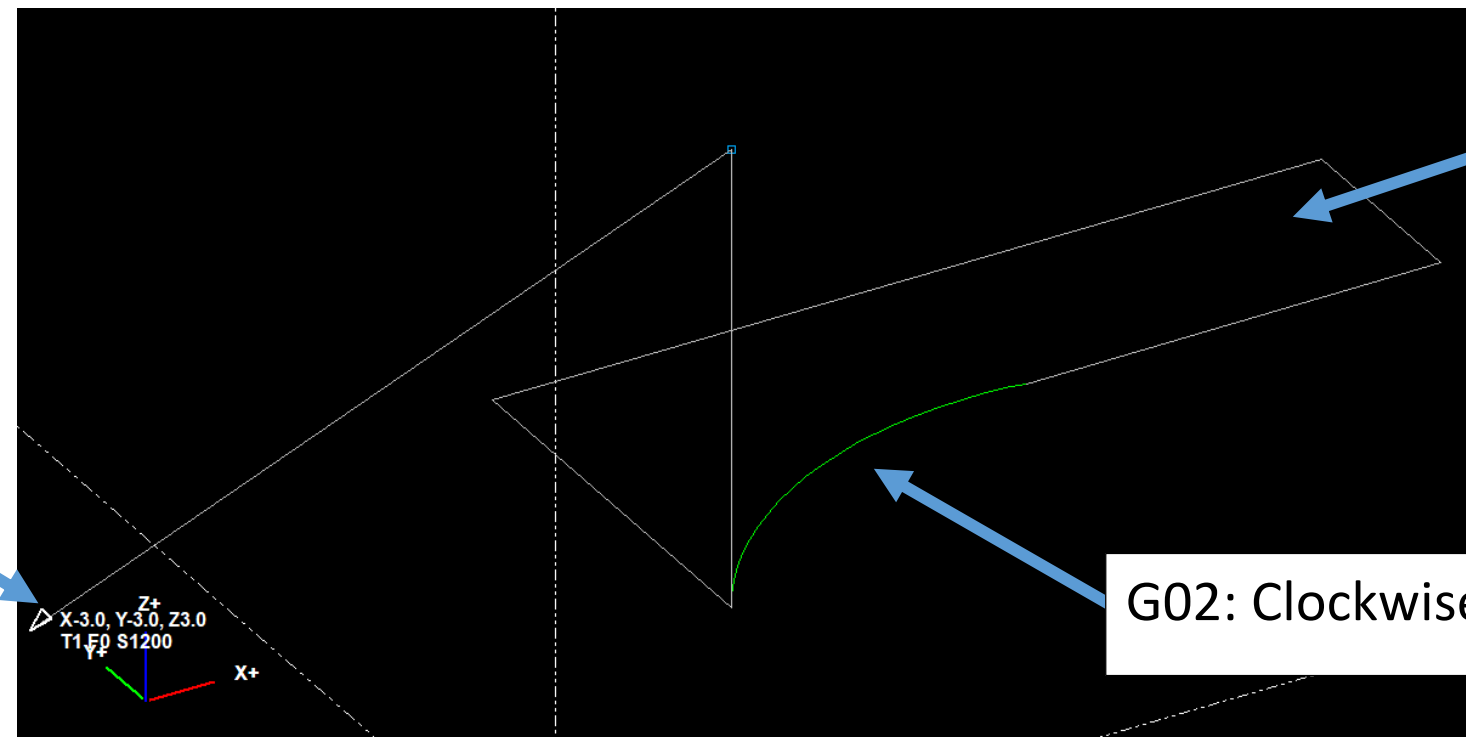


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N10 G90 G59 G17 G70 //G90=Absolute Position, G59=Adaptive Controls, G17=XY Plane, G70=Inches
N20 T1 M06 //T1=Tool Cutter 1, M06=Tool Change
N30 S1200 M03 //S1200=Cutting Speed (RPM), M03=Spindle On Clockwise motion
//NOTE: Movement of cutting tool is Counterclockwise
N35 G00 X-3.00 Y-3.00 Z3.00 //Rapidly Traverse (not cutting) to Home Position
N40 G00 X1.00 Y1.00 Z1.00 //Rapidly Traverse to just above the part
N50 G01 X1.00 Y1.00 Z-0.1 //Traverse to part and height to begin cut
N55 G02 X2.00 Y1.50 Z-0.1 R1.0 //Cut Clockwise arc of R1.0 (makes concave cut; G03 Counterclockwise bows out)
N60 G01 X3.00 Y 1.50 Z-0.1 //Traverse cut to Point
N70 G01 X3.00 Y2.00 Z-0.1 //Traverse cut to Point
N80 G01 X1.00 Y2.00 Z-0.1 //Traverse cut to Point
N90 G01 X1.00 Y1.00 Z-0.1 //Traverse cut to Point
N95 G01 X1.00 Y1.00 Z1.00 //Traverse cutting tool above part
N100 G00 X-3.00 Y-3.00 Z3.00 M05 // Rapidly Traverse to Home Position; M05=Turn Spindle OFF
N110 M02 //M02=Turns Program OFF

```

Home Position: Makes it easier to insert blank material or remove finished product



Profile being cut out of flat stock material

G02: Clockwise Cut