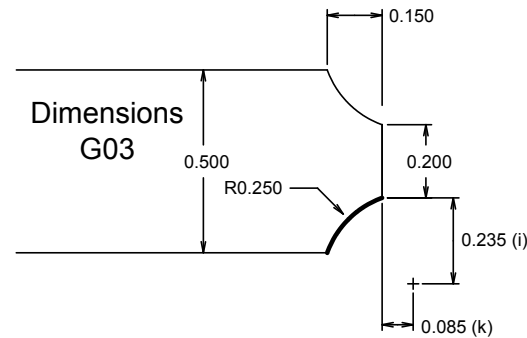
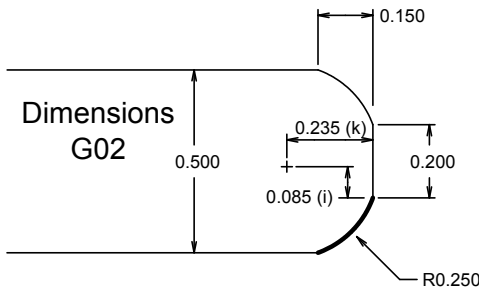
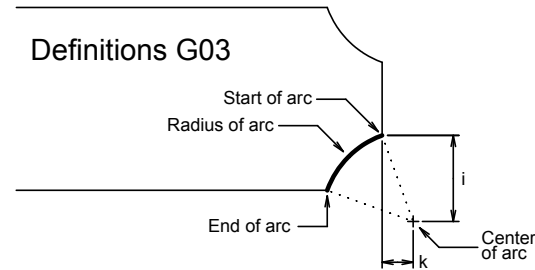
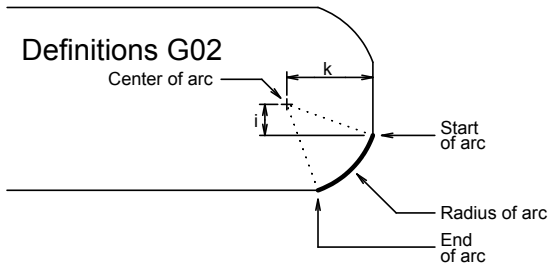


G02 and G03 Arcs by **Radius (r)**:
G02XnZnRn / G03XnZnRn:

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)

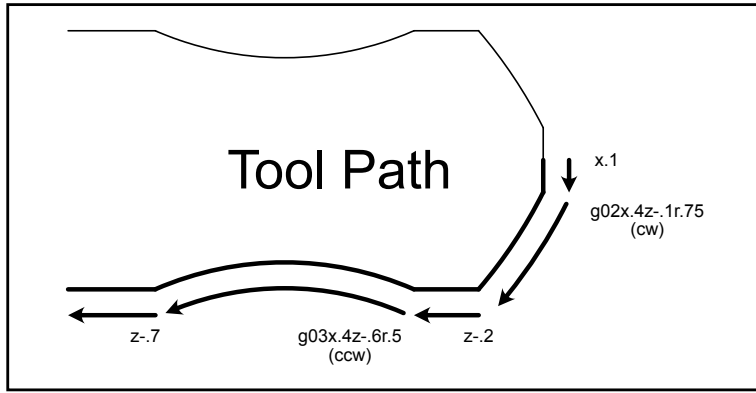
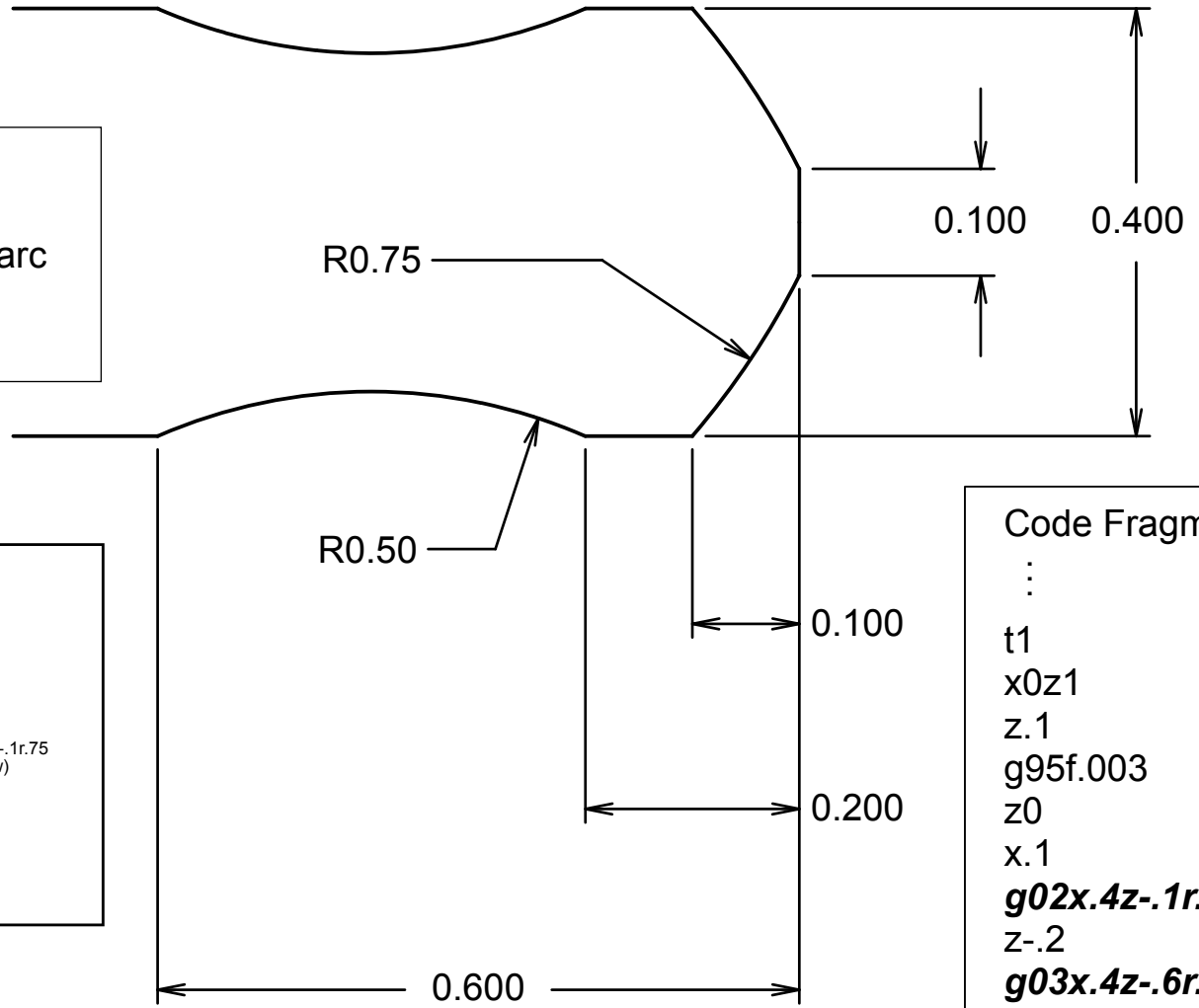
```
t1
x0z1
z.1
g95f.003
z0
x.2 (Start of arc)
using r: g02x.5z-.15r.25
using i-k: g02x.5z-.15i-.085k-.235
z-.3
```

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

```
t1
x0z1
z.1
g95f.003
z0
x.2 (Start of arc)
using r: g03x.5z-.15r.25
using i-k: g03x.5z-.15i.235k.085
z-.3
```

G02 and G03 Example: Arc by Radius (G02XnZnRn)

G02: Clockwise
G03: Counter clockwise
Xn: X location (Ø) at the end of the arc
Zn: Z location of end of the arc
R: Radius of the arc



Code Fragment

```

:
t1
x0z1
z.1
g95f.003
z0
x.1
g02x.4z-.1r.75
z-.2
g03x.4z-.6r.5
z-.7
:

```