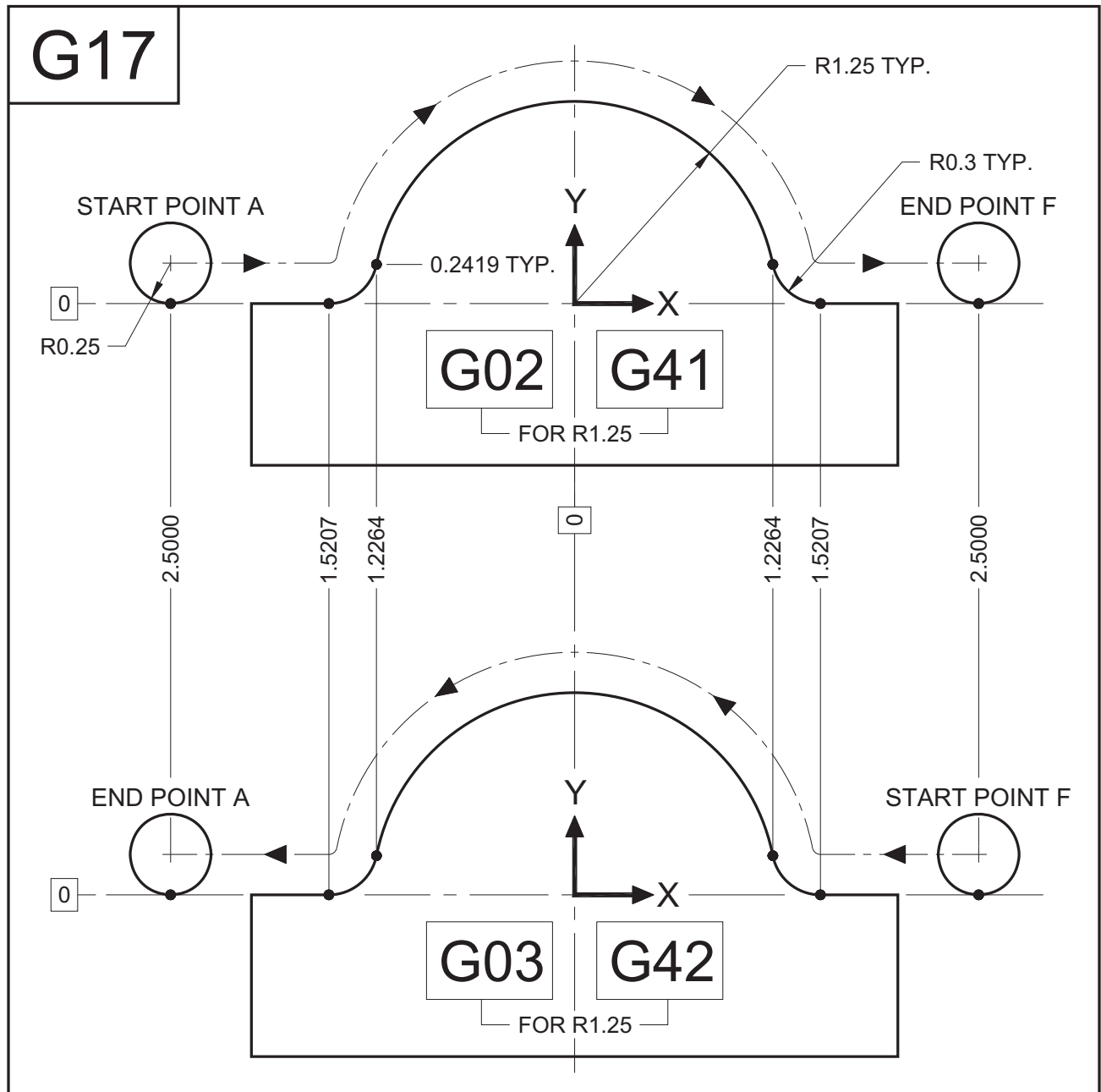


Working in Planes - G17

The illustration below shows the required toolpath and is followed by the two program listings.



(XY PLANE - G17 - TOP - 0.5 DIA FLAT BOTTOM END MILL - D51=0.25)
(FROM POINT A TO POINT F - USES I AND J ARC CENTER VECTORS)

```
N1 G20
N2 G17 G40 G80
N3 G90 G54 G00 X-2.5 Y1.0 S1000 M03
N4 G43 Z0 H01 M08
N5 G41 G01 Y0 D51 F20.0
N6 X-1.5207 F10.0
N7 G03 X-1.2264 Y0.2419 I0 J0.3
N8 G02 X1.2264 I1.2264 J-0.2419
N9 G03 X1.5207 Y0 I0.2943 J0.0581
N10 G01 X2.5
N11 G40 G00 Y1.0
N12 G28 X2.5 Y1.0 Z0 M09
N13 M30
%
```

(XY PLANE - G17 - TOP - 0.5 DIA FLAT BOTTOM END MILL - D51=0.25)
(FROM POINT F TO POINT A - USES I AND J ARC CENTER VECTORS)

```
N1 G20
N2 G17 G40 G80
N3 G90 G54 G00 X2.5 Y1.0 S1000 M03
N4 G43 Z0 H01 M08
N5 G42 G01 Y0 D51 F20.0
N6 X1.5207 F10.0
N7 G02 X1.2264 Y0.2419 I0 J0.3
N8 G03 X-1.2264 I-1.2264 J-0.2419
N9 G02 X-1.5207 Y0 I-0.2943 J0.0581
N10 G01 X-2.5
N11 G40 G00 Y1.0
N12 G28 X-2.5 Y1.0 Z0 M09
N13 M30
%
```