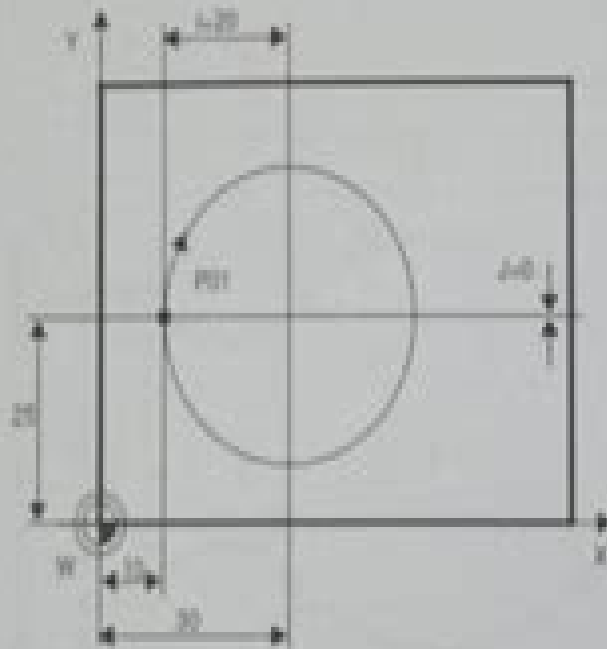


Full Circle CNC Program Example



```
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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Robert R. Redfield



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