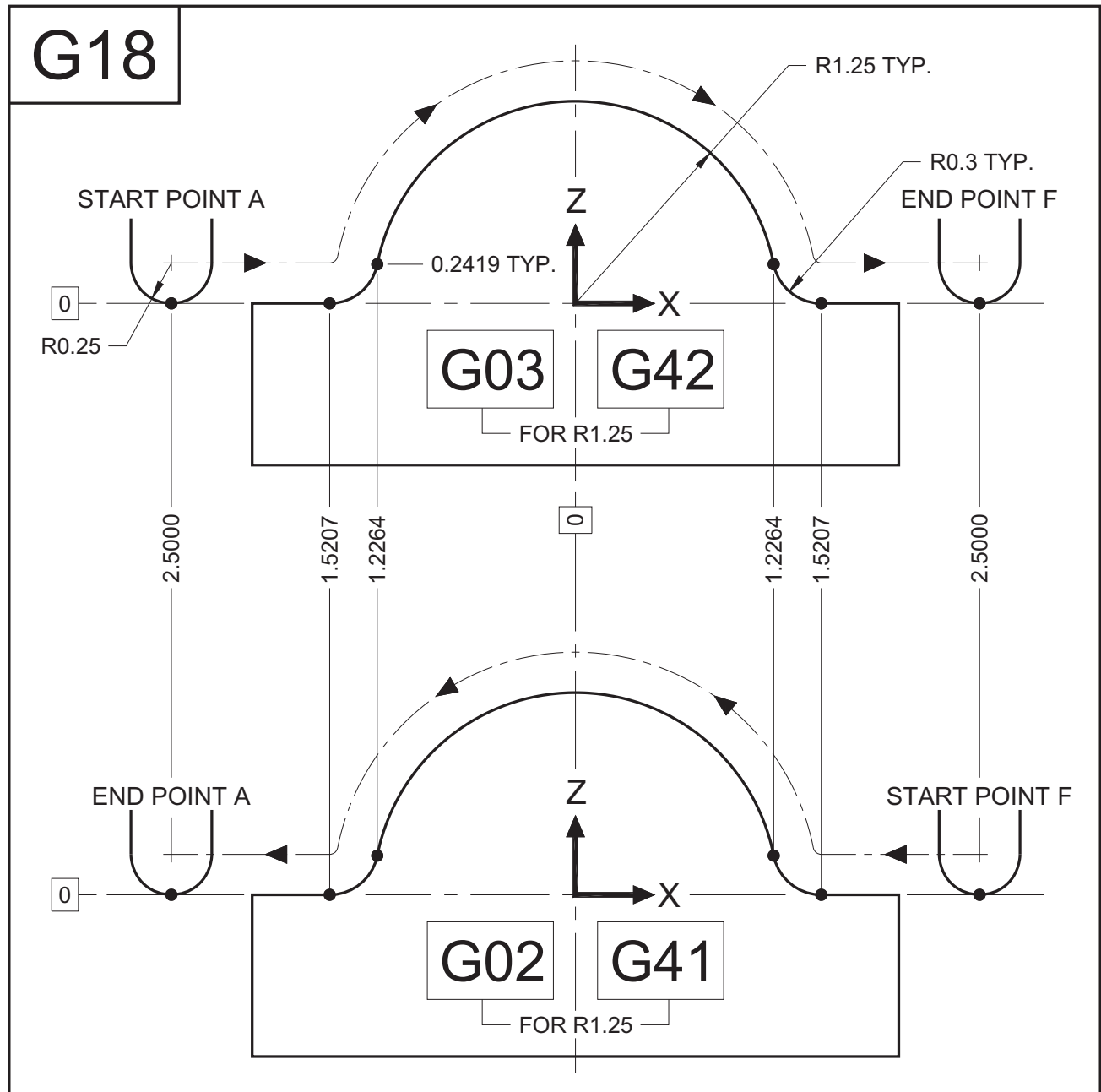


Working in Planes - G18

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



(ZX PLANE - G18 - FRONT - 0.5 DIA BALL NOSE END MILL - D51=0.25)
(FROM POINT A TO POINT F - USES I AND K ARC CENTER VECTORS)

```
N1 G20
N2 G17 G40 G80
N3 G90 G54 G00 X-2.5 Y0 S1000 M03
N4 G43 Z1.0 H01 M08
N5 G18 G01 G42 Z0 D51 F20.0
N6 X-1.5207 F10.0
N7 G02 X-1.2264 Z0.2419 I0 K0.3
N8 G03 X1.2264 I1.2264 K-0.2419
N9 G02 X1.5207 Z0 I0.2943 K0.0581
N10 G01 X2.5
N11 G40 G00 Z1.0
N12 G17 G28 X2.5 Y0 Z1.0 M05
N13 M30
%
```

(ZX PLANE - G18 - FRONT - 0.5 DIA BALL NOSE END MILL - D51=0.25)
(FROM POINT F TO POINT A - USES I AND K ARC CENTER VECTORS)

```
N1 G20
N2 G17 G40 G80
N3 G90 G54 G00 X2.5 Y0 S1000 M03
N4 G43 Z1.0 H01 M08
N5 G18 G01 G41 Z0 D51 F20.0
N6 X1.5207 F10.0
N7 G03 X1.2264 Z0.2419 I0 K0.3
N8 G02 X-1.2264 I-1.2264 K-0.2419
N9 G03 X-1.5207 Z0 I-0.2943 K0.0581
N10 G01 X-2.5
N11 G40 G00 Z1.0
N12 G17 G28 X-2.5 Y0 Z1.0 M05
N13 M30
%
```