O0001 (FOUR G CODES G0 G1)

G52 X0 Y0 Z0

G94 G15 G40 G49 G80

G28 G91 Z0

T09 M6 (12MM ENDMILL)

M01

G90 G40 G0 G54

G43 X0 Y0 Z3. H9

S2000 M3

M8

X150. Y150.

X-150.

Y-150.

X150.

X0 Y0

G1 Z0 F100.

X-80. Y-80. Z-6. F500.

X80.

Y80.

X-80.

X80. Y50.

X0 Y0 Z0

G0 Z1.

X112. Y112.

Z-15.

G1 X106. Y100. Y106. F300.

Y-106.

X-106.

Y106.

X106.

X110. Y110.

G0 Z100.

G28 G91 Z0

G28 Y0

M30