```
(43-02 - SCALING EXERCISE)

(MAIN PROGRAM)
(T01 = 20 MM DIA END MILL)
N1 G21
N2 G50                                  (SCALING OFF)
N3 G17 G40 G80 T01
N4 M06
N5 G90 G54 G00 X95.0 Y37.5 S2500 M03    (CONTOUR START POINT)
N6 G43 Z3.0 H01 M08
N7 G01 Z-3.0 F300.0                     (DEPTH OF THE SMALLEST CONTOUR)
N8 G51 I37.5 J37.5 P0.5                 (SCALING DATA - 0.5 SCALE)
N9 M98 P4352                            (SCALED CONTOUR CUTTING)
N10 G01 Z-5.9                           (DEPTH OF THE MIDDLE CONTOUR)
N11 G51 I37.5 J37.5 P0.7                (SCALING DATA - 0.7 SCALE)
N12 M98 P4352                           (SCALED CONTOUR CUTTING)
N13 G01 Z-8.5                           (DEPTH OF THE LARGEST CONTOUR)
N14 G51 I37.5 J37.5 P0.9                (SCALING DATA - 0.9 SCALE)
N15 M98 P4352                           (SCALED CONTOUR CUTTING)
N16 M09
N17 G28 Z3.0 M05
N18 G50                                 (SCALING OFF - REPEATED FOR SAFETY)
N19 G00 X-50.0 Y250.0                   (PART CHANGE POSITION)
N20 M30
%

O4352 (SUB FOR 43-02 SCALING EXERCISE)
(D51 = CUTTER RADIUS = 10 MM)
N101 G01 G41 Y57.5 D51                  (LEAD-IN LINE WITH G41)
N102 G03 X75.0 Y37.7 I0 J-20.0 F250.0   (LEAD-IN ARC)
N103 G01 Y10.0
N104 G02 X65.0 Y0 I-10.0 J0
N105 G01 X10.0
N106 G02 X0Y10.0 I0 J10.0
N107 G01 Y65.0
N108 G02 X10.0 Y75.0 I10.0 J0
N109 G01 X65.0
N110 G02 X75.0 Y65.0 I0 J-10.0
N111 G01 Y37.5
N112 G03 X95.0 Y17.5 I20.0 J0           (LEAD-OUT ARC)
N113 G00 G40 Y37.5 F500.0               (LEAD-OUT LINE WITH G40)
N114 G50                                (SCALING OFF)
N115 X95.0 Y37.5                        (RETURN TO ORIGINAL START - NOT SCALED)
N116 M99
%
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