

First cut

;begin material setup

(o=0,kw=0.055, ph=0.15, pd=0.2, ch=0.06, fr=43, th=1, cv=124, pe=0, jh=0, jd=0)

F#<_hal[plasmac.cut-feed-rate]>

;end material setup

G0 X6.03922 Y4.42383

M3 \$0 S1 (plasma start)

M67 E3 Q100

G3 X5.91346 Y4.55404 I-0.12798 J0.00222

G1 X2.67415 Y4.61025

G2 X2.65709 Y4.61543 I0.00056 J0.0325

G1 X0.78738 Y5.82222

G2 X0.80503 Y5.88203 I0.01762 J0.02731

G1 X6.75345 Y5.87725

G2 X6.78065 Y5.827 I-0.00003 J-0.0325

G1 X5.9599 Y4.56845

G2 X5.93211 Y4.55371 I-0.02722 J0.01775

G1 X5.91346 Y4.55404

G1 X5.86347 Y4.5549

G3 X5.73327 Y4.42914 I-0.00222 J-0.12798

M5 \$0 (plasma end)

G0 X5.89018 Y3.73531

7th cut

G0 X8.90314 Y4.4445

M3 \$0 S1 (plasma start)

G3 X8.77514 Y4.5725 I-0.128 J0

G1 X7.2 Y4.5725

G2 X7.2 Y5.6275 I0 J0.5275

G1 X8.825 Y5.6275

G2 X8.8525 Y5.6 I0 J-0.0275

G1 X8.8525 Y5.43147

G2 X8.84515 Y5.41199 I-0.0295 J0

G3 X8.84515 Y4.78801 I0.35485 J-0.31199

G2 X8.85023 Y4.77955 I-0.02065 J-0.01816

G1 X8.85073 Y4.77823

G2 X8.8525 Y4.76853 I-0.02573 J-0.0097

G1 X8.8525 Y4.6

G2 X8.825 Y4.5725 I-0.0275 J0

G1 X8.77514 Y4.5725

G1 X8.72514 Y4.5725

G3 X8.59714 Y4.4445 I0 J-0.128

M5 \$0 (plasma end)

G0 X1.53838 Y2.2055