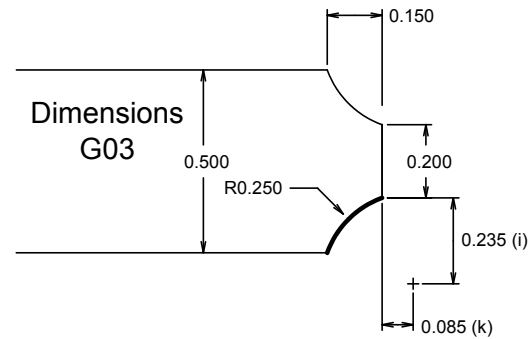
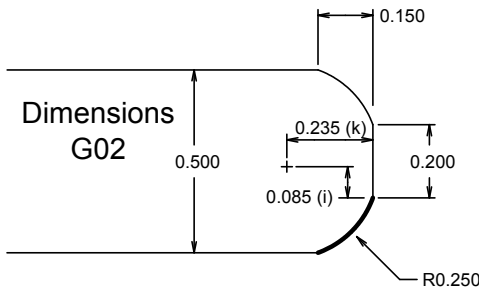
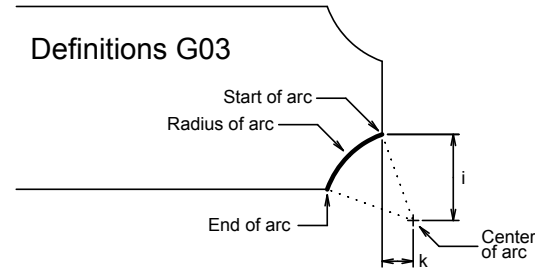
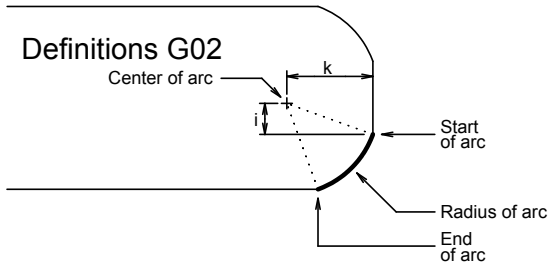


G02 and G03 Arcs by **Radius (r)**:
G02XnZnRn / G03XnZnRn:

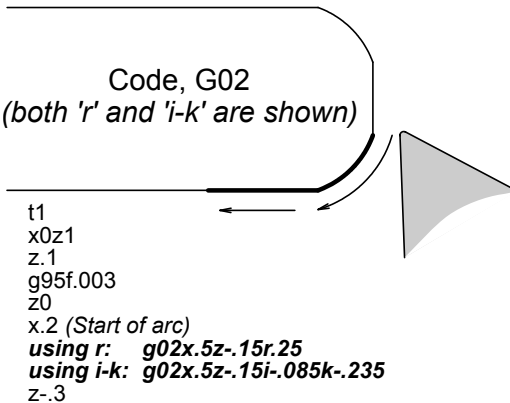
G02 and G03 Arcs by **Center (i-k)**:
G02XnZnInKn / G03XnZnInKn

Xn: X location (Ø) at the end of the arc
Zn: Z location at the end of the arc
Rn: Radius of arc
In: X location of center of arc (incremental)
Kn: Z location of center of arc (incremental)

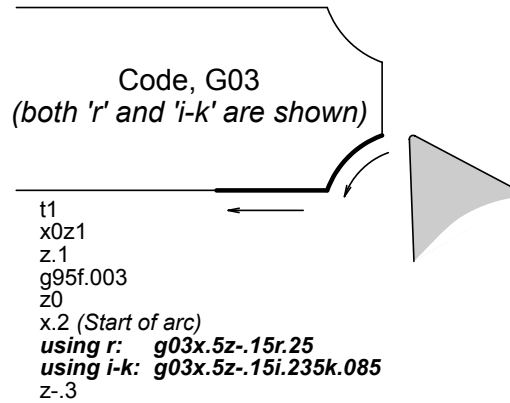
Position tool at Start of arc before calling arc move.



Code, G02
(both 'r' and 'i-k' are shown)

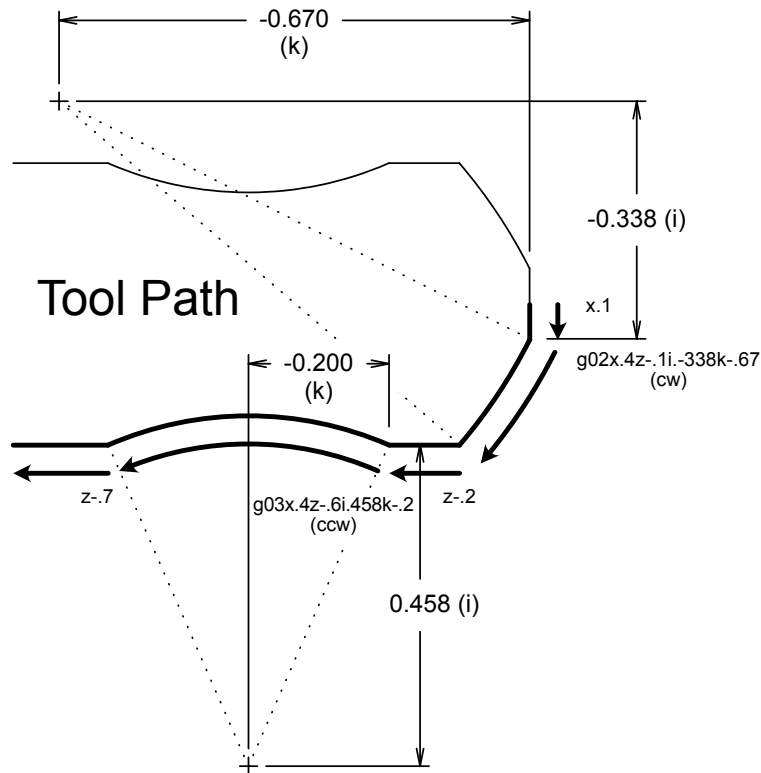


Code, G03
(both 'r' and 'i-k' are shown)



G02 and G03 Example: Arc by Center (G02XnZnInKn)

G02: Clockwise
G03: Counter clockwise
Xn: X location (Ø) at the end of the arc
Zn: Z location of end of the arc
In: X location center of the arc
Kn: Z location center of the arc (*incremental*)



```
Code Fragment
:
t1
x0z1
z.1
g95f.003
z0
x.1
g02x.4z-.1i-.338k-.67
z-.2
g03x.4z-.6i.458k-.2
z-.7
:
```

