

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
```

