```
(LINEAR HOLE PATTERN)
(VERSION 2 - USING A SUBPROGRAM)
(X0Y0 = LL CORNER OF PART - Z0 = TOP OF PART)
(T01 - 10 MM SPOT DRILL)
(T02 - 5 MM DRILL)

(T01 - 10 MM SPOT DRILL)
N1 G21
N2 G17 G40 G80 T01
N3 M06
(*** VERTICAL PATTERN IN Y+ DIRECTION)
N4 G90 G54 G00 X7.0 Y14.0 S1800 M03 T02  (RAPID TO HOLE 1 OF THE VERTICAL PATTERN)
N5 G43 Z25.0 H01 M08
N6 G99 G82 R2.0 Z-2.75 P200 F120.0       (SPOT DRILL H0LE 1 OF THE VERTICAL PATTERN)
N7 M98 P7001                             (CALL SUBPROGRAM)
N8 G90 G80 G00 Z25.0 M09                 (SPOT DRILLING CYCLE CANCELLED)
N9 G28 Z25.0 M05
N10 M01

(T02 - 5 MM DRILL)
N11 T02
N12 M06
(*** VERTICAL PATTERN IN Y+ DIRECTION)
N13 G90 G54 G00 X7.0 Y14.0 S2100 M03 T01 (RAPID TO HOLE 1 OF THE VERTICAL PATTERN)
N14 G43 Z25.0 H02 M08
N15 G99 G81 R2.0 Z-15.0 F170.0           (H0LE 1 OF THE VERTICAL PATTERN)
N16 M98 P7001                            (CALL SUBPROGRAM)
N17 G90 G80 G00 Z25.0 M09                (DRILLING CYCLE CANCELLED)
N18 G28 Z25.0 M05
N19 G91 G28 X0 Y0
N20 M30
%

O7001 (SUBPROGRAM)
N101 G91 Y10.0 L5                        (REMAINING HOLES OF VERTICAL PATTERN)
(*** UPPER ANGULAR PATTERN IN X+Y+ DIRECTION)
N102 G90 X22.0 Y50.0                     (HOLE 1 OF THE UPPER ANGULAR PATTERN)
N103 G91 X9.571 Y2.286 L7                (REMAINING HOLES OF UPPER ANGULAR PATTERN)
(*** HORIZONTAL PATTERN IN X- DIRECTION)
N104 G90 X92.0 Y39.0                     (HOLE 1 OF THE HORIZONTAL PATTERN)
N105 G91 X-7.0 L8                        (REMAINING HOLES OF HORIZONTAL PATTERN)
(*** LOWER ANGULAR PATTERN IN X-Y+ DIRECTION)
N106 G90 X90.0 Y8.0                      (HOLE 1 OF THE LOWER ANGULAR PATTERN)
N107 G91 X-10.337 Y3.762 L6              (REMAINING HOLES OF LOWER ANGULAR PATTERN)
N108 M99
%
```