Full Circle CNC Program Example


```
N05  G00  X10  Y25  Z1  S1250  M3
N10  G01  Z-5  F100
N15  G02  X10  Y25  I20  J0  F125
N20  G00  Z100  M5
N25  X-20
N30  M30
```

Summary

N05 Tool rapid traverse (G00) to point P01.

N10 Infeed (G01) to Z-5

N15 X-Y plane selected automatically (G17). Tool travels clockwise around a full circle (G02).

N20/N25 Rapid traverse (G00) retraction.

N30 End of program (M30).

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Michael Brown

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