

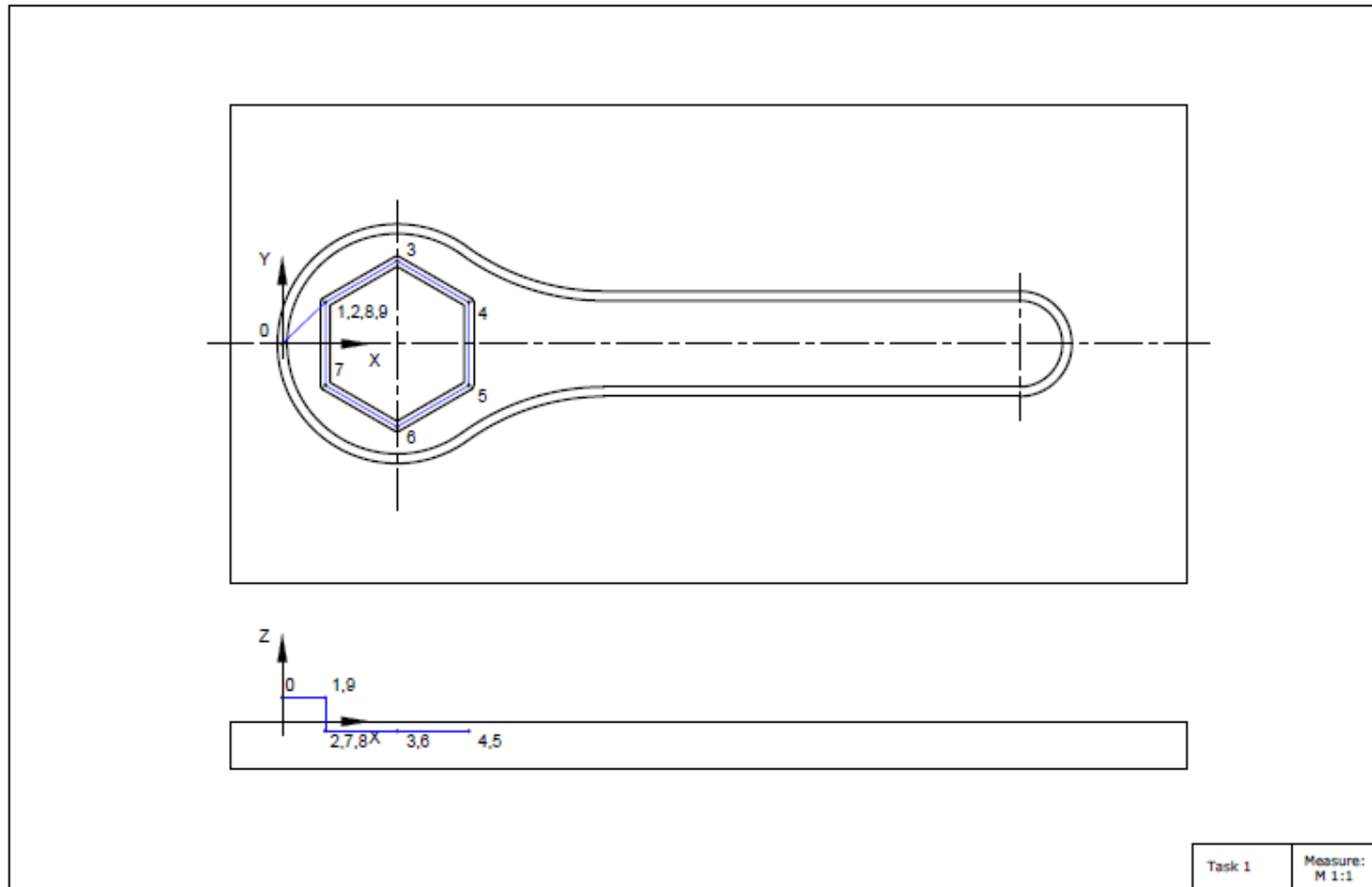
Field of education:  
**Mechanical engineering**

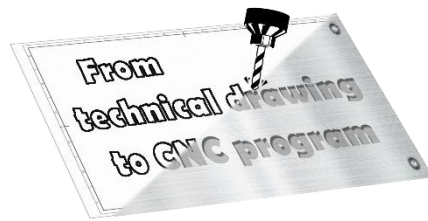
Professional qualification:  
**CNC operator**

Exercise:  
**Programming of CNC machine  
(solution)**

Variant:  
Task 6 – Wrench 2.3.

Solution:





**Required written code that should be inserted into the control unit:**

```
G0 X9 Y8,66  
G1 Z-2  
X24 Y17,321  
X39 Y8,66  
Y-8,66  
X24 Y-17,321  
X9 Y-8,66  
Y8,66  
Z5  
M30
```

**Explanation of the G-code:**

```
%Setting the coordinate system x=0, y=0, z=5; point 0  
G0 X9 Y8,66 %Positioning at the starting point; point 1  
G1 Z-2 %Tool entry into material; point 2  
X24 Y17,321 %Straight milling; point 3  
X39 Y8,66 %Straight milling; point 4  
Y-8,66 %Straight milling; point 5  
X24 Y-17,321 %Straight milling; point 6  
X9 Y-8,66 %Straight milling; point 7  
Y8,66 %Straight milling; point 8  
Z5 %Lifting of tool; point 9  
M30 %End of program
```