



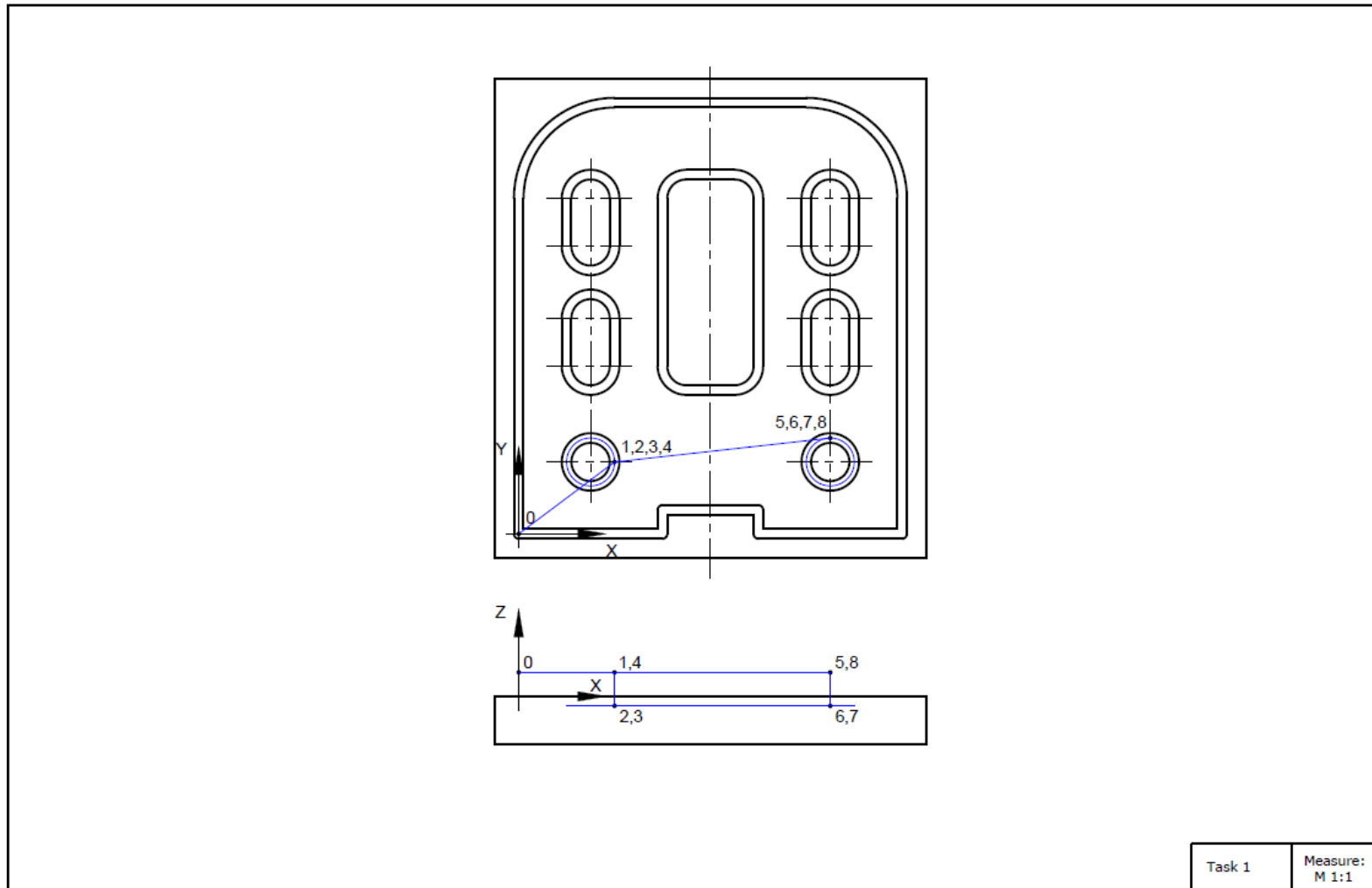
Field of education:  
**Mechanical engineering**

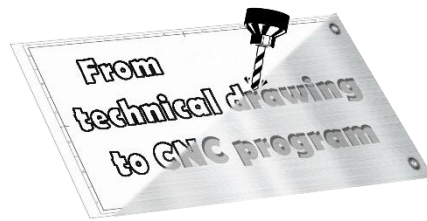
Professional qualification:  
**CNC operator**

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

Variant:  
Task 33 – Support plate 5.3.

Solution:





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

```
G0 X20 Y15  
G1 Z-2  
G2 X20 Y15 I-5 J0  
G1 Z5  
G0 X65 Y20  
G1 Z-2  
G3 X65 Y20 I0 J-5  
G1 Z5  
M30
```

**Explanation of the G-code:**

```
%Setting the coordinate system x=0, y=0, z=5; point 0  
G0 X20 Y15 %Positioning at the starting point; point 1  
G1 Z-2 %Tool entry into material; point 2  
G2 X20 Y15 I-5 J0 %Circle milling; point 3  
G1 Z5 %Lifting of tool; point 4  
G0 X65 Y20 %Positioning; point 5  
G1 Z-2 %Tool entry into material; point 6  
G3 X65 Y20 I0 J-5 %Circle milling; point 7  
G1 Z5 %Lifting of tool  
M30 %End of program
```