

BEGINNING OF COMP MOVE

G0 X50 Y-10
G1 Z-1
G42 D1
G1 X65 Y0
G1 X100 Y0

or

G0 X50 Y-10
G1 Z-1
G42 D1 X65 Y0
G1 X100 Y0

END OF COMP MOVE

.....

G1 X0 Y0

G1 X20 Y0

G40

G1 X30 Y-10

or

.....

G1 X0 Y0

G1 X20 Y0

G40 X30 Y-10

