

Sample G128 program INT200SY

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O00000001 (sample 1)
N1(Mill Slot)
G53 ( T32 MODE )
M201
T0101.8 B2
G97 S2000 M203
G28 U0
M250
G00 B30.
M251
G17
G128 X2.5 Y0 Z-2. R1 S0.
G98 G00 C0
G0 X0 Z1.
G0 Y4.0 M08
Z.1
M211
G01 Z-.25 F20.
Y-4. F10.
M212
G00 Z1.0
M205
G69.5
G28 U0Y0

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N2(Drill .5" hole Solid Carbide)
G53 ( T32 MODE )
M201
T0202.8 B1
G97 S2000 M203
G28 U0 Y0
M250
B30.
M251
G17
G128 X2.5 Y0 Z-2. R1 S0.
G98 G00 X2. Z1.0
M211
M08
Y-1.0
G01 Z.1 F20.
G01 Z-1. F7.5
G01 Z.1 F400.
G00 Y1.0
G01 Z-1. F7.5
G01 Z.1 F400.
M212
M09
M205
G69.5
G28 U0 Y0
M30

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