

N10 G18 G20 G40 G49 G64 G80 G90 G94  
N100 G00 X 0 Z 0 ( G02 ARC ABSOLUTE)  
N110 G01 X2 F20  
N120 G01 Z-1.0  
N130 G02 X4.0 Z-2.0 R -1  
N140 G01 Z-3.0  
N150 G4 P2  
N200 G18 G20 G40 G49 G64 G80 G90 G94  
N200 G00 X 4.0 Z -3.0 ( G03 ARC ABSOLUTE BACK TO 0,0 )  
N210 G01 Z-2 F20  
N220 G03 X2.0 Z-1.0 R-1  
N230 G01 Z-0.0  
N240 G01 X0.0  
N250 G4 P2  
N30 G18 G20 G40 G49 G64 G80 G90 G94  
N300 G00 X 0 Z 0 ( G03 90 DEG ARC ABSOLUTE)  
N310 G01 X2 F20  
N320 G01 Z-1.0  
N330 G03 X4.0 Z-2.0 R 1  
N340 G01 Z-3.0  
N350 G4 P2  
N40 G18 G20 G40 G49 G64 G80 G90 G94  
N400 G00 X 4.0 Z -3.0 ( G02 90 DEG ARC ABSOLUTE BACK TO 0,0 )  
N410 G01 Z-2 F20  
N420 G02 X2.0 Z-1.0 R 1  
N430 G01 Z-0.0  
N440 G01 X0.0  
N450 G4 P2  
N50 G18 G20 G40 G49 G64 G80 G90 G94

N500 G00 X 0 Z 0 ( G02 INWARD 90 DEG ARC ABSOLUTE)

N510 G01 X2 F20

N520 G01 Z-1.0

N530 G02 X4.0 Z-2.0 R 1

N540 G01 Z-3.0

N550 G4 P2

N60 G18 G20 G40 G49 G64 G80 G90 G94

N600 G00 X 4.0 Z -3.0 ( G03 INWARD ARC ABSOLUTE BACK)

N610 G01 Z-2.0 F20

N620 G03 X2 Z-1 R 1

N630 G01 Z 0.0

N640 G01 X0.0

N650 G4 P2