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REAL #qLENGTH #qWIDTH #qHEIGHT #qSTEPOVER #qSTEPDOWN #qNUMBER #qTOOL #qTOOLRPM #qCOUNTER
#alternate

#qLENGTH=24 (ENTER LENGTH OF BLOCK IN X)

#qWIDTH=24 (ENTER WIDTH OF BLOCK IN Y)

#qHEIGHT=10 (ENTER HEIGHT OF BLOCK IN Z)

#qSTEPOVER=0.75 (ENTER STEP OVER OF TOOL - 75% OF TOOL DIAMETER)

#qSTEPDOWN=0.25 (ENTER DEPTH OF CUT IN Z)

#qNUMBER=[#qLENGTH/#qSTEPOVER] (NUMBER OF PASSES IN X)

#qTOOL=1 (TOOL: 1.000 inches dia. slot drill)

#qTOOLRPM=14000 (Spindle Speed)

#qCOUNTER=0

#alternate=1

N13 G91 (INCREMENTAL Mode)

N14 S14000 (Spindle Speed)

N15 G20 (Set Units to Inches)

N16 M3 (Spindle On)

N17 M8 (Dust Collector On)

N18 G0 X0.0000 Y0.0000(Go To X/Y Home)

N19 G0 Z1.5000 (Go To Z Home)

N20 G0 X[#qLENGTH+#qSTEPOVER] Y0 Z1.5000

N21 G1 Z-[#qSTEPDOWN] F150.0

WHILE #qCOUNTER<#qNUMBER DO

N26 Y[#alternate*[#qWIDTH+#qSTEPOVER]]

N27 X-#qstepover

#qCOUNTER=#qCOUNTER+1

#alternate=[-1*#alternate]

ENDWHILE

N29 Y0

N30 G0 Z1.5000
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N31 G0 X0.0000 Y0.0000

N32 G53Z0 (Raise Head to Top)

N33 M9 (Dust Collector Off)

N34 M5 (Spindle Off)

N35 G0X0Y0 (Go Home)

N36 (End of File)