
N9 X-0.4455 Y0.4455
N10 X-0.63 Y0
N11 X-0.4455 Y-0.4455
N12 X0 Y-0.63
N13 X0.4455 Y-0.4455
N14 G80 Z1.0 M09
N15 G52 X0 Y0
N16 G28 Z1.0 M05
N17 M30
%
```

Check first if the control system supports this command