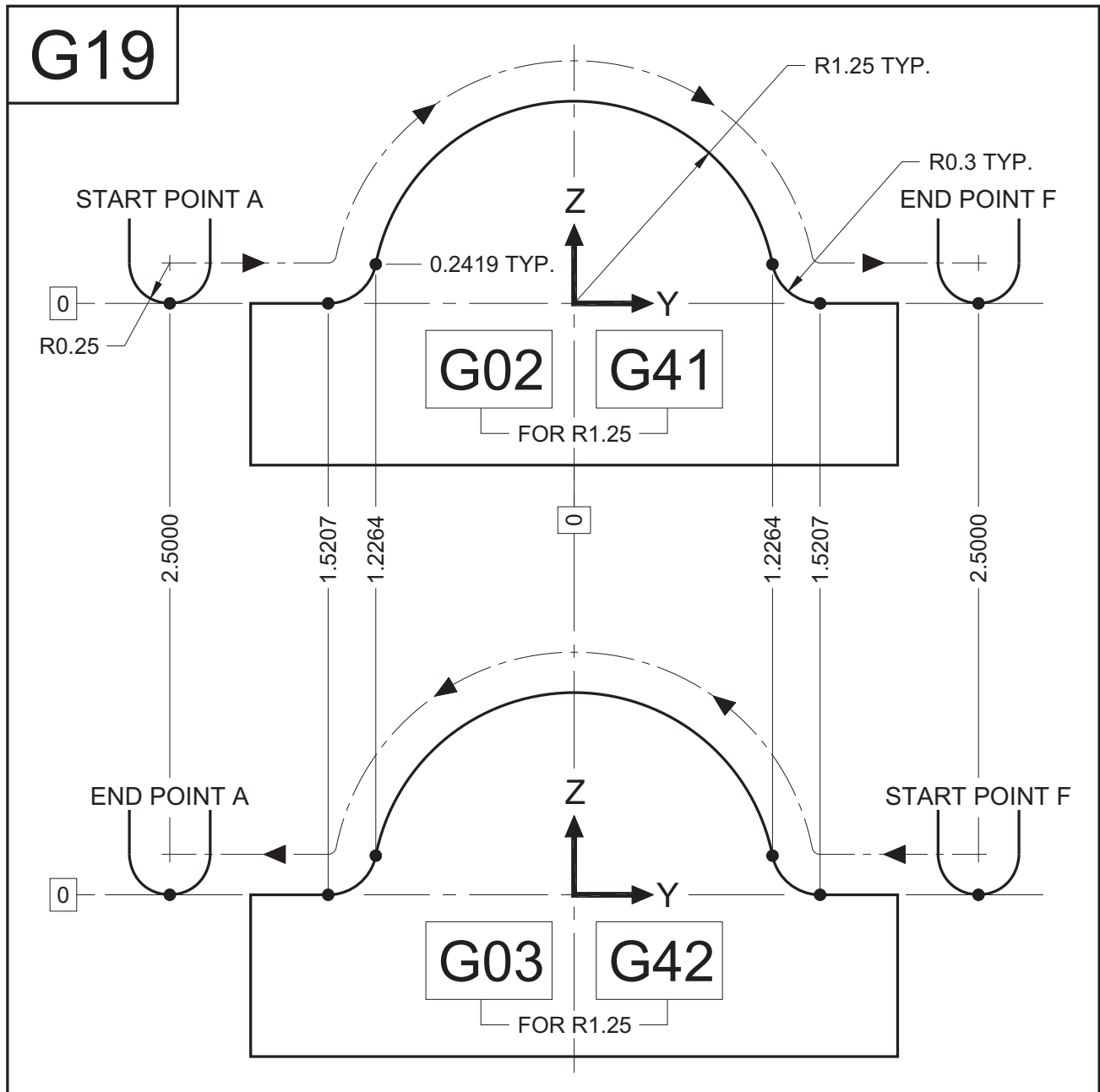


Working in Planes - G19

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



(YZ PLANE - G19 - RIGHT SIDE - 0.5 DIA BALL NOSE END MILL - D51=0.25)
(FROM POINT A TO POINT F - USES J AND K ARC CENTER VECTORS)

```
N1 G20
N2 G17 G40 G80
N3 G90 G54 G00 X0 Y-2.5 S1000 M03
N4 G43 Z1.0 H01 M08
N5 G19 G41 G01 Z0 D51 F20.0
N6 Y-1.5207 F10.0
N7 G03 Y-1.2264 Z0.2419 J0 K0.3
N8 G02 Y1.2264 J1.2264 K-0.2419
N9 G03 Y1.5207 Z0 J0.2943 K0.0581
N10 G01 Y2.5
N11 G40 G00 Z1.0
N12 G17 G28 X0 Y2.5 Z1.0 M09
N13 M30
%
```

(YZ PLANE - G19 - RIGHT SIDE - 0.5 DIA BALL NOSE END MILL - D51=0.25)
(FROM POINT F TO POINT A - USES J AND K ARC CENTER VECTORS)

```
N1 G20
N2 G17 G40 G80
N3 G90 G54 G00 X0 Y2.5 S1000 M03
N4 G43 Z1.0 H01 M08
N5 G19 G42 G01 Z0 D51 F20.0
N6 G01 Y1.5207 F10.0
N7 G02 Y1.2264 Z0.2419 J0 K0.3
N8 G03 Y-1.2264 J-1.2264 K-0.2419
N9 G02 Y-1.5207 Z0 J-0.2943 K0.0581
N10 G01 Y-2.5
N11 G17 G40 G00 Z1.0
N12 G28 X0 Y-2.5 Z1.0 M09
N13 M30
%
```