```
(2019/05/14 V13.6G_C32 20190102 柱底付);
(       PL  ON   OFF   IP   SV  S  UP  DN  JS  LNS  STEP    V  HP PP C  ALV  OC
   LF  JM LS LNM);
C004   =  + 0171 0038 005.1 048 22 010 063 020 0000 0.0000  02 000 00 0 2100 000
0 0002 02 02 000;
C003   =  + 0115 0033 003.3 060 42 010 059 010 0000 0.0000  03 000 00 0 0015 000
0 1502 02 02 000;
C002   =  + 0055 0023 001.6 059 52 012 056 005 0000 0.0000  03 000 00 0 0015 000
0 1302 02 03 000;
C001   =  + 0038 0019 001.5 060 52 012 055 005 0000 0.0000  03 000 00 0 0015 000
0 1302 02 03 000;
;
H005   = +000000.0001   (飛び先 123:荒･中･仕､1:荒､13:荒･仕､12:荒･中､  );
                        (       2:中､23:中･仕、3:仕                    );
H017   = +000000.0000   (1:COMBINATION                                  );
H002   = -000000.6000   (MACHINING DEPTH                                );
H019   = +000000.0002   (LNS                                            );
H018   = +000000.0003   (LNM                                            );
H011   = +000000.1600   (EL1 UNDER SIZE                                 );
H012   = +000000.0000   (EL2 UNDER SIZE                                 );
H013   = +000000.0000   (EL3 UNDER SIZE                                 );
H027   = +000001.0000   (干渉回避位置                                   );
H010   = +000000.0000   (EL PROCESS NO.                                 );
H028   = +000000.0000   (SIDE OFFSET                                    );
H030   = +000000.0000   (BOTTOM OFFSET                                  );
H048   = +000000.0000   (CONDITION COUNT                                );
H000   = +000625.0000   (投影面積                                       );
H003   = +000000.6000   (ACTUAL DEPTH                                   );
H008   = +000095.0101   (CONDITION                                      );
H009   = +000000.0000   (TIMER FOR BOTTOM                               );
H039   = +000000.0000   (TIMER FOR SIDE                                 );
H001   = +000000.0000   (MACHINING DIRECTION                            );
H007   = +000000.0000   (ABS/INC                                        );
H006   = +000060.0000   (SIDE MACHINING AREA                            );
H025   = +000000.0150   (SIDE 逃げ量                                    );
H026   = +000000.0200   (BOTTOM 逃げ量                                  );
H032   = +000000.0000   (LORAN ROTATION                                 );
H037   = +000000.2222   (LP                                             );
;
G90;
H900=H027 H940=0 H941=0 H942=1 H943=0 H950=1 H951=0 H952=0 H910=0 H947=0 H960=0;

IFH005=3(1100);
IFH005=23(1110);
IFH005=2(1110);
JUMP1120;
N1100 H942=3;
G83 Z920;
JUMP2300;
N1110 H942=2;
G83 Z920;
JUMP2200;
N1120;
G83 Z920;
;
N2100;
CRT(- EL1-C004-HOLE1 -);
M98P2001;
CRT(- EL1-C003-HOLE1 -);
M98P2002;
CRT(- EL1-C002-HOLE1 -);
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 62 M98P2003;
 63 CRT(- EL1-C001-HOLE1 -);
 64 M98P2004;
 65 ;
 66 N2200;
 67 N2300;
 68 N2400;
 69 IF H017=1(9999);
 70 M02;
 71 ;
 72 N2001;
 73 C004;
 74 H010=1 H048=1 H028=0.1545 H030=0.1664 H039=0 H009=0;
 75 M98 P3100;
 76 M99;
 77 N2002;
 78 C003;
 79 H010=1 H048=2 H028=0.0786 H030=0.1017 H039=0 H009=0;
 80 M98 P3100;
 81 M99;
 82 N2003;
 83 C002;
 84 H010=1 H048=3 H028=0.0487 H030=0.0546 H039=0 H009=0;
 85 M98 P3100;
 86 M99;
 87 N2004;
 88 C001;
 89 H010=1 H048=4 H028=0.0410 H030=0.0434 H039=0 H009=0;
 90 M98 P3100;
 91 M99;
 92 ;
 93 (V13.0A_C32 0111 STANDARD NC);
 94 N3100 (*************** PATTERN 1 ***************);
 95 G183F0060923;
 96 IF H923<1(3110);
 97 M99;
 98 N3110;
 99 M98 P3500;
100 M98 P3600;
101 JUMP 3900;
102 ;
103 N3200 (*************  PATTERN 2 3  *************);
104 N3300;
105 G183F0060923;
106 IF H923<1(3210);
107 M99;
108 N3210;
109 M98 P3500;
110 M98 P3600;
111 JUMP 3900;
112 ;
113 N3500    (********   PARAMETER SET UP **********);
114 MDIV16 A0D0.030 LEJL0.150 LEJS90.0;
115 G25;
116 LNMH018 LNSH019 LPH037;
117 G85 T H009;
118 N3530                  ( **   WITH ROTATION   ** );
119 IF H960=0(3550);
120 IF H001>0(3550);
121 G83 U947;
122 LAH032+H947;
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 123 G326;
 124 M99;
 125 N3550;
 126 LAH032;
 127 G326;
 128 M99;
 129 ;
 130 N3600(**********   MACHINING   **********);
 131 G90+H007;
 132 IF H048=801(3605);
 133 IF H048=1(3608,3610);
 134 N3605;
 135 G85 ZH009;
 136 N3608;
 137 STEP0                    ( **  1ST MACHINING  ** );
 138 G01 Z+H002+H030 M04;
 139 M99;
 140 N3610;
 141 IF H048>800(,3660);
 142 N3620                   ( **  TIMER MACHINING  ** );
 143 LSEA15.0;
 144 IF H009=0(3640);
 145 IF H009>30(3630);
 146 H009=30;
 147 N3630 G85 ZH009                (**  BOTTOM  ** );
 148 M98 P3800                     ( ** SET STEP ** );
 149 G01 Z+H002+H030 M04;
 150 N3640;
 151 IF H039=0(3655);
 152 IF H039>30(3650);
 153 H039=30;
 154 N3650 G85 ZH039                   ( ** SIDE ** );
 155 M98 P3700                     ( ** SET STEP ** );
 156 G01 Z+H002+H030+H026 M04;
 157 N3655;
 158 LSEA5.0;
 159 M99;
 160 N3660               ( ** 2ND MACH. AND LATER ** );
 161 G83 IP915;
 162 IF H915>70(3670)                   ( ** IP>7 ** );
 163 IF H000<10.0/1/1(3670)         ( ** AREA<10SQ ** );
 164 IF H[010+H010]-H028-H025<0.003/1(3670);
 165 STEP0+H[010+H010]-H028-H025;
 166 LSEA5.0;
 167 G01 Z+H002+H030+0 M04            ( ** BOTTOM ** );
 168 M98 P3700                     ( ** SET STEP ** );
 169 LSEA15.0;
 170 G85 T H039;
 171 G01 Z+H002+H030+H026 M04           ( ** SIDE ** );
 172 JUMP3673;
 173 N3670;
 174 M98 P3700                     ( ** SET STEP ** );
 175 LSEA5.0;
 176 G01 Z+H002+H030 M04                ( ** ALL ** );
 177 N3673;
 178 LSEA5.0;
 179 M99;
 180 ;
 181 N3700(**********   SET STEP 1  **********);
 182 IF H[010+H010]-H028<0.003/1(3710);
 183 STEP0+H[010+H010]-H028;
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 184 JUMP3720;
 185 N3710;
 186 STEP0;
 187 N3720;
 188 M99;
 189 ;
 190 N3800(**************   SET STEP 2  **************);
 191 IF H[010+H010]-H028-H025<0.003/1(3810);
 192 STEP0+H[010+H010]-H028-H025;
 193 JUMP3820;
 194 N3810;
 195 STEP0;
 196 N3820;
 197 M99;
 198 ;
 199 N3900 (**************   READ TIME   **************);
 200 G327;
 201 G90;
 202 G83 T[300+H952];
 203 H[301+H952]=99999;
 204 IF H952>100(3999);
 205 H952=H952+1;
 206 M99;
 207 N3999;
 208 H952=0;
 209 M99;
 210 N9999;
```