



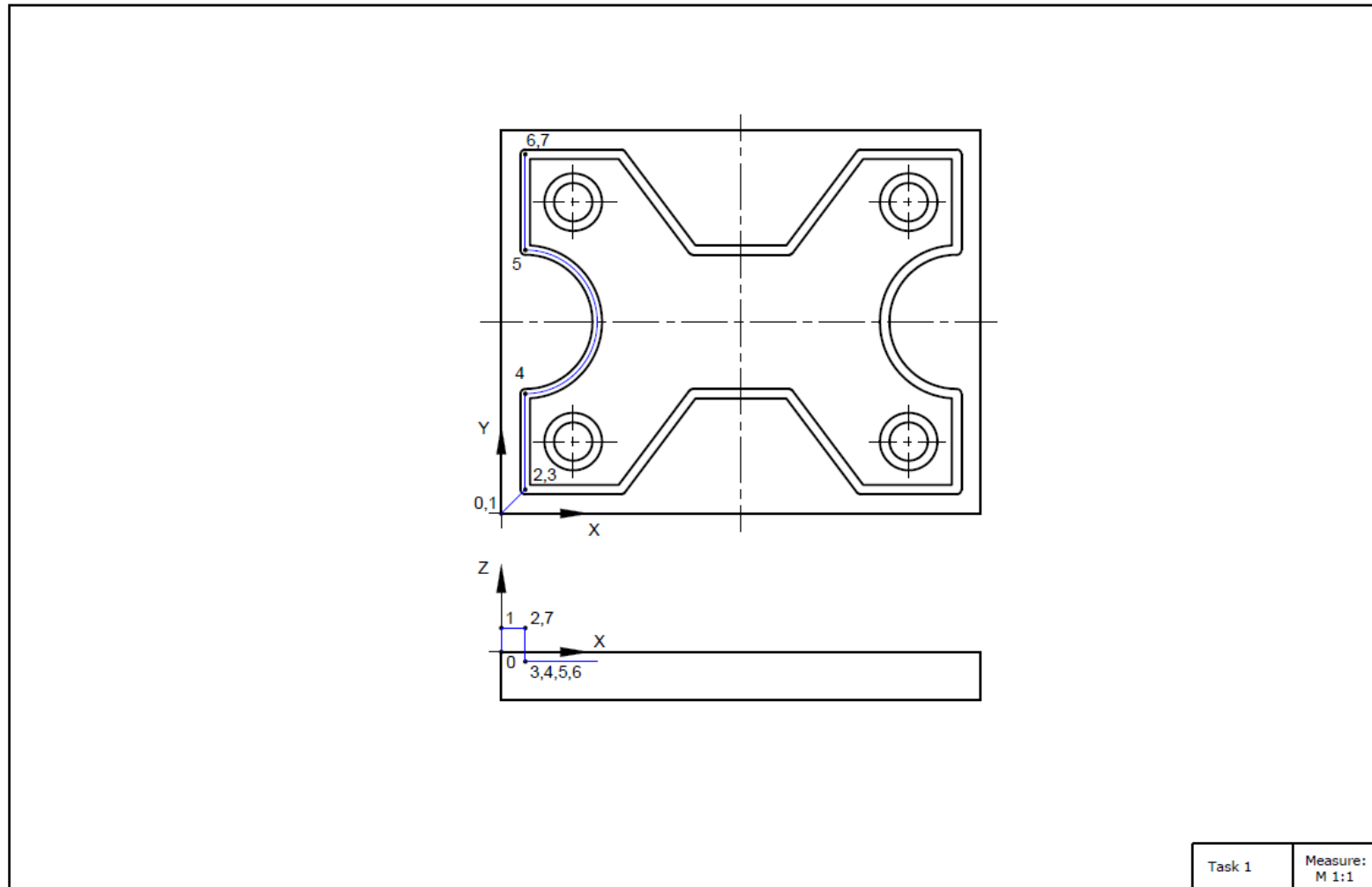
Field of education:  
**Mechanical engineering**

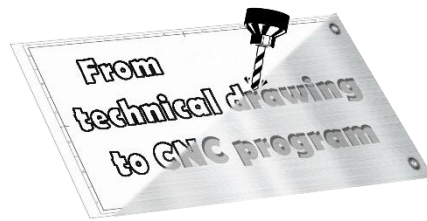
Professional qualification:  
**CNC operator**

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

Variant:  
Task 26 – Support plate 4.1.

Solution:





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

G0 Z5  
X5 Y5  
G1 Z-2  
Y25  
G2 Y50 R15  
G1 Y75  
Z5  
M30

**Explanation of the G-code:**

%Setting the coordinate system  $x=0$ ,  $y=0$ ,  $z=0$ ; point 0

G0 Z5 %Lifting of tool; point 1

X5 Y5 %Positioning at the starting point; point 2

G1 Z-2 %Tool entry into material; point 3

Y25 %Straight milling; point 4

G2 Y50 R15 %Radial milling; point 5

G1 Y75 %Straight milling; point 6

Z5 %Lifting of tool; point 7

M30 %End of program