

N100 G20  
N110 G0 G17 G40 G49  
N120 T232 M6  
N130 G0 G90 G54 X-.1  
N140 G43 H232 Z.25 M  
N150 Z.2  
N160 G1 Z.1 F6.42  
N170 G2 X-.0679 Y-7.6  
N180 X-.1929 Y-7.794 2  
N190 X-.3179 Y-7.669 2  
N200 X-.1929 Y-7.544 2  
N210 X-.1705 Y-7.546 2  
N220 X-.0679 Y-7.669 2  
N230 X-.1929 Y-7.794 2  
N240 X-.3179 Y-7.669 2  
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N350 X-.1929 Y-7.544 2  
N360 X-.1705 Y-7.546 2  
N370 X-.0679 Y-7.669 2  
N380 X-.0702 Y-7.6927  
N390 G1 X0. Y-7.7062  
N400 G2 X-.0223 Y-7.7  
N410 X-.0003 Y-7.9343  
N420 X-.0025 Y-7.9998  
N430 G1 Y-8.  
N440 G3 X0. Y-8.0025  
N450 X.0025 Y-8. 10. J.  
N460 G1 Y-7.9998  
N470 G2 X.0003 Y-7.93  
N480 X.0223 Y-7.7259  
N490 X0. Y-7.7062 I.73  
N500 G1 Y-7.6017  
N510 G2 X-.1062 Y-7.6  
N520 X-.0754 Y-7.9343  
N530 X-.0773 Y-7.9949  
N540 G3 X-.0775 Y-8. 1  
N550 X0. Y-8.0775 I.07  
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N570 X.0773 Y-7.9949  
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N630 X-.1503 Y-7.9343  
N640 X-.1522 Y-7.99 I-  
N650 G3 X-.1525 Y-8. 1  
N660 X0. Y-8.1525 I.15  
N670 X.1525 Y-8. 10. J.  
N680 X.1522 Y-7.99 I-  
N690 G2 X.1504 Y-7.93  
N700 X.1929 Y-7.669 I.  
N710 X0. Y-7.4887 I.56

# Programming of **CNC** Machines

# 4

EDITION

# Ken Evans

*FOURTH EDITION*

Programming of  
CNC Machines

Ken Evans

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# Dedication

In Memory of my Father, who taught me many things in life,  
especially to love Jesus, to work hard, and to have fun.

To my loving wife, Marci, for her support, patience, and proofreading skills,  
and who kept me on track, and offered countless valuable critiques of  
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Thanks to the many students I have taught over the years and the readers  
of this text. I hope this text will help you have many years of success and an  
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