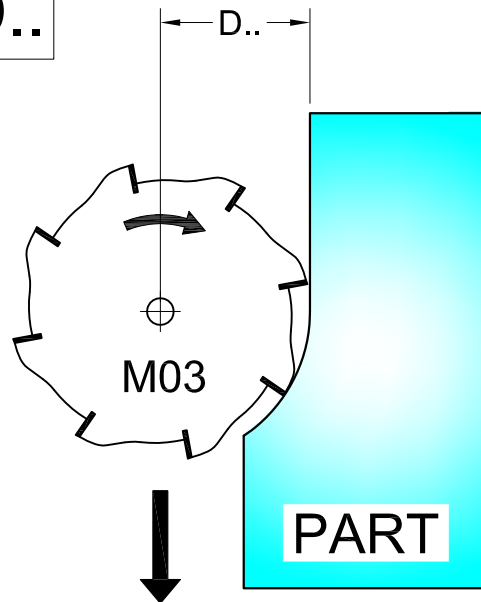
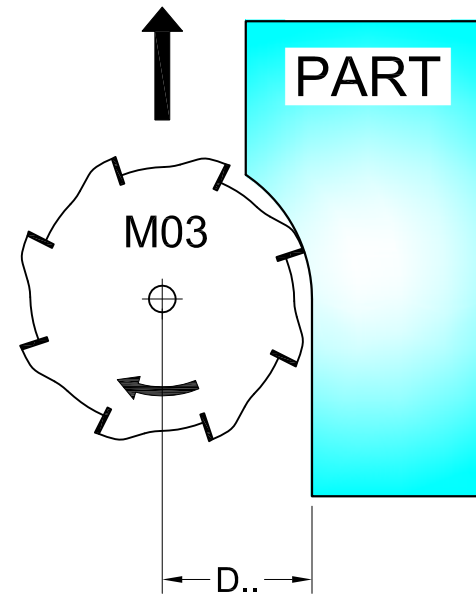


G42 D..



CONVENTIONAL MILLING
or ... UP MILLING

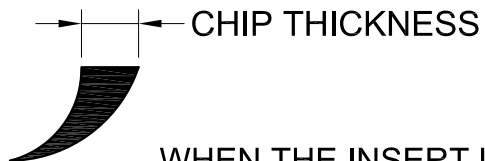
G41 D..



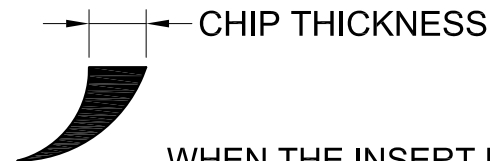
CLIMB MILLING
or ... DOWN MILLING

➡ TOOL MOTION DIRECTION

D = CUTTER RADIUS OFFSET NUMBER



... WHEN THE INSERT LEAVES THE PART



... WHEN THE INSERT ENTERS THE PART