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THE EFFECT OF PROBE FREQUENCY IN ULTRASONIC TESTING

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Laporan ini dikemukakan sebagai memenuhi syarat sebahagian daripada syarat penganugerahan Ijazah Sarjana Muda Kejuruteraan Mekanikal (Design&Inovasi)

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“Saya akui laporan ini adalah hasil kerja saya sendiri kecuali ringkasan dan petikan yang tiap-tiap satunya saya telah jelaskan sumbernya”

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Untuk ayah dan ibu tersayang

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ABSTRACT

This research is conducted to investigate the effect of different probe frequency in Ultrasonic Testing. From the literature, the investigation about the probe frequency in Ultrasonic Testing has not been clearly investigated until now. Ultrasonic Testing is part of Nondestructive Testing and used widely to detect flaws and thickness of specimen without destroying the specimen. In the methodology chapter, the test sample is design using Catia V5R16 and fabricated using CNC Universal Milling Machine for 5-Axis. For the experiment work, dual crystal probe type is used, whereby the probe frequency that is manipulated during experiment are 2 MHz, 4 MHz and 5 MHz. The result for this experiment is the reflected sound energy from A-scanned. From the observation, it is shows that high frequency probe has low amplitude, low noise and sharp peak while low frequency probe shows high amplitude, high noise and wide peak. Through this result, the different characteristic for each level frequency that is high (5 MHz) and low (2 MHz) is discussed. The characteristic of high frequency is high attenuation, narrow beam and less penetration in contrast, low frequency has less attenuation, more penetration depth and flaw sensitivity. From this characteristic, it shows that high frequency probe suitable to detect small thickness, thin material and suitable in noisy environment, meanwhile low frequency probe is suitable for rough surface, grainy materials, small size and high depth defects.

ABSTRAK

Kajian ini khusus untuk mengkaji kesan frekuensi pemindaharuh ultrabunyi yang berbeza di dalam penggunaan pemeriksaan ultrabunyi. Dari kajian literatur, kajian mengenai kesan penggunaan frekuensi pemindaharuh ultrabunyi yang berbeza masih tidak jelas lagi dibincangkan sehingga ke hari ini. Pemeriksaan ultrabunyi merupakan cabang Kajian Tanpa Musnah yang digunakan secara meluas untuk mengesan kecacatan serta menguji kedalaman spesimen tanpa memusnahkannya. Dalam bab metodologi, bahan ujikaji telah direka dan difabrikasi menggunakan mesin CNC Universal Milling Machine for 5-Axis. Untuk eksperimen ini, jenis pemindaharuh bunyi satu kristal akan digunakan dengan pemindaharuh bunyi frekuensi sebagai pembolehubah yang dimanipulasikan di mana 2 MHz, 4 MHz dan 5 MHz digunakan. Hasil eksperimen ini ialah pantulan tenaga suara dari 'A-scanned'. Dari pemerhatian, pemindaharuh berfrekuensi tinggi mempunyai amplitud yang rendah, kurang gangguan bunyi dan puncak yang tajam sementara pemindaharuh berfrekuensi rendah menunjukkan amplitud yang tinggi, gangguan bunyi yang tinggi dan puncak yang lebar. Melalui keputusan ini, perbezaan ciri untuk setiap peringkat frekuensi di mana tinggi (5 MHz) dan rendah (2MHz) dibincangkan. Ciri-ciri pemindaharuh berfrekuensi tinggi ialah mudah kehilangan tenaga, pancaran kecil dan kadar penembusan rendah dan berlawanan dengannya, pemindaharuh berfrekuensi rendah lebih susah untuk kehilangan tenaga, kadar penembusan yang tinggi dan sensitif dengan kecacatan. Ciri-ciri ini menunjukkan bahawa pemindaharuh berfrekuensi tinggi sesuai untuk mengesan kecacatan pada kedalaman yang rendah, bahan yang nipis dan persekitaran yang bising

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CHAPTER 1

INTRODUCTION

Nondestructive Testing or NDT is a testing where the test object is not been destroyed. There are different methods to detect different defects. NDT techniques has two categories. The first category is only detect and size defects or damage present on the surface; and second category can detect and size defects/damage embodied within a component. There are various NDT technique that are used in industrial. This include the Dye Penetrant Inspection (PT), Eddy Currents (EC), Magnetic Particle Inspection (MPI or MT), Radiography (RT) and Ultrasonic Testing (UT). Each of these various technique suitable in certain application and be of little or no value at all in other application. To enhance performances of NDT, choosing the right techniques is essential. Types of defects that can be detects are planar defects, laminations, voids and inclusions, wall thinning, corrosion pits and structural deformities such as dents, bulges and ovality. However, UT has been chosen for this project due to it abilities and advantages than the other techniques. UT can be carried out from a single surface, can detect internal flaws with accurate location and provides reliable crack depth.

1.1 Background of the project

Ultrasonic sound waves used to help measure material thickness, integrity and other physical properties in manufacturing or in-service situations. In the Ultrasonic Testing, sound waves are applied that are too high so cannot be detected by human ears, which is more than 20 kHz. To detect flaws in metal material, a range of 1 MHz to 6 MHz is used [1]. This high frequencies ultrasound are produce from Piezo-electric Effect. Flaws are detected by moving the probe over surface of the material that will be checked. However, layer of liquids (water, oil, grease) used in between of material and probe and material. This probe will produce a beam of ultrasound that passes inside the material and reflected if there is any flaws and discontinuity. Then, the same probe will receive the ultrasound. This reflected ultrasound in the form of signal with an amplitude representing the intensity of the reflection and the distance taken for the reflection to return to the probe will be seen in the screen on the calibrated diagnostic machine. The parameters that affecting the reading of Ultrasonic Testing is the probes type and frequency. For probes type, there are single crystal, dual crystal and also angle beam probe. Probes are also one-half-wavelength-long section that act as mechanical transformers to increase the amplitude of vibration generated by the converter. Probes are made to resonate at a specific frequency. The environment factors should be concern when using Ultrasonic Testing devices. Frequency is measured in cycles per second or Hertz. The more vibrations or oscillations each molecule makes in a set period of time, the higher the frequency. By increasing the probe diameter or increasing the frequency, the solid angle of beam will decrease. The factors consists of temperature, air turbulence and convection currents, atmospheric pressure, humidity, acoustic interference, radio frequency interference and splashing liquids. The other possible factor that will affecting Ultrasonic Testing experiment are composition, shape, target orientation to sensor and averaging.

1.2 Problem Statement

Transducer or probe is one of the basic component for an ultrasonic testing system. It is manufactured in variety of forms, shapes and sizes to suit for varying applications. Selection of correct probe frequency is one of the critical parameter to optimize the Ultrasonic Testing capabilities. Proper selection is important to ensure accurate inspection data as desired for specific applications. Therefore, an investigation is required to specify the suitability of different range of probe frequency.

1.3 Objective

This project is conducted to investigate the effect of selection of probe frequency in Ultrasonic Testing results and specify the suitability of different range of probe frequency in Ultrasonic Testing. In this project, the test sample for the experiment will be design and the suitability of probe frequency in Ultrasonic Testing will be investigated experimentally.

1.4 Scope

The Ultrasonic Testing test sample is designed and fabricated, the experimental procedure to investigate the effect of different probe frequency is developed and the experiment is conducted based on the procedure to study the suitability of probe frequency in Ultrasonic Testing is specified. The planning and execution of PSM 1 and PSM 2 can be referred in Appendix 1A.

CHAPTER 2

LITERATURE REVIEW

2.1 An overview of Ultrasonic

Since the publication of Lord Rayleigh's work on sound in "The Theory of Sound"; this work explained the nature and properties of sound waves which led to the development of the techniques that are currently in use in nondestructive testing [2].

Ultrasounds or Ultrasonics is a sound that generated above the human hearing range. Vibrations above 20 KHz are termed "Ultrasonic waves". 0.5 MHz to 20 MHz is the usual frequency range for ultrasonic flaw detection[2,3]. However, from [1], the frequency range for ultrasonic nondestructive testing and thickness gage is 0.1 MHz to 50 MHz. The Piezo-Electric Effect is used to produce these high frequencies [2,4,5]. Although ultrasound behaves in a similar manner to audible sound, it has a much shorter wavelength. This means it can be reflected off very small surfaces such as defects inside materials. It is this property that makes ultrasound useful for nondestructive testing of materials.

The Acoustic Spectrum in Figure 2.1 below shows the breaks down sound into 3 ranges of frequencies. The Ultrasonic Range is then broken down further into 3 sub sections [1].

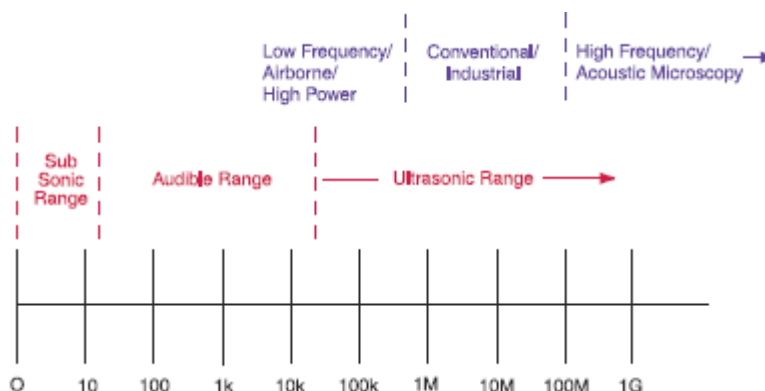


Figure 2.1: Acoustic Spectrum [1]

From the figure above, the part of the spectrum from zero to 16 Hz is below the range of human hearing and is called the ‘Subsonic’, or ‘Infrasonic’ range. From 16 Hz to 20 KHz is known as the ‘Audible’ range and above 20 KHz as the ‘Ultrasonic’ range. Ultrasonic flaw detection uses vibrations at frequencies above 20 KHz.

Most flaw detection takes place between 500 KHz and 20 MHz although there are some applications, for example in concrete, that use much lower frequencies and there are special applications at frequencies above 20 MHz. In most practical applications in steels and light alloys, frequencies between 2 MHz and 10 MHz predominate. Generally the higher the test frequency, the smaller the minimum detectable flaw, but it will be shown in following articles that higher frequencies are more readily attenuated by the test structure. Choosing an appropriate test frequency becomes a compromise between the size of flaw that can be detected and the ability to get sufficient sound energy to the prospective flaw depth [3].

2.1.1 Piezo-electric Effect

In the Ultrasonic Testing, the crystal given a sharp knock by mechanical means so it will be vibrate for a short period at its resonant frequency producing an alternating potential across its surfaces at the same frequency. Such devices which convert electrical

energy to mechanical energy or vice-versa are called transducer which are incorporated in device call probe. Usually this probe manufactured from a number of materials such as quartz and ceramic. The vibrating crystal is used to produce ultrasonic compression waves within the probe [3].

2.1.2 Ultrasonic Processors

Ultrasonic processors consists of three major components; power supply (generator), a converter (transducer) and a probe (horn)[4].

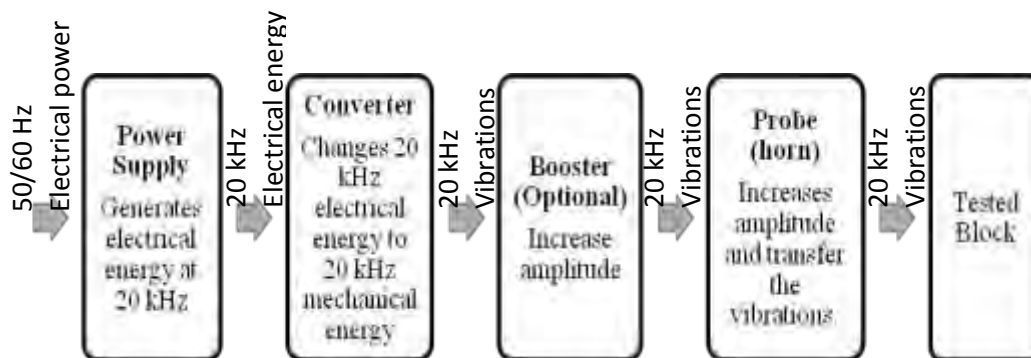


Figure 2.2: Ultrasonic Processor [4]

From the Figure 2.2, power supply generates energy from the electrical power. Then this electrical energy is convert to mechanical energy using transducer. To increase amplitude, booster is used. Lastly, probe increases the amplitude and transfer the vibrations to the tested blocks.

However, according to Heiller C.J. others termed to describe the transducer are “probe”, “search unit”, and “test head” [2]. Throughout this research transducer will refer as probe.

2.1.3 Ultrasonic Probes

Probes are also one-half-wavelength-long section that act as mechanical transformers to increase the amplitude of vibration generated by the converter. Probes are made to resonate at a specific frequency. 20 kHz probes are typically 5 inch and can be made longer in 5 inch increments. 40 kHz probes are typically 2.5 inch long and can be made longer in 2.5 inch increments [4].

2.1.4 Frequency

For frequency selection between varied instruments by respective manufactures it is important to predetermined nominal frequency of the transducer operated based on their thickness. Though the probe oscillates at its resonant frequencies, but other frequency produce, some higher and some lower than the nominal center frequency. Some undesirable frequencies are filtered out because they produce low-level noise and by this can reduce “the signal-to-noise” ratio. The signal from a reflector must be visible above the background noise caused by material grain and other factor such as instrument circuit noise [2].

Some ultrasonic instrument is designed so that the individual frequencies are user-selectable but some accept a range of frequency that are not user-selectable. These are classified as having either narrow band receivers or broad band receivers. The

narrow band receivers is usually user-selectable. In this case, the user selects the frequency nearest to that of the transducer being used. The effect is that receiver processes only the frequency selected, within a certain “bandwidth”. This circuitry will filter out frequencies outside this bandwidth. Another name for this type is “bandpass filter”. There are other types of filters. Those that allow frequencies higher than a certain value to be processed are called “low-pass filters”. When conducting a test on very grainy material, low-frequency energy is used to help overcome the grain noise. In this case, it is advantageous to use a low-pass filter to reject the scattered higher-frequency energy. This usually helps to increase the signal-to-noise ratio and provide superior data [2].

The frequencies of the probe element determines the wavelength of the ultrasound within the test material. Combined with the geometry of the element, the frequency also establishes the extent of the near-field or natural focusing point and the amount of beam-spreading in the far-field or the points beyond the focal point [6].

The higher the frequency the greater the attenuation by absorption and scatter, therefore, when working on coarse grain structures which cause high attenuation a lower frequency probe is selected. Attenuation is the decrease of sound pressure when a wave travels through a material arising from absorption and scattering.

Lowering the frequency has the effect of increasing the beam angle. To overcome this we can increase the crystal diameter.

Generally, when testing steels of relatively thin section attenuation is by using a higher frequencies which produce a narrow, well defined beam. These higher frequencies correspond to shorter wavelengths and result in shorter pulse lengths which provide a greater practice, defects with diameters of less than half a wavelength cannot be detected.

A probe with good resolution will be able to detect small defects and will be able to resolve defects which are close together [3].

The environment factors should be concern when using Ultrasonic Testing devices. The factors consist of temperature, air turbulence and convection currents, atmospheric pressure, humidity, acoustic interference, radio frequency interference and splashing liquids. The other possible factor that will affecting Ultrasonic Testing experiment are composition, shape, target orientation to sensor and averaging [7].

2.2 Previous research

A studies of Automation of Ultrasonic Testing Procedures has been conducted. It involves the use of both longitudinal and transverse high-frequency sound waves for the exploration and/or mapping of both surface and sub-surface defect or irregularities. The aim for this studies is to determine the location of defects, the size of defects and acceptability of the defects in the specimen. However this research is only focusing on the procedure, so there are no discussion of the A-scan readings and potentials errors. USD 15 ultrasonic flaw detector and 90° probe is used. The frequency that suggested is 0.5 MHz to 20 MHz [8].

A research measurement of the viscoelastic anisotropic properties of composites made of polymeric matrix and long fibers, using two transducer with section size of 40×100 mm that captured from various angle had been made. It found that, this immersion ultrasonic method gives general good estimations of the attenuation values in the directions that are not too far from the direction normal to the plate. The bandwidth 6 dB is 0.3 MHz for a central frequency of 0.5 MHz due to specimen that polymer and glass fiber used [9].

According to the research of Ultrasonic detection of defects in strongly attenuating structures using the Hilbert–Huang transform, the purpose of the studies is to improve visualization of defects. Ultrasonic signals were processed using Hilbert-Huang method. The probe that used is Panametric Transducer V308 aperture 19 mm. Using plastic pipe as specimen, 5 MHz is set as the frequency. From this research it shows that the higher frequency the greater attenuation, therefore detection and characterization of defects of a similar size at different distances become complicated. Sound attenuation is the decreased of sound pressure when a wave travels through a material arising from absorption and scattering. As a conclusion, the experimental investigations demonstrated a good performance of the proposed technique in the case of highly attenuating plastic pipes [10].

A research of continuous-wave ultrasound reflectometry for surface roughness imaging applications, using continuous-wave ultrasound reflectometry (CWUR) as a novel nondestructive modality for imaging and measuring surface roughness in a non-contact mode is made. In CWUR, voltage variations due to phase shifts in the reflected ultrasound waves are recorded and processed to form an image of surface roughness. The purpose is to work out new experimental methods and efficient tools for quantitative estimation of surface roughness. The result of this experiment is an acrylic test block with surface irregularities ranging from 4.22 μm to 19.05 μm as measured by a coordinate measuring machine (CMM), is scanned by an ultrasound transducer having a diameter of 45 mm, a focal distance of 70 mm, and a central frequency of 3 MHz. It is shown that CWUR technique gives very good agreement with the results obtained through CMM in as much as the maximum average percent error is around 11.5% [11].

The Ultrasonic technique is applied for monitoring the alcoholic wine fermentation. This technique consists in placing a test tube, containing the analyzing fluid, between two matched ultrasonic piezoelectric transducers, one used as transmitter and the other as receiver. The transmitter generates an ultrasonic wave in the liquid sample which is received by the receiver; the attenuation and the delay of the received

signal in respect to the transmitted one are used to characterize the testing fluid. This experiment is carried out at 1 MHz frequency at 25°C [12].

A weak ultrasonic signals identification method is experimented using the optimal scale wavelet transform is proposed. The result is by using this technique, it much simpler and effective to process heavy noised ultrasonic signals, and is greatly time-saving comparing with other typical wavelet transform. Beside that, the central frequency of the optimal scale wavelet is equal to that of the ultrasonic pulse, and the frequency band of the ultrasonic pulse is within the support of the optimal scale wavelet. This research done by using an offshore pipeline specimen that is applied in which a series of man-made cracks are fabricated. Ultrasonic probe with 5 MHz central frequency and 6 mm diameter wafer is used and water is selected as couplant. The flaw echoes were recorded in the format of A-scan with a sample frequency of 100 MHz [13].

Another application of Ultrasonic Testing has been done purposely to demonstrate the potentiality of air-coupled transducers to set up a contact-less, single-sided technique for testing the moisture content and/or the micro-cracking of carbon-epoxy composite wound around a Titanium liner. This research done by orienting probes at opposite angles, θ and $-\theta$, defined according to the Snell–Descartes law to select one particular mode in a given frequency domain, which is imposed by the frequency range of the excitation and by the frequency bandwidth of the probes. Air-coupled system with frequency around 100–350 kHz used mainly because composites as the specimen [14].

A research for detecting flaws that are subjected to large dynamically stressed forgings in nuclear and conventional power stations constitute a high risk potential has been conducted, thus the spread of the sound beam depends upon the crystal size and the frequency of the probe. To cover the whole shaft cross-section, the sound beams must overlap. This is achieved by changing the angle of incidence from 0° to 70°. The resolution, for example, can be improved by increasing the test frequency or by the use of focusing or T/R probes. The flaw parameters (position, angle, geometry, size,

roughness) determine the probe parameters (frequency, crystal size, angle of incidence, T/R or focus technique) required for analysis, and the evaluation methods. The probes that been used in this research B2S-N: crystal diameter, 24 mm; frequency 2 MHz. However the specimen have not been discussed in this research [15].

A research comparing between radiography versus ultrasonic testing and from that, it shows that ultrasonic inspection can be 40% faster, 50% cheaper and considerably safer than radiography; if a specialist is in charge of the inspection and the equipment is correctly calibrated. Beside that, a statement has been said that ultrasonic inspection is necessary where the critical crack length is small (twice the plate thickness) where we consider lack of fusion and cracks equally. Otherwise, especially for thinner plates it is highly probable that radiography will reveal unacceptable cracks [16].

According to a research purposely to develop an automated ultrasonic inspection system for detecting sub-surface defects in aluminium die-casting parts where as material of the two sample parts have more or less the same combination of base Al, Si, Fe, Cu, Mn and Mg elements. In addition to the above elements less than one percentage of Ti, Cr, Ca and P are also present in the alloy. Ultrasonic immersion testing was carried out on the sample parts using different probes situated at different water path distances to obtain the best possible signal from the defect. In this research the equipment and probes he use were EPOCH III flaw detector and 20 MHz, purposely chosen to compensate the problem of small thickness of casting and surface roughness. In ultrasonic contact testing 5 MHz and 10 MHz frequency normal beam contact probes were used. The back wall echo (reflected ultrasound signal from the back surface of the casting) was not obtained in certain sections of the sample parts. In the case of angle beam contact probes, different angled wedges (30°, 45°, 60° and 70°) were used. Due to the rough surface, it was difficult to move the probe along the surface of the casting. The ultrasound contact testing experiments carried out on the test cases supported the view of other researchers that it was quite difficult to obtain satisfactory results with contact inspection. Hence, immersion testing was carried out on the sample castings [17].

From the research of the development of a new device to perform torsional ultrasonic fatigue testing on ferritic-pearlitic steel 38MnV5S with frequency of 20 kHz, thus the result of this research is it was shown that a loading train designed to vibrate axial mode can be source of power over another body which has been calculated to vibrate on torsion mode, then, if there is an existing ultrasonic machine working on tension-compression testing, it can be used to characterize metallic alloys on torsion cycling loading [18].

A new probes suggestion is made using piezocomposite to improve overall probe performance. 2 MHz angle beam probe that used is directly glued a piezoceramic as well as piezocomposite probe to a Perspex wedge. His result shows that the probe with piezoceramic generate an long pause which is unacceptable for most applications whereas the piezocomposite make a short pulse with an extra 8 dB in amplitude [19].

CHAPTER 3

METHODOLOGY

3.1 Introduction

The methodology will cover for the experimental process that will be done for this project. The step will be started with the experimental review and finished with analysis of the test sample. The overall methodology is shown in the flow chart below.

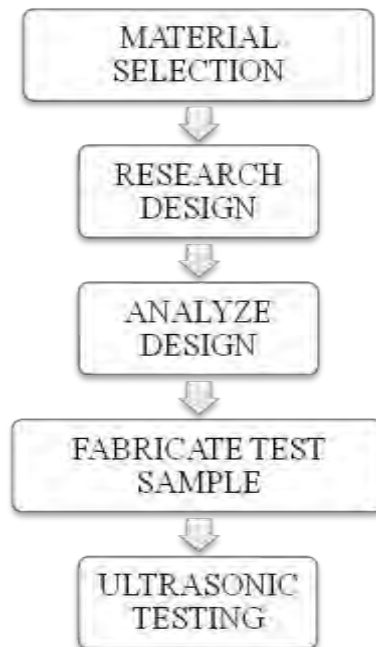


Figure 3.1: Overview of Research Methodology

3.2 Material

For this project, the test sample material is mild steel and aluminum. However, mild steel is the main focus for UT test sample.

Table 3.1: Material Properties for Mild Steel

Composition	Iron alloy with 0.3% carbon
Properties	Malleable and ductile
Density (kg/m ³)	7799.16 – 7900.08
Tensile strength (MPa)	410.03 – 1199.69
Young's modulus (GPa)	200.00 – 216.01
Material velocity (m/s)	5960

Table 3.1 above shows the material properties for mild steel. The advantages of mild steel are cheap, with high stiffness and easy to machine and weld. But, the disadvantage of this mild steel is their poor corrosion resistance.

Table 3.2 below shows the material properties for aluminum. Aluminum is known for its ability to resist to corrosion and its low density. It is ductile, and easily machined, cast, and extruded.

Table 3.2: Material Properties for Aluminum

Composition	Aluminum with alloying elements
Properties	Corrosion-resistant and easy to form
Density (kg/m ³)	2500.41 – 2899.26
Tensile strength (MPa)	58.00 – 550.00
Young's modulus (GPa)	68.00 – 81.98
Material velocity (m/s)	6400

3.3 Research Design

Figure 3.2 below shows the flow process for research design. For test sample virtual prototyping, Catia V5R16 software is used. Using an application of the same software known as CATIA PROCESS, to do the programming for this test sample. The physical prototyping is made using CNC Universal Milling Machines for 5-Axis which is available in the Advanced Manufacturing Center (AMC). This test sample focuses on different shape and thickness. Then, this test sample undergoes experiment using the Ultrasonic Testing. These experiment objectives are to investigate the effect of probe frequency and to investigate the effect of test sample material for probe frequency selection.

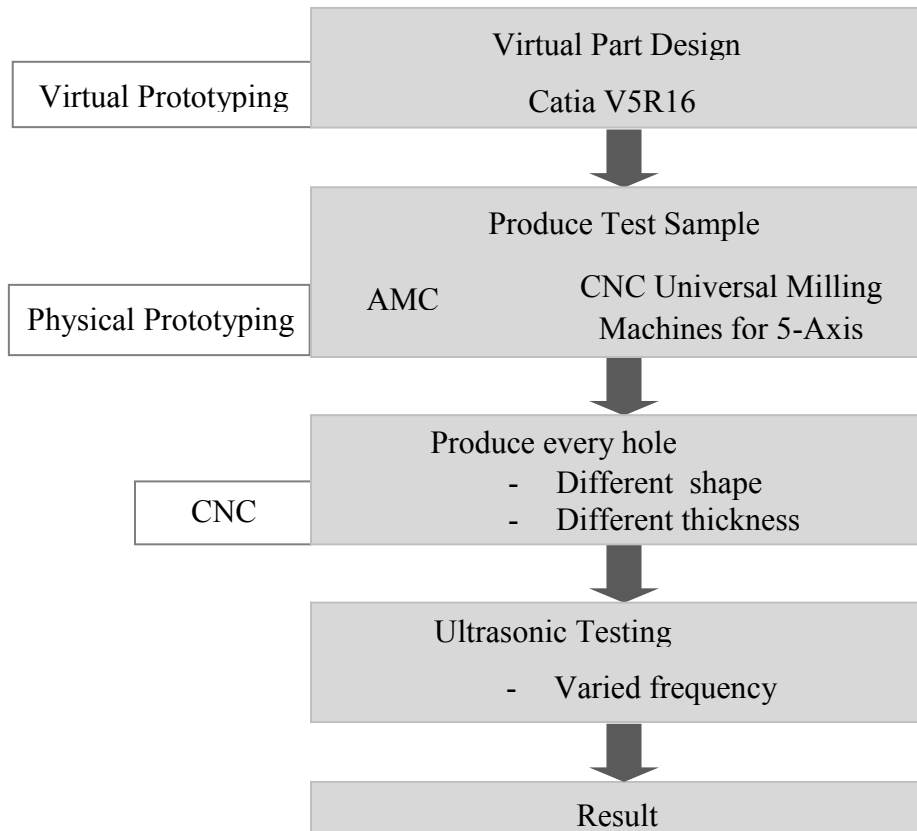


Figure 3.2: Flow Process for Research Design

3.4 Design Analysis

There are four proposed test sample from the beginning of project till the last submission which are accepted. The mainly focus of this design is to make artificial defects which are different in size, shape and thickness. The design of the previous design can be refer in Appendix 3A.

The material size for this test sample is 150x100x20. The virtual prototyping of the final design is made using Catia V5R16. This design vastly improves the previous design especially in term of arrangement and purpose of the artificial defect. The arrangement is important so that easy to use the UT. Fully design of this final test sample can be refer in Appendix 3B.

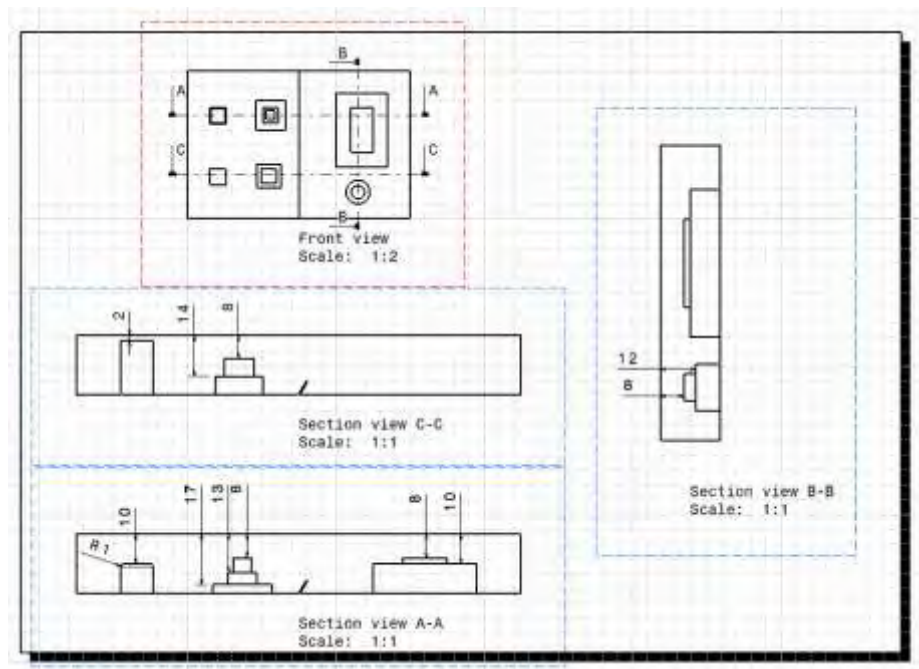


Figure 3.3: Final Test Sample Drafting and Cross Section

Figure 3.3 above shows the drafting and cross section of the final test sample design. There are 6 different cracks to act as artificial defects that usually occur in

industry. All of these cracks are varied to achieve different purpose. For the cross section of this 6 cracks, please refer to appendix 3C.

Four of these cracks are layered, which is purposely design to see the changes signal at the different thickness. Beside that, to see either the vertical lines effect the signal reading. Crack 2 is an example of layered crack which is shown in Figure 3.4 below.

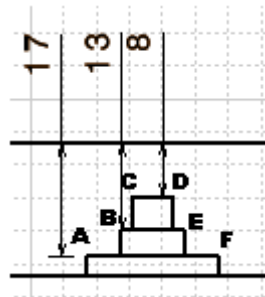


Figure 3.4: Layered Crack

Some of the crack has a very small gap between each layer and the minimum of the gap that are design in this test sample is 2 mm. The purpose of this small gap is to see either the size of this gap effecting the reading and result of the UT.

One of the crack is design with the depth of 18 mm. However, the UT capability to detect thickness is for minimum of 7 mm. So, this crack design is to show that the capability of Ultrasonic Testing measurement for thickness that less than 7 mm. This will give unclear signal where noise is near as a thickness.

Crack 4 designed to be rounded. Purpose of this design is to show the effect for different type of crack. From theory, the square shape will give clearer signal because of the flat wall while the rounded crack is not.

A crack with chamfer is design to see the effect of this additional flat angle to the result of UT. It is expected to see that when the probe reaches at the chamfer position, display system will show an unclear signal.

3.5 Fabrication of Test Sample



Figure 3.5: CNC 5-Axis Face Milling (DMG-DMU250) [22]

Figure 3.5 above shows the CNC 5-Axis Face Milling that is used to fabricate the test sample. This CNC machine is located at AMC. The information of this CNC 5-Axis Face Milling can be referred in Appendix 3D. 5-Axis means that this machine has two more axes in addition to three normal axis (XYZ) which allowing the horizontally mounted workpiece to be rotated. This CNC system highly automated using CAD/CAM programs. The programs produce a computer file that is interpreted to extract the commands needed to operate a particular machine, and then loaded into the CNC machines for production.

Before fabricating, the programming of machining process is done. For this test sample, the programming is done using CATIA PROCESS, an application of CATIA V5R16. Then, from this CATProcess file converted into H files. Both of this programming process is asserted in the Appendix 3E for CATProcess file and Appendix

3F for H file. After the coding from H file is save in the CNC 5-Axis Face Milling, the machining begun.

Both of aluminum and mild steel undergoes milling process. Figure 3.6 below shows how the milling machine process is done. The type of machining operation that done throughout this manufacturing is facing, pocketing, contouring and lastly surface finish. There are four tools that been used, counterbore, ball nose and end mill toll size $\text{Ø}8$ mm and $\text{Ø}2$ mm. Facing is done to machine the top face to provide the final thickness of 20.00 mm, as per drawing. All of the cracks are done using pocketing process. Contouring is done for filleted rectangular shape. Lastly, surface finish is a compulsory for finishing. The machining process can be referred in Appendix 3G.

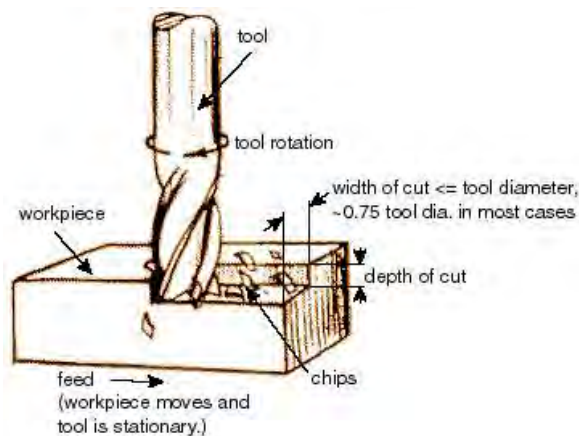


Figure 3.6: Milling Machining Process[23]

3.6 Ultrasonic Testing

This topic discuss the design of experiment, equipment and basic procedure to investigate the effect of probe frequency in Ultrasonic Testing experiment.

3.6.1 Equipments

There are five basic equipments during Ultrasonic Testing Experiment. Which are USD 30 ultrasonic flaw detector, 90° dual crystal probe with three different frequency (2 MHz, 4 MHz and 5 MHz), test sample (mild steel and aluminum), lubricant gel and IOW Calibration block. USD 30 ultrasonic flaw detector will give the result of A-Scan. 90° dual crystal probe used as the type of probe because in theoretically, dual crystal probe is better than single crystal because one for continually transmitting ultrasonic waves and one for receiving. Test sample already fabricated is made by mild steel and aluminum material. Lubricant gel is needed because solid to air interface creates 100% reflection, so the sound goes straight back into probe without transmitting into the metal. IOW Calibration steel block is important for calibrated for accurate thickness measurement

Figure 3.7 below shows the equipment that use throughout Ultrasonic Testing experiment. USD 30 ultrasonic flaw detector, 90° dual crystal probe, test sample and couplant.



Figure 3.7: Equipment for Ultrasonic Testing.



Figure 3.8: IOW Calibration Block

IOW Calibration Block that use during experiment is shown in Figure 3.8 above. This Calibration Block is made from steel. Calibration is necessary every time the probe is changed.

3.6.2 Procedure

The probe (2 MHz, 4 MHz, 5 MHz) is connected to the USD 30 and therefore an ultrasonic beam was produced. First, using IOW Calibration block to calibrate. Some lubricant gel is put on the surface of the block. The transducer is attached steadily and softly on the lubricated surface and is moved towards edge of defect and stop when significant echo is reached. The display system adjusted to A-scan display system. The initial pulse set between 80-100% Full Screen Height (FSH) using the Gain Control. Using pulse delay control, the initial transmission pulse is adjusted.

Figure 3.8 below shows reflected sound energy which is displayed versus time, and inspector can visualise a cross section of the specimen showing the depth of features that reflect sound. The picture of each reflected sound energy are taken and traced using transparent paper so that they can be overlap to make it easier for comparing each frequency.

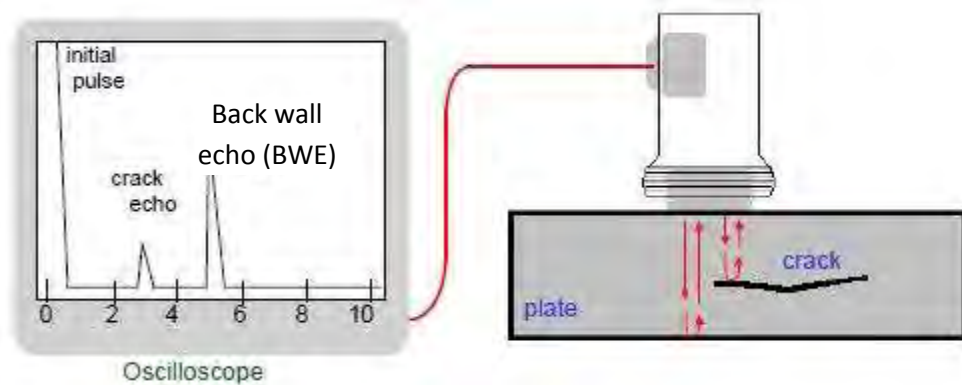


Figure 3.9: Reflected Sound Energy [24]

3.6.3 Parameter of Study

3.6.3.1 Objective: To investigate effect of probe frequency

Table 3.3: To Study Effect of Probe Frequency

Material	Frequency (MHz)	Parameter of Study
Mild Steel	2	Pulse-Delay
	4	Gain
	5	Sa

Table 3.3 above shows the parameter of study for effect of probe frequency. Mild steel is used as the test sample. Three different frequency is used which is classified into three class. Low (2 MHz), medium (4 MHz) and high (5 MHz). The result of the experiment is A-scan graph that shows time base in x-axis and amplifier gain in y-axis at the respective point. The important data that will be collected is pulse-delay, gain and Sa.

3.6.3.2 Objective: To investigate the effect of test sample material for probe frequency selection

Table 3.4: To Study the Effect of Test Sample Material for Probe Frequency Selection

Frequency (MHz)	Material	Material Velocity (Mm/s)	Parameter of Study
4	Mild Steel	5960	Pulse Delay
	Aluminum	6400	Gain Sa

Parameter of study for the effect of test sample material for probe frequency selection is shown in Table 3.4 above. There are two materials that used, which is aluminum and mild steel. The material velocity is ensured to change according to test sample material. The important data that will be collected is pulse-delay, gain and Sa.

CHAPTER 4

RESULT

4.1 Effect of Probe Frequency

An experiment for the effect of probe frequency has been conducted in the NDT Lab. Probe frequency that used in this experiment are 2 MHz (low), 4 MHz (medium) and 5 MHz (high). During this experiment, the parameters that will be control is the type of probe, material of test sample and atmosphere condition. The type of probe that use throughout this experiment is dual crystal probe. The test sample is made from mild steel. The material velocity is set as 5960 Mm/s. Through out this experiment, some steps are taken to avoid failure. The probe will be calibrated first using I.O.W steel block. The initial pulse will be always set between 80-100% Full Screen Height (FSH). FSH is the value of screen percentage. The probe will be moved towards edge of defect and stop when significant echo is reach. Then, the display system shows the result that discussed in this experiment for the effect of probe frequency, which is A-scan graph that shows time base in x-axis and amplifier gain in y-axis at the respective point. The defect echo feedback value will be search, and also the defect location will be detected.

The first result that will be show is backwall analysis. For 2 MHz probe, the result for backwall signals in A-Scan is as shown in Figure 4.1 below. The initial pulse is approximately 90% FSH. There are 3 peaks that can be seen in this 60 mm full scale. The first BWE show that the value for Sa is 20.00 mm. However from the graph, the

noise detected quite high and all of the peak is quite width. The amplitude for the first peak is 78% FSH. All of the general data is listed in Table 4.1.

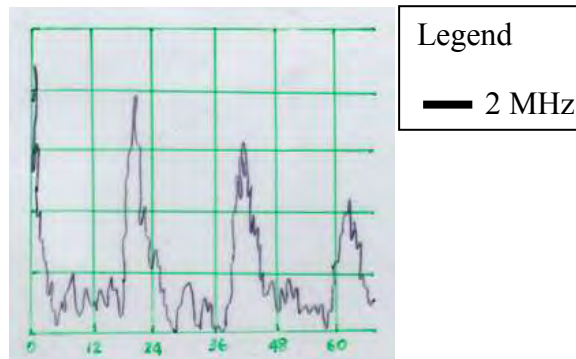


Figure 4.1: 2 MHz Result for Backwall

Figure 4.2 below shows the result for backwall signals in A-Scan for 4 MHz probe. The initial pulse is roughly 96% FSH. There are 3 peaks that can be seen in this 60 mm full scale. The first backwall echo show that the value for Sa is 20.00 mm. However from the graph, the noise detected is justifiable and all of the peak is sharper. The amplitude for the first peak is approximately 62% FSH. All of the general data is listed in Table 4.1.

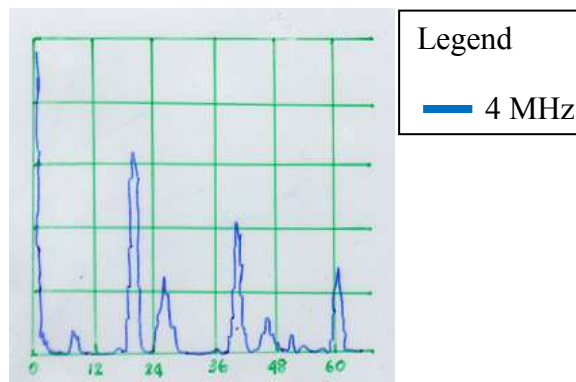


Figure 4.2: 4 MHz Result for Backwall

Figure 4.3 below shows the A-Scan result for backwall signals of 5 MHz probe frequency. The initial pulse is also approximately 90% FSH. There are 3 signals that can be seen in this 60 mm full scale. The time base for this probe of the first back wall echo

value is 20.00 mm. However from the graph, the noise is little and the entire peak is sharper. The amplitude for the first peak is around 41% FSH. All of the general data is listed in Table 4.1.

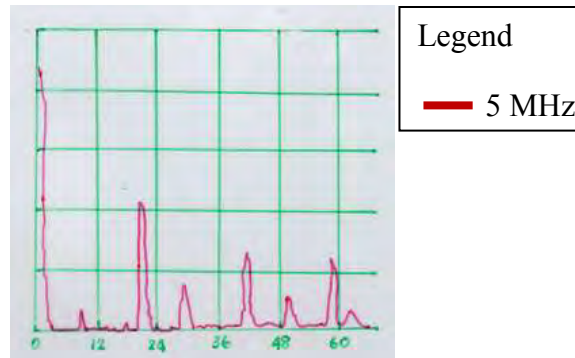


Figure 4.3: 5 MHz Result for Backwall

Table 4.1: Result of Backwall for Different Probe Frequency

Frequency (MHz)	2	4	5
Material	Mild Steel		
Gain (dB)	64.00	44.52	52.50
Pulse Delay (μ s)	14.00	16.13	13.25
Sa (mm)	20.00	20.00	20.00

Table 4.1 above shows the result of backwall analysis. From this table, the higher frequency, lower the gain and pulse delay. However, for 4 MHz probe, the pulse delay is higher than 2 MHz. All of the Sa value for backwall is 20.00 mm.

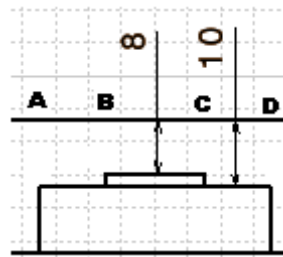


Figure 4.4: Crack 1 Cross Section

Figure 4.4 shows the cross section of Crack 1. Suppose when probe at the first layer from A to B and C to D, the value of Sa will be 10 mm. The value Sa when the probe move from B to C is 8 mm.

Figure 4.5 below shows the result for crack 1 signals the first layer of the crack, which is from position A to B for 2 MHz probe. The initial pulse is roughly 88% FSH. There are 6 peaks that can be seen in this 60 mm full scale. The first crack echo show that the value for Sa is 10.00 mm. However from the graph, the noise detected is high and most of the peak is width. The gain for the first peak is approximately 76% FSH. All of the general data is listed in Table 4.2.

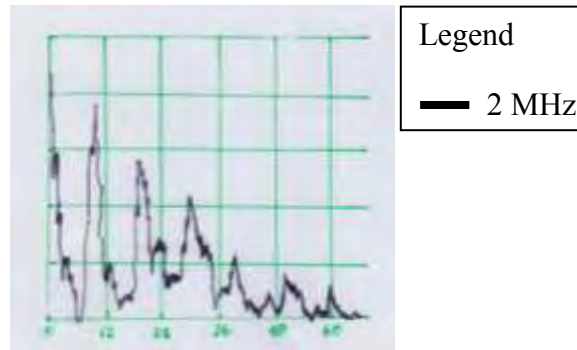


Figure 4.5: 2 MHz Result for Crack 1 at Position A to B

For 4 MHz probe, the result for back wall signals in A-Scan at the position from A to B is as shown in Figure 4.6 below. The initial pulse is approximately 90% FSH. There are 6 signals that can be seen in this 60 mm full scale. The first peak show that the value for Sa is 10.00 mm. However from the graph, the noise detected is justifiable and where not all peak is width. The amplitude for the first peak is 58% FSH. All of the general data is listed in Table 4.2.

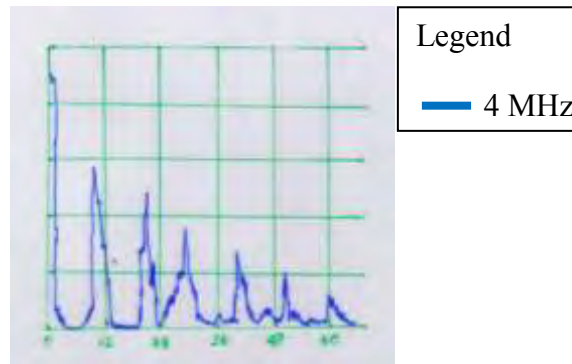


Figure 4.6: 4 MHz Result for Crack 1 at Position A to B

Figure 4.7 below shows the A-Scan result for back wall signals of 5 MHz probe frequency. The initial pulse is also approximately 90% FSH. There are 6 signals that can be seen in this 60 mm full scale. The time base for this probe of the first peak value is 10.00 mm. However from the graph, the noise is little and the entire peak is sharper. The gain for the first peak is around 56% FSH. All of the general data is listed in Table 4.2.

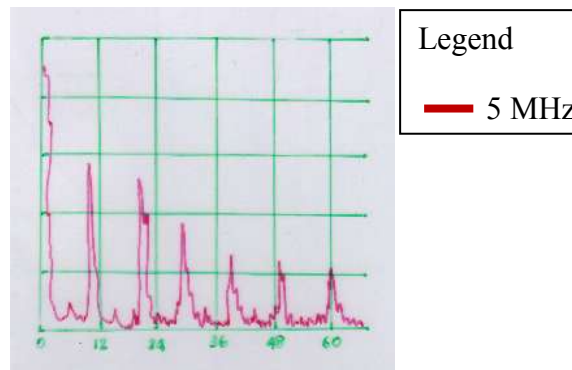


Figure 4.7: 5 MHz Result for Crack 1 at Position A to B

Table 4.2 shows the result of Crack 1 at Position A to B general data analysis. From this table, the higher frequency, lower the gain and pulse delay. All of the Sa value for Back wall is 10.00 mm.

Table 4.2: Result of Crack 1 at Position A to B for Different Probe Frequency

Frequency (MHz)	2	4	5
Material	Mild Steel		
Gain (dB)	60.50	55.00	46.50
Pulse Delay (μ s)	15.77	13.09	12.93
Sa (mm)	10.00	10.00	10.00

Result of Crack 1 at position B to C for 2 MHz is shown in Figure 4.8 below. The initial pulse is approximately 88% FSH. There are 8 peaks that can be seen in this 60 mm full scale. The first peak show that the value for Sa is 8.00 mm. However from the graph, the noise detected quite high and all of the peak is quite width. The gain for the first peak is 60% FSH. All of the general data is listed in Table 4.3.

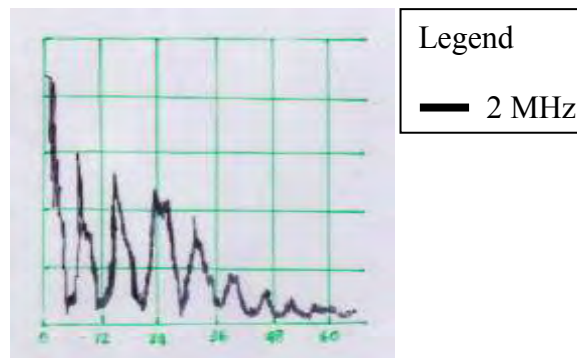


Figure 4.8: 2 MHz Result for Crack 1 at Position B to C

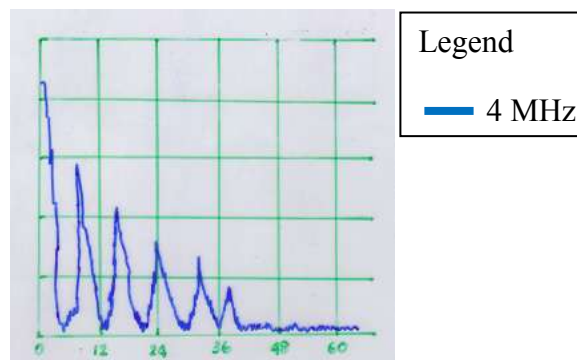


Figure 4.9: 4 MHz Result for Crack 1 at Position B to C

For 4 MHz probe, the result for back wall signals in A-Scan at the position from B to C is as shown in Figure 4.6 above. The initial pulse is approximately 86% FSH.

There are 5 signals that can be seen in this 60 mm full scale. The first peak show that the value for Sa is 8.00 mm. However from the graph, the noise detected is acceptable and where not all peak is width. The gain for the first peak is 58% FSH. All of the general data is listed in Table 4.3.

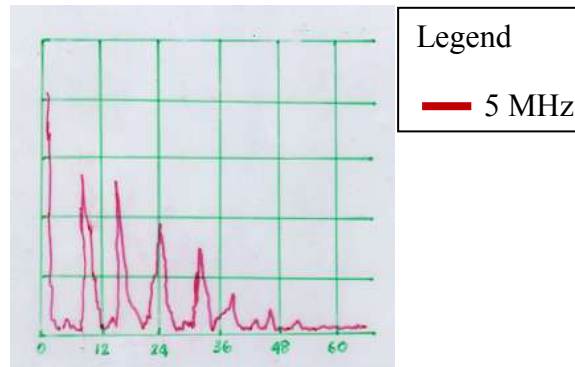


Figure 4.10: 5 MHz Result for Crack 1 at Position B to C

Figure 4.3 above shows the A-Scan result for back wall signals of 5 MHz probe frequency. The initial pulse is also approximately 82% FSH. There are 6 signals that can be seen in this 60 mm full scale. The time base for this probe of the first peak value is 8.00 mm. However from the graph, the noise is little and the entire peak is sharper. The gain for the first peak is around 54% FSH. All of the general data is listed in Table 4.3 below.

Table 4.3: Result of Crack 1 at Position B to C for Different Probe Frequency

Frequency (MHz)	2	4	5
Material	Mild Steel		
Gain (dB)	59.00	55.00	43.00
Pulse Delay (μ s)	15.77	13.18	12.58
Sa (mm)	8.00	8.00	8.00

Table 4.3 above shows the result of Crack 1 at Position B to C general data analysis. From this table, the higher frequency, lower the gain and pulse delay. All of the Sa value for first back wall echo is 8.00 mm.

When the probe moved from position C to D, the result for 2 MHz A-Scan is shown in Figure 4.11 below. The initial pulse is approximately 92% FSH. There are 6 peaks that can be seen in this 60 mm full scale. The first peak show that the value for Sa is 10.00 mm. However from the graph, the noise detected quite high and all of the peak is width. The gain for the first peak is 62% FSH. All of the general data is listed in Table 4.4.

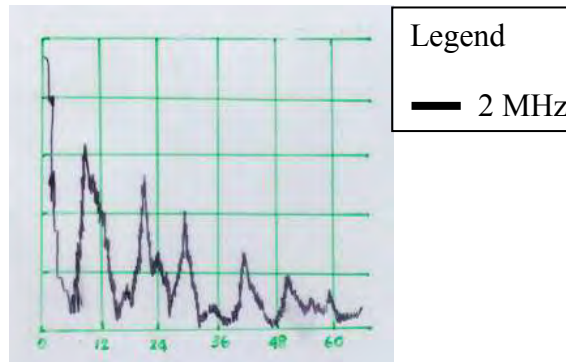


Figure 4.11: 2 MHz Result for Crack 1 at Position C to D

Figure 4.12 below shows the result of A-Scan for 4 MHz probe at Crack 1 at position C to D. The initial pulse is roughly 92% FSH. There are 6 peaks that can be seen in this 60 mm full scale. The first peak show that the value for Sa is 10.00 mm. However from the graph, the noise detected is permissible and all of the peak is sharper. The gain for the first peak is approximately 62% FSH. All of the general data is listed in Table 4.4.

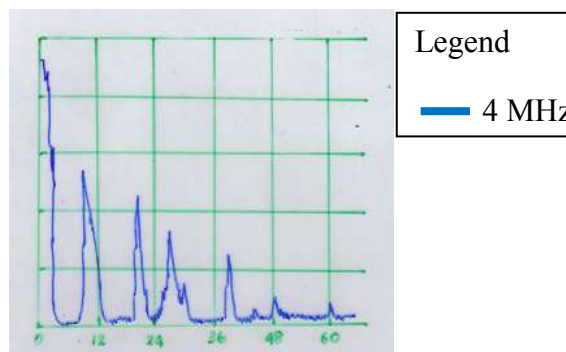


Figure 4.12: 4 MHz Result for Crack 1 at Position C to D

A-Scan result for crack 1 at position C to D for 5 MHz probe frequency is shown in Figure 4.13 below. The initial pulse is also approximately 82% FSH. However, there are only 4 peaks that can be seen in this 60 mm full scale. The time base for this probe of the first peak value is 8.00 mm. However from the graph, the noise is little and the entire peak is sharper. The gain for the first peak is around 54% FSH. All of the general data is listed in Table 4.4 below.

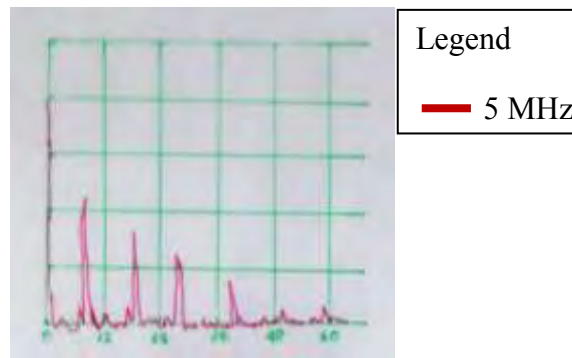


Figure 4.13: 5 MHz Result for Crack 1 at Position C to D

Table 4.4: Result of Crack 1 at Position C to D for Different Probe Frequency

Frequency (MHz)	2	4	5
Material	Mild Steel		
Gain (dB)	60.50	56.00	45.03
Pulse Delay (μ s)	15.33	13.20	12.88
Sa (mm)	10.00	10.00	10.00

Table 4.4 above shows the result of Crack 1 at Position C to D general data analysis. From this table, the higher frequency, lower the gain and pulse delay. All of the Sa value for first crack echo is 10.00 mm.

The graph analysis and general data of result for crack 2, 4 and 5 are same as for Crack 1. However, the only changes in this graph analysis is the crack echo value and the noise. All of this A-Scan graph is asserted in the Appendix 4A.

However, there are some differences of A-Scan result for Crack 2 at position B to C when using 5 MHz frequency. This result is shown in Figure 4.14 below.

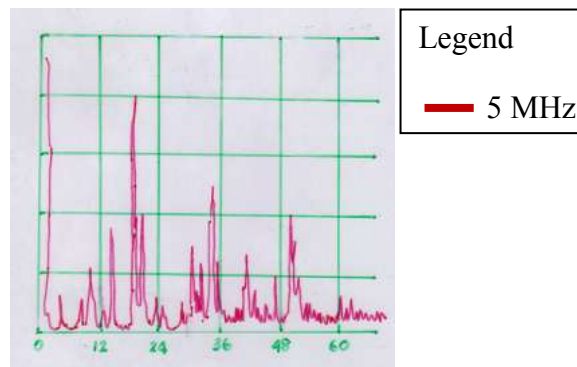


Figure 4.14: 5 MHz Result for Crack 2 at Position B to C

A-Scan result for crack 2 at position B to C for 5 MHz probe frequency is shown in Figure 4.14 above. The initial pulse is approximately 90% FSH. The signal is quite messy. The time base for this probe of the first peak value is supposed to be 13 mm, but the value of Sa that achieved is 17 mm. All of the peaks are sharp but the noise is regrettably large that the crack echo is harder to read.

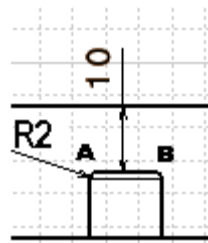


Figure 4.15: Cross Section of Crack 3

Figure 4.15 above shows the cross section of Crack 3 which has an R2 chamfer. Suppose when the probe is at the first layer from A to B, the value of Sa will be 10 mm.

For 2 MHz probe, the result for Crack 3 signals in A-Scan is as shown in Figure 4.16 below. The initial pulse is approximately 96% FSH. There are 3 peaks that can be seen in this 60 mm full scale. The first peak show that the value for Sa is 10.00 mm. However from the graph, the noise detected quite high and all of the peak is width. The gain for the first peak is 48% FSH, with an amplitude that lower than the second peak. All of the general data is listed in Table 4.5.

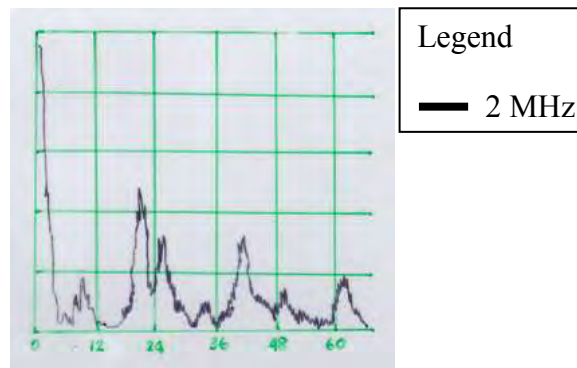


Figure 4.16: 2 MHz Result for Crack 3

For 4 MHz probe, the result for Crack 3 signals in A-Scan at the position from A to B is as shown in Figure 4.17 below. The initial pulse is approximately 90% FSH. There are 5 signals that can be seen in this 60 mm full scale. The crack echo show that the value for Sa is 10.00 mm. However from the graph, the noise detected is acceptable and where not all peak is width. The gain for the first peak is 58% FSH. However, the first BWE echo is lower than second peak. All of the general data is listed in Table 4.5.

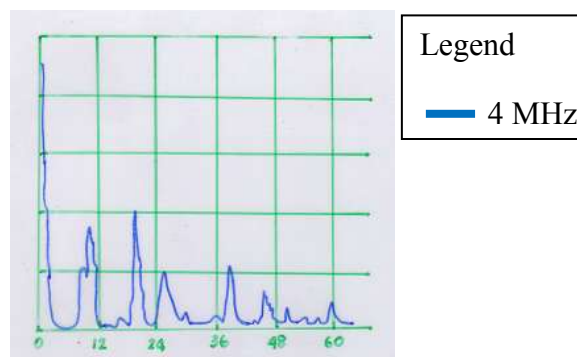


Figure 4.17: 4 MHz Result for Crack 3

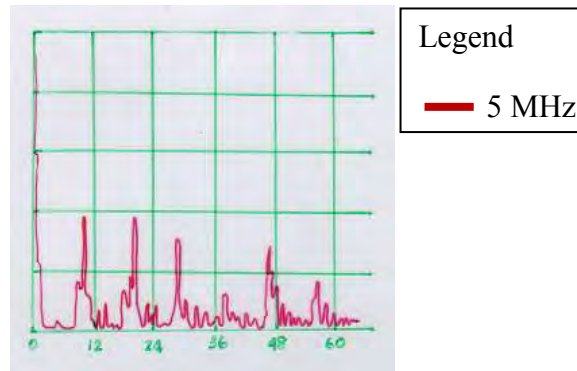


Figure 4.18: 5 MHz Result for Crack 3

A-Scan result for crack 3 at position A to B for 5 MHz probe frequency is shown in Figure 4.18 above. The initial pulse is also around 38% FSH. There are only 5 peaks that can be seen in this 60 mm full scale. The time base for this probe of the first crack echo value is 10.00 mm. From the graph, the noise is little and the entire peak is sharper. However, the amplitude of the peak is cluttered. The gain for the first peak is around 54% FSH. All of the general data is listed in Table 4.5 below.

Table 4.5: Result of Crack 3 at Position A to B for Different Probe Frequency

Frequency (MHz)	2	4	5
Material	Mild Steel		
Gain (dB)	64.00	55.00	46.5
Pulse Delay (μ s)	16.44	16.13	16.04
Sa (mm)	10.00	10.00	10.00

Table 4.5 above shows the result of Crack 3 at Position A to B general data analysis. From this table, the higher frequency, lower the gain and pulse delay. All of the Sa value for first BWE is 10.00 mm.

Figure 4.19 shows the cross section of Crack 6. With the size of 10 mmx10 mm, this crack depth is 18 mm.

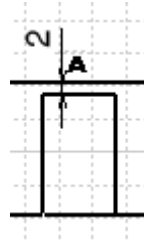


Figure 4.19: Cross Section for Crack 6

When the probe moved to Crack 6, the result for 2 MHz A-Scan is shown in Figure 4.20 below. The FSH value is 82%. The graph shows no crack echo due to the noises. All of the general data is listed in Table 4.6.

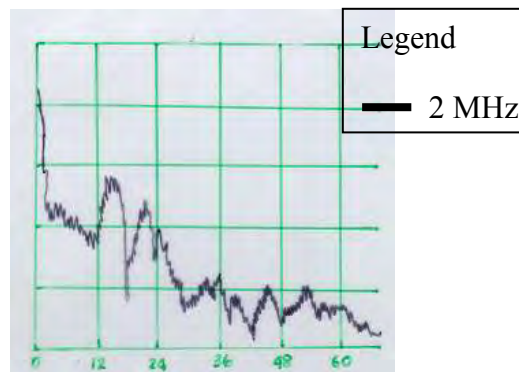


Figure 4.20: 2 MHz Result for Crack 6

Figure 4.21 below shows the result for Crack 6 using 4 MHz probe frequency. The noise is too high that no Sa reading can be figure . All of the general data is listed in Table 4.6.

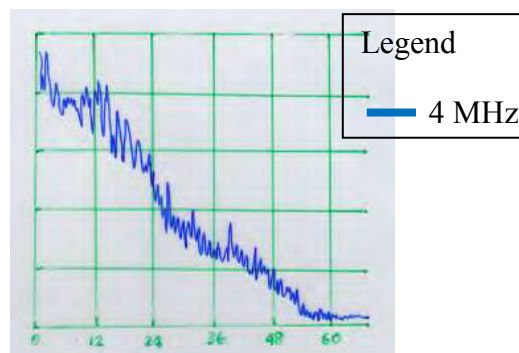


Figure 4.21: 4 MHz Result for Crack 6

The result of 5 MHz for Crack 6 is shown in Figure 4.22 below. The graph is smoother but the Sa value still not shown. All of the general data is listed in Table 4.6 below.

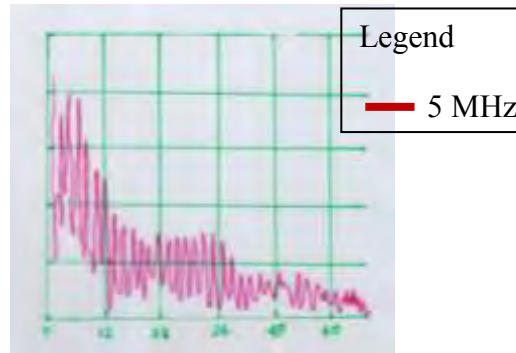


Figure 4.22: 5 MHz Result for Crack 6

Table 4.6 below shows the result of Crack 1 at Position B to C general data analysis. From this table, the higher frequency, lower the gain and pulse delay. There is no Sa value detected.

Table 4.6: Result of Crack 1 at Position C to D for Different Probe Frequency

Frequency (MHz)	2	4	5
Material	Mild Steel		
Gain (dB)	40.00	46.5	47.00
Pulse Delay (μ s)	16.55	16.17	13.00
Sa (mm)	-	-	-

4.2 The Effect of Test Sample Material for Probe Frequency Selection

To investigate the effect of test sample material for probe frequency selection, an experiment has been conducted in the NDT Lab. To meet the objective of the experiment, the probe frequency that used in this experiment is 4 MHz only. This is because to see either the 4 MHz is more suitable for mild steel or aluminum. Beside probe frequency, the parameters that will be control is the type of probe and atmosphere condition. The type of probe that use throughout this experiment is still dual crystal probe. However, the test sample is made from mild steel and aluminum. The material velocity is set to be 6400 Mm/s. Throughout this experiment, some steps are taken to avoid failure. The probe will be calibrated first using I.O.W steel block. The initial pulse will be always set between 80-100% FSH. The probe will be moved towards edge of defect and stop when significant echo is reach. Then, the display system shows the result that discussed in this experiment for the effect of probe frequency, which is A-scan graph that shows time base in x-axis and amplifier gain in y-axis at the respective point. The defect echo feedback value will be search, and also the defect location will be detected.

The result backwall for mild steel test sample already been shown in Figure 4.2. While result of the aluminum test sample is shown in Figure 4.23 below. The initial pulse is roughly 98% FSH. There are 3 signals that can be seen in this 60 mm full scale. The first back wall echo show that the value for Sa is 20.00 mm. However from the graph, the noise detected is justifiable and all of the peak is sharp. However the gain for first peak is short, around 42% FSH. All of the general data is listed in Table 4.7.

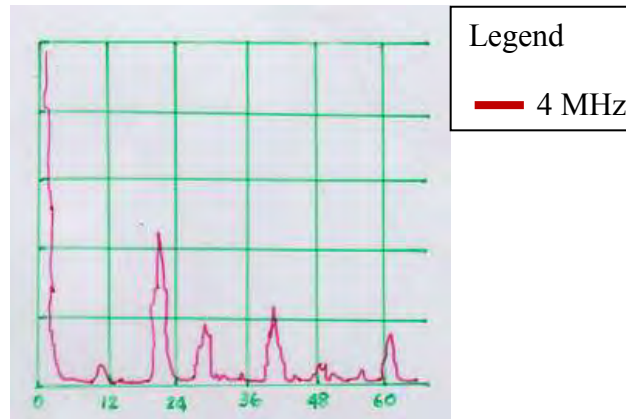


Figure 4.23: 4 MHz Result for Aluminum Backwall

Table 4.7 below shows the result of backwall analysis for mild steel and aluminum material when using the same probe frequency, which is 4 MHz. It shows that aluminum uses lower gain and pulse delay from mild steel.

Table 4.7: Result of Backwall for Mild Steel and Aluminum

Frequency (MHz)	4	
Material	Mild Steel	Aluminum
Gain (dB)	44.52	33.50
Pulse Delay (μ s)	16.13	15.40
Sa (mm)	20.00	20.00

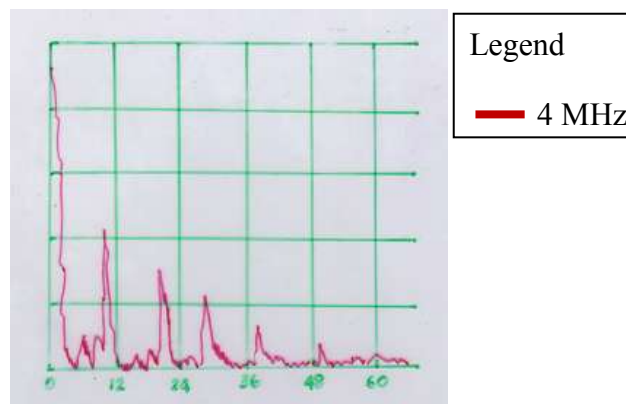


Figure 4.24: 4 MHz Result for Aluminum for Crack 1 at Position A to B

Crack 1 result for mild steel test sample is in Figure 4.6. While result of the aluminum test sample is shown in Figure 4.24 above. The initial pulse is roughly 90% FSH. There are 5 peaks that can be seen in this 60 mm full scale. The first crack echo show that the value for Sa is 10.00 mm. However from the graph, the noise detected is justifiable and all of the peak is sharp. However the gain for first peak is short, around 42% FSH. All of the general data is listed in Table 4.8.

Table 4.8 below shows the result of crack 1 analysis for mild steel and aluminum material when using the same probe frequency, which is 4 MHz. It is shows that aluminum use lower gain and pulse delay from mild steel.

Table 4.8: Result of Crack 1 at Position A to B for Mild Steel and Aluminum

Frequency (MHz)	4	
Material	Mild Steel	Aluminum
Gain (dB)	55.00	31.50
Pulse Delay (μ s)	13.09	12.22
Sa (mm)	10.00	10.00

All of A-Scan result characteristic and general data for each crack and point is nearly identical with an exception of Crack 3 and 6. All experiment result in term of A-Scan graph is asserted in Appendix 4.

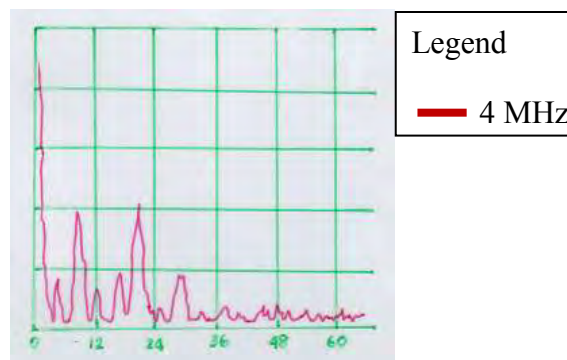


Figure 4.25: 4 MHz A-Scan Result for Aluminum at Crack 3

For Crack 3, the result of Crack 3 signals in A-Scan is as shown in Figure 4.25 above. The initial pulse is around 90% FSH. There are 3 peaks that can be seen in this 60 mm full scale. The first crack echo shows that the value for Sa is 10.00 mm. However from the graph, there are some insignificant signal, probably noise and the peak is sharp. The gain for the first peak is 49% FSH, with an amplitude that slightly lower than the second peak. All of the general data is listed in Table 4.9.

Table 4.9: Result of Crack 1 at Position A to B for Mild Steel and Aluminum

Frequency (MHz)	4	
Material	Mild Steel	Aluminum
Gain (dB)	55.00	32.00
Pulse Delay (μ s)	16.13	11.68
Sa (mm)	10.00	10.00

The result of aluminum material for Crack 6 is shown in Figure 4.26 below. The graph is smoother but the Sa value still not shown. All of the general data is listed in Table 4.10 below.

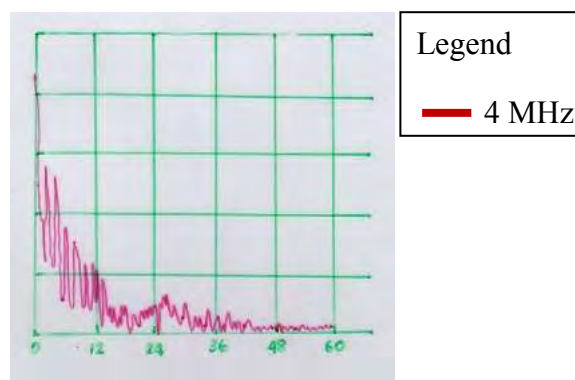


Figure 4.26: 4 MHz A-Scan Result for Aluminum at Crack 6

Table 4.10 shows the result of crack 6 analysis for mild steel and aluminum material when using the same probe frequency, which is 4 MHz. It is shows that aluminum use lower gain and pulse delay from mild steel.

Table 4.10: Result of Crack 6 for Mild Steel and Aluminum

Frequency (MHz)	4	
Material	Mild Steel	Aluminum
Gain (dB)	46.5	36.00
Pulse Delay (μ s)	16.17	11.00
Sa (mm)	-	-

4.3 Crack Location

The test sample is drawn into grid of 10 mmx10 mm. The probe then will be moved along the grid line and each time the signals change, the spot will be marked. After that, the probe is slowly moved in each grid until the shape of crack defined.

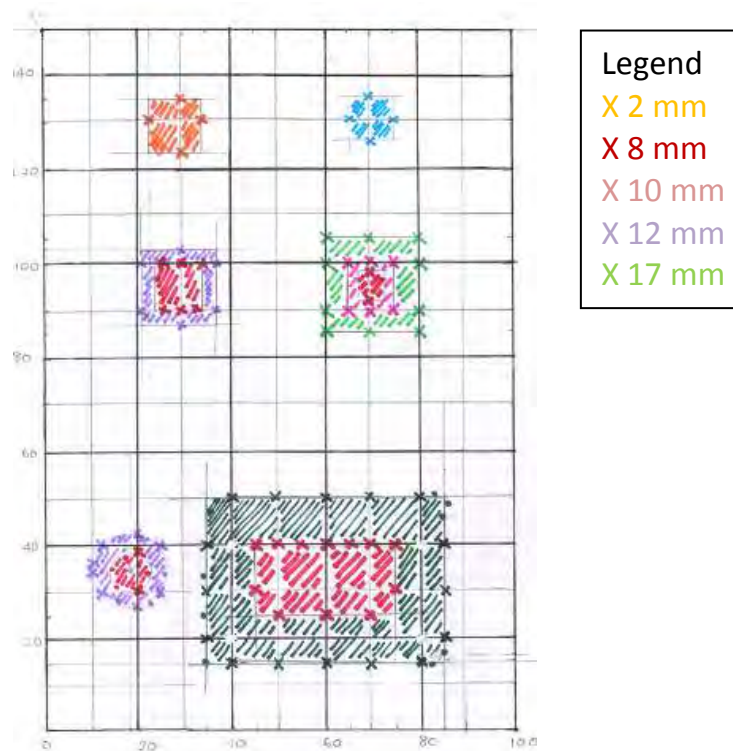


Figure 4.27: Crack Location and Shape

CHAPTER 5

DISCUSSION

5.1 Introduction

From the experiment, the probe frequency that will be used are 2 MHz, 4MHz and 5 MHz. This is because the probes are available from NDT Lab in Universiti Teknikal Malaysia Melaka. This probe frequencies are categorized in three classes; which are high (5 MHz), medium (4 MHz) and lastly low (2 MHz). It is important to study the effect of the probe frequency from low to high signal. In this chapter, the result of two experiment will be discussed in details. The first experiment is to investigate the effect of probe frequency and the second experiment is to the effect of test sample material for probe frequency selection

5.2 Effect of Probe Frequency

From backwall general data, the graph for gain and pulse delay are made in Figure 5.1 below. From this graph, the changes that happen from low to high frequency for back wall result is analyzed. In theoretically, the higher frequency, the lower value of gain and pulse delay. Base on the result of 4 MHz for backwall in Figure 4.2, the initial

pulse are 96% FSH. So, it can be assumed that due to the initial pulse being too high, the result of gain and back pulse of 4 MHz is affected.

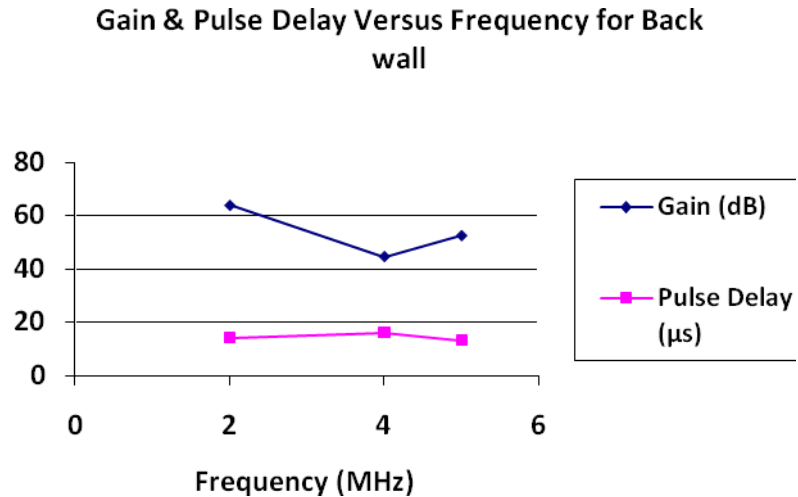


Figure 5.1: Graph Gain & Pulse Delay Versus Frequency for Backwall

To compare the effect of probe frequency, the A-Scan result is trace using transparent paper. This overlapping A-Scan is to compare the effect of frequency between 2 MHz and 5 MHz. Black line indicates A-Scan of 2 MHz while red line is A-scan for 5 MHz.

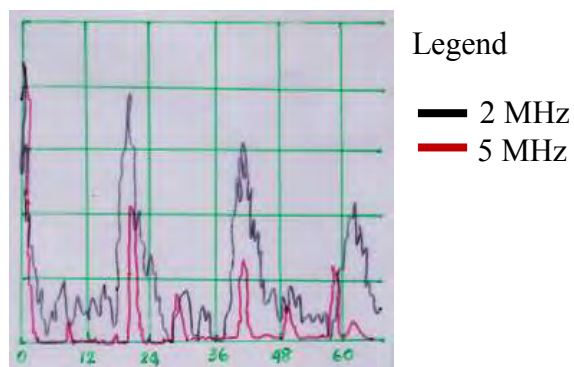


Figure 5.2: A-Scan Backwall for 2 MHz and 5 MHz

From Figure 5.2 above, it is observed that both of 2 MHz and 5 MHz have the same thickness of 20.00. From the observation, all of 2 MHz peaks is wider than 5 MHz

so, the peak for 5 MHz is sharper than 2 MHz. However, the amplitude for 5 MHz is lower than 2 MHz. The noise is high for 2 MHz compare to 5 MHz.

All of the graph for every crack and position is similar to the Figure 5.2 in terms of the width, amplitude and noise differences. All of this A-Scan result for 2 MHz and 5 MHz can be referred to in Appendix 5A.

The width of the peak is effected by beam that produce by transducer. 5 MHz has a sharper peak than 2 MHz because higher frequency produce a narrow, well defined beam.

The higher the test frequency, the greater attenuation and the less penetration that can be achieved. So, the amplitude of the 5 MHz is supposed to be lower than 2 MHz because of the less penetration that achieved by it.

Noise occurred when scattered energy (sound to reflect in random direction due to grain boundaries in material) reach to receiver. Scatter decrease if frequency decreased. However a higher frequency will result in higher attenuation. Even though this attenuation limit the range of higher frequency, but the noise at the same higher frequency is also less. Beam angle also helps to lower background noise interference by limiting the probe's noise sensitivity to area defined by the angle of the sensor. The result that shows 2 MHz have more noise than 5 MHz in Figure 5.2 is proven.

From Crack 1 at Position A to B general data, the graph for gain and pulse delay are made in Figure 5.1 below. From this graph, the changes that happen from low to high frequency for back wall result is analyzed. In theoretically, the higher frequency, the lower value of gain and pulse delay. So, the graph belows confirmed the theoretical statement.

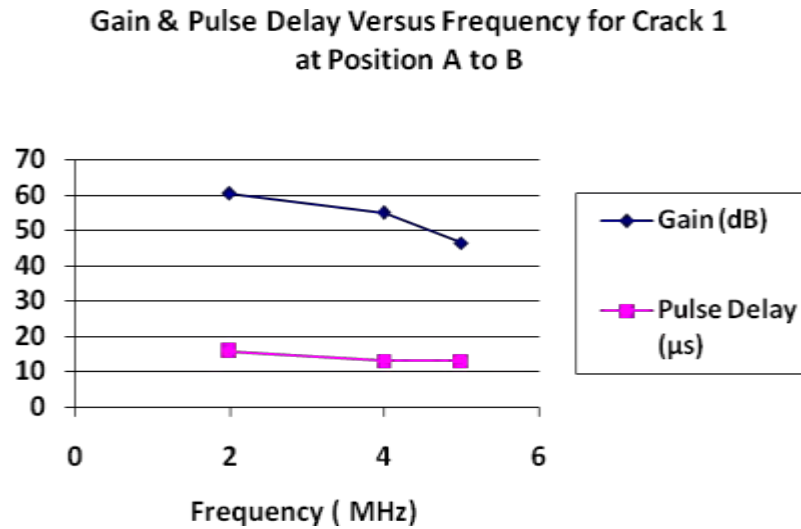


Figure 5.3: Graph Gain & Pulse Delay Versus Frequency for Crack 1 at Position A to B.

5.3 Effect of Test Sample Material for Probe Frequency Selection

From Back wall general data, the chart for gain and pulse delay are made in Figure 5.4 below. This chart shows that aluminum has lower gain and pulse delay than mild steel.

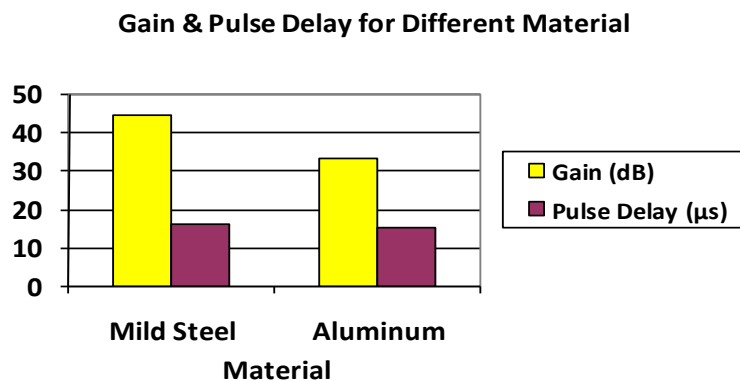


Figure 5.4: Chart Gain & Pulse Delay Versus Type of Material

To compare the effect material for probe frequency selection, the A-Scan result is trace using transparent paper. This overlapping A-Scan is to compare result between mild steel and aluminum using the same frequency, 4 MHz. Blue line indicates A-Scan for mild steel while red line is A-scan for aluminum.

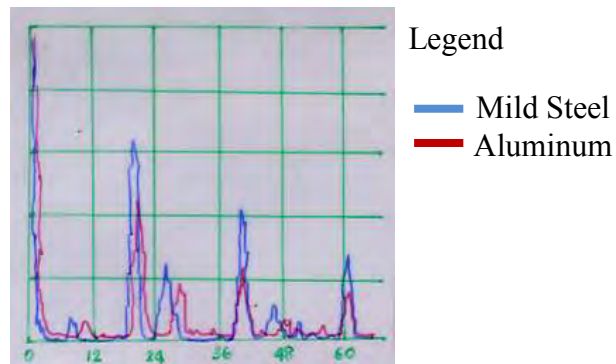


Figure 5.5: A-Scan Backwall for Mild Steel and Aluminum

Figure 5.5 above shows the A-Scan backwall for mild steel and aluminum. However, the signals for backwall in Figure 5.5 above show little differences. It can be seen that most of mild steel BWE is wider than aluminum so, the peak for aluminum is sharper than mild steel. The amplitude for aluminum is lower than mild steel.

Both of these observations, chart in Figure 5.4 and graph in Figure 5.5 proved that material factors effecting probe frequency selection. The ultrasonic sound beam propagation is influenced by grain type, size and distribution of material. Large or directionally oriented grains tend to scatter and otherwise absorb ultrasonic energy to a greater extent than fine, randomly oriented grains. Beside that, another factor for this experiment is the surface condition for test sample. Example surface condition will be considered during this experiment is corrosion, surface roughness

Mild steel grain size is considered to be larger than aluminum and mild steel also known for its poor corrosion resistance. So, theoretically, aluminum will have sharper and narrow signals, less noise and high amplitude from mild steel. Mild steel also will have less peak from aluminum. However, the result in Figure 5.5 shows that aluminum has higher amplitude, this probably due to some error during the experiment. Most of

result for experiment the effect of test sample material for probe selection shows the exact outcome as theoretically.

Figure 5.6 shows the A-Scan result for mild steel and aluminum at Crack 1 when positioned from A to B. Clearly, mild steel peak is wider than aluminum so, the peak for aluminum is sharper than mild steel. The amplitude for aluminum is higher than mild steel. This is example of the correct result suppose to get in theoretically.

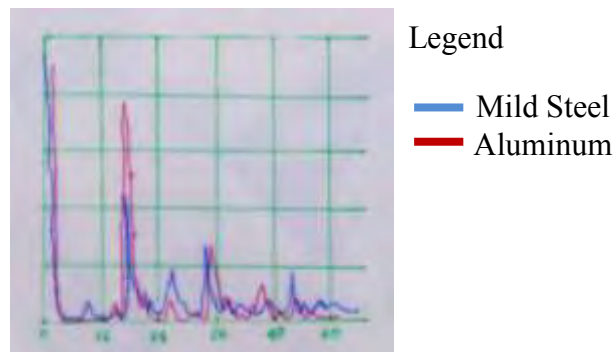


Figure 5.6: A-Scan Crack 1 at Position A to B for Mild Steel and Aluminum

5.4 Design Factor

Crack shape and size affecting the reading of Ultrasonic Testing. After the experiment is done using mild steel test sample, the suitable probe frequency will be chosen specifically to each defect. This is the conclusion of probe frequency selection for type of defect.

Crack 2 has a very small gap at position B to C and D to E, which is only 2 mm. The purpose of this small gap is to see either the size of this gap effecting the reading and result of the UT. During the experiment, to achieve the result of A-scan that acceptable is hard due to its location, in the centre of three layered crack and gap for 2 mm only.

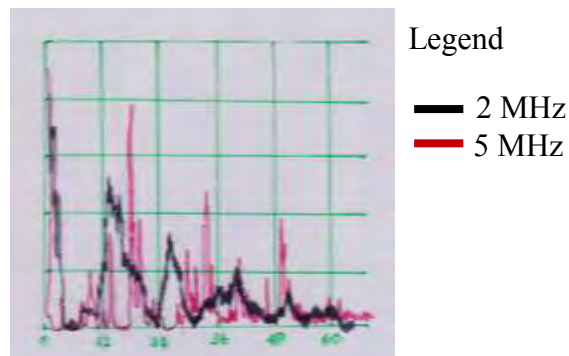


Figure 5.7: A-Scan Crack 2 at Position B to C for 2 MHz and 5 MHz

The Figure 5.7 before shows the result of A-Scan Crack at Position B to C for 2 MHz and 5 MHz. Although the graph for 2 MHz has more noises, the right value S_a which is 13 mm still can be detected. In contrast, the 5 MHz did detect this crack, but the S_a that considered in this experiment is 17 mm. This experiment has proved that, low frequency is more suitable to detect small size defect. When frequency increased, attenuation will be increased too. Then, this lead to less penetration can be achieved. So, smaller size defects harder to achieve.

A crack with chamfer is design to see the effect of this additional flat angle to the result of UT. It is expected to see that when the probe reaches at the chamfer position, display system will show an unclear signal.

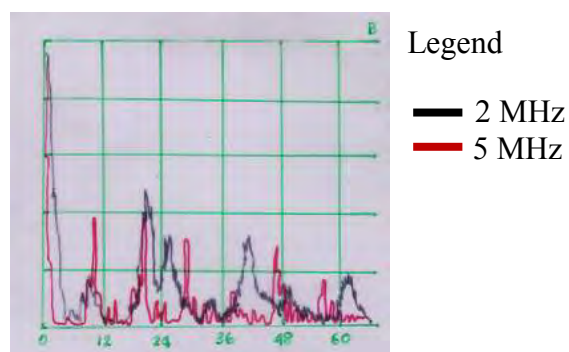


Figure 5.8: A-Scan at Crack 3 for 2 MHz and 5 MHz

Figure 5.8 shows the result of A-Scan at Crack 3. From the graph, 2 MHz did not achieved the Sa value 10 mm but 20 mm. However, the noise is still acceptable even for 2 MHz. This probably due to the radius of chamfer is small. It is suggested that in this situation, higher frequency should be use. This is due to the attenuation that reduce the noise.

Crack 4 designed to be rounded. Purpose of this design is to show the effect for different type of crack. From theory, the square shape will give clearer signal because of the flat wall while the rounded crack is not. This graph can be refer in Appendix 4A.

One of the crack is design with the depth of 18mm. Supposedly, UT can detect thickness with minimum of 7 mm. So, this crack design is to show that the capability of Ultrasonic Testing measurement for thickness that less than 7 mm. All of results showed unclear signal where noise is near as a thickness. However, the result for A-Scan at Crack 6 for 2 MHz and 5 MHz still be compared in Figure 5.10 below.

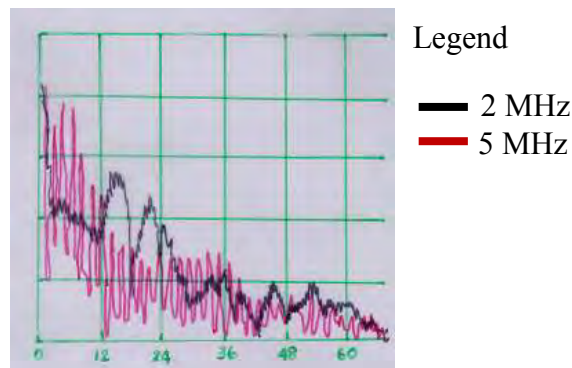


Figure 5.9: A-Scan at Crack 6 for 2 MHz and 5 MHz

From the Figure 5.8 above, even though both of the probe frequency shows unclear signal, but the 5 MHz graph shows smoother signal then. The first BWE is read 2 mm, however the Sa value is considered to be 4 mm because the first peak has shorter amplitude than second peak. This confirmed the theory that higher frequency, smallest thickness can be read.

5.5 Error Analysis

Through out Ultrasonic Testing experiment, some of errors has been detected that may influence the result of experiment. One of them is the value of FSH. Supposedly, when frequency increased, the value of gain control and pulse delay will be lower. This FSH value affecting the value of gain control and pulse delay for back wall analysis. This can be avoid by maintaining result of FSH between 80-90%.

Some of the result shows that the first crack echo is shorter than second echo. This shown especially in the effect of test sample material for probe frequency experiment. This is probably can be avoid if calibration is made. However, calibration block for aluminum is not available in the NDT lab.

Third error will be more than one signal which is having almost the same amplitude shown. This is because, the probe is situated in the crack interchange. To avoid this, the probe should be moved more to get the more appropriate signal.

The result that gains in this experiment is A-scan graph. For comparison, this data is traced in the transparent paper. However, the traced graph are not precisely as graph shown in the display screen (oscilloscope). To avoid this, it is suggested to use software from UT manufacturer to obtain more accurate graph.

Table 5.1 below shows the error analysis for effect of probe frequency experiment using mild steel material. The value of relative error is calculated by:

$$\left\| \frac{\text{Experiment value} - \text{Theoretical Value}}{\text{Theoretical Value}} \right\| \times 100\%$$

Example for relative calculation error:

For Backwall; 4 MHz frequency

$$= \left| \frac{20.20 - 20}{20.00} \right| \times 100\%$$

$$= 1\%$$

Table 5.1: Relative Error for Effect of Probe Frequency Experiment

Crack No.	Position	Frequency (MHz)	Sa Value (mm)	Theoretical Value (mm)	Relative Error (%)
Backwall	-	2	20.40	20.00	2.00
		4	20.20		1.00
		5	19.90		0.50
1	A to B	2	10.00	10.00	0.00
		4	10.00		0.00
		5	10.10		1.00
	B to C	2	8.01	8.00	0.13
		4	8.02		0.25
		5	8.00		0.00
	C to D	2	10.00	10.00	0.00
		4	10.03		3.00
		5	10.01		1.00
2	A to B	2	17.00	17.00	0.00
		4	17.00		0.00
		5	17.02		0.12

Crack No.	Position	Frequency (MHz)	Sa Value (mm)	Theoretical Value (mm)	Relative Error (%)
2	B to C	2	12.98	13.00	0.15
		4	13.06		0.46
		5	17.00		30.0
	C to D	2	8.04	8.00	0.50
		4	8.00		0.00
		5	8.00		0.00
	D to E	2	13.00	13.00	0.00
		4	13.09		0.70
		5	13.07		0.53
	E to F	2	17.00	17.00	0.00
		4	17.00		0.00
		5	17.00		0.00
3	A to B	2	19.96	10.00	99.60
		4	10.02		0.20
		5	10.00		0.00
4	A to B	2	12.00	12.00	0.00
		4	12.00		0.00
		5	12.03		0.25
	B to C	2	8.00	8.00	0.00
		4	20.00		150.00
		5	9.82		22.75

Crack No.	Position	Frequency (MHz)	Sa Value (mm)	Theoretical Value (mm)	Relative Error (%)
4	C to D	2	12.00	12.00	0.00
		4	12.00		0.00
		5	11.85		0.17
5	A to B	2	19.89	14.00	42.00
		4	20.00		42.86
		5	14.00		0.00
	B to C	2	19.71	8.00	146.38
		4	20.00		150.00
		5	8.00		0.00
	C to D	2	21.00	14.00	50.00
		4	14.19		1.36
		5	14.00		0.00
6	A	2	15.00	2.00	650.00
		4	1.50		22.00
		5	4.00		100.00

From the table above, there is some of relative error that is too high that can be considered fail. One of this failure is at Crack 3 when probe is at position B to C. This failure proved that low frequency has more flaw sensitivity.

While at Crack 4 at position B to C, this failure probably caused by the round design and small diameter. Beside that, it could be that the probe fails to focus in the depth of that location. Probe should be moved more slowly and steadily until the appropriate value is detected. The same error also detected at Crack 5, both using mild steel and aluminum.

Lastly, Crack 6 is purposely design to fail especially when using low frequency probe. However, for 5 MHz, the value shown that the second peak is higher than the first peak. To avoid this, it is suggested to adjust probe delay.

Table 5.2 below shows the error analysis for effect of test sample material for probe frequency selection using probe frequency 4 MHz. Calculation for relative error is same as previous experiment.

Table 5.2: Relative Error Calculation for Effect of Test Sample Material for Probe Frequency Selection Experiment

Crack No.	Position	Material	Sa Value (mm)	Theoretical Value (mm)	Relative Error (%)
Backwall	-	Mild Steel	20.20	20.00	1.00
		Aluminum	20.00		0.00
1	A to B	Mild Steel	10.00	10.00	0.00
		Aluminum	10.00		0.00
	B to C	Mild Steel	8.02	8.00	0.25
		Aluminum	8.00		0.00
	C to D	Mild Steel	10.03	10.00	3.00
		Aluminum	9.89		1.10
2	A to B	Mild Steel	17.00	17.00	0.00
		Aluminum	17.00		0.00
	B to C	Mild Steel	13.06	13.00	0.46
		Aluminum	13.00		0.00
	C to D	Mild Steel	8.00	8.00	0.00
		Aluminum	7.90		1.25

Crack No.	Position	Material	Sa Value (mm)	Theoretical Value (mm)	Relative Error (%)
2	D to E	Mild Steel	13.09	13.00	0.70
		Aluminum	13.02		0.15
	E to F	Mild Steel	17.00	17.00	0.00
		Aluminum	17.04		0.24
3	A to B	Mild Steel	10.02	10.00	0.20
		Aluminum	9.70		3.09
4	A to B	Mild Steel	12.00	12.00	0.00
		Aluminum	20.00		66.00
	B to C	Mild Steel	20.00	8.00	150.00
		Aluminum	8.20		2.50
	C to D	Mild Steel	12.00	12.00	0.00
		Aluminum	12.00		0.00
5	A to B	Mild Steel	20.00	14.00	42.86
		Aluminum	20.02		43.00
	B to C	Mild Steel	20.00	8.00	150.00
		Aluminum	20.20		152.5
	C to D	Mild Steel	14.19	14.00	1.36
		Aluminum	14.01		0.07
6	A	Mild Steel	1.50	2.00	22.00
		Aluminum	2.00		0.00

The cause of relative error calculated for both of this experiment probably effected by design factor or error during experimental which already discussed earlier.

Table 5.3 and 5.4 below shows the thickness analysis of both mild steel and aluminum test sample. UT function in this experiment is to detect thickness, so the depth of the cracks is measured using ruler and vernier caliper first. Then, this depth value is deducted with material thickness to gain the thickness.

Table 5.3: Thickness Analysis of Mild Steel

Crack No.	Position	Thickness Analysis		
		Ruler (mm)	Vernier Calliper (mm)	Theoretical Value (mm)
Backwall	-	20.0	20.0	20.0
1	A to B	10.0	10.0	10.0
	B to C	8.0	8.3	8.0
	C to D	10.0	10.0	10.0
2	A to B	17.0	17.2	17.0
	B to C	13.0	13.3	13.0
	C to D	-	8.0	8.0
	D to E	13.0	13.2	13.0
	E to F	17.0	17.2	17.0
3	A to B	11.0	10.15	10.0
4	A to B	12.0	12.0	12.0
	B to C	8.0	8.1	8.0
	C to D	12.0	12.0	12.0
5	A to B	14.0	14.0	14.0
	B to C	8.0	8.0	8.0

Crack No.	Position	Thickness Analysis		
		Ruler (mm)	Vernier Calliper (mm)	Theoretical Value (mm)
5	C to D	14.0	14.3	14.0
6	A	2.0	2.1	2.0

Table 5.4: Aluminum Thickness Analysis

Crack No.	Position	Thickness Analysis		
		Ruler (mm)	Vernier Calliper (mm)	Theoretical Value (mm)
Backwall	-	20.0	20.0	20.0
1	A to B	10.0	10.1	10.0
	B to C	8.0	8.1	8.0
	C to D	10.0	10.0	10.0
2	A to B	17.0	17.0	17.0
	B to C	13.0	13.3	13.0
	C to D	-	8.0	8.0
	D to E	13.0	13.0	13.0
	E to F	17.0	16.9	17.0
3	A to B	11.0	10.1	10.0
4	A to B	12.0	12.0	12.0
	B to C	8.0	8.0	8.0
	C to D	12.0	12.0	12.0

Crack No.	Position	Thickness Analysis		
		Ruler (mm)	Vernier Calliper (mm)	Theoretical Value (mm)
5	A to B	14.0	14.1	14.0
	B to C	8.0	8.3	8.0
	C to D	14.0	14.0	14.0
6	A	2.0	2.0	2.0

The theoretical value for this experiment is the value of designed test sample. Data for Crack 2 at position C to D is unavailable using ruler because the limited size of crack is 9mm. Vernier calliper shown differently that both ruler and theoretical value. This is because vernier caliper has more decimal than normal ruler while during fabrication, machine tolerances has effected the theoretical value.

CHAPTER 6

CONCLUSION AND RECOMMENDATION

6.1 Conclusion

Ultrasonic Testing is a part of Non-destructive Testing to detect thickness and defects. Using software Catia V5R16, the virtual prototyping and programming for machining is done. The sample have been fabricated using CNC Universal Milling Machines for 5-Axis. Test sample has 6 crack that represent artificial defect in industrial and the purpose of each crack discussed in the methodology. Probe frequency is one of parameters that affecting the result of Ultrasonic Testing. Result of Ultrasonic Testing is A-Scan graph that shows time base in x-axis and amplifier gain in y-axis at the respective point. High frequency shows lower amplitude, lower noise and sharper peak while low frequency shows high amplitude, high noise and wider peak. From the experiment, it can be conclude that low frequency has less attenuation, more penetration achieved, and high flaw sensitivity. So lower the frequency, rougher surface can be detected, smaller size defect and greater depth. However, low frequency probe also is more suitable for grainy material to overcome the grain noise. While, higher the frequency, higher the attenuation, narrow beam and less penetration achieved. So, high probe frequency is suitable detect smaller thickness, thin material and suitable in noisy environment. The objective of PSM2 successfully achieve.

6.2 Recommendation

It is recommended to get the higher differences of probe frequency. Probably with 10 MHz probe frequency so that the result to be compared is far difference. Before experiment, calibration is important to ensure the probe well function. However, the calibration block that exist in NDT Lab is for mild steel only. Then it is recommended that calibration block for aluminum for this experiment. To obtain more accurate data, it is suggested to use software from UT manufacturer. Lastly the FSH value should be standardized in between 80-90% so that the value of gain and pulse delay is more appropriate.

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APPENDIX 1A
GANTT CHART

Table 1: PSM1 Gantt Chart

No.	Task	Week															
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16
1	Select topic, proposal	■	■														
2	Literature review		■	■	■	■	■	■	■	■	■	■					
3	Material Selection		■	■													
4	Select machine		■	■													
5	Designing test sample				■	■	■	■									
6.	Edit Draft PSM 1										■	■					
7.	Full Progress Report												■				
8.	Submit technical report													■			
9.	Preparing for oral presentation														■	■	
10.	Oral presentation																■

Table 2: PSM2 Gantt Chart

No.	Task	Week																			
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
1	Redesign test sample	■	■	■	■																
2	Programming					■	■	■													
3	Fabricate test sample							■	■	■	■										
4	Experiment and obtain result										■	■	■	■	■						
5	Analysis characteristic defect												■	■	■	■					
6	PSM 2 report	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■				
7	Submit technical report																■	■			
8	Preparing for oral presentation																■	■	■	■	■
9	Oral presentation																			■	■
10	Amendment of report																				■
11	Handbound																				■

Appendix 3A

Test Sample Design

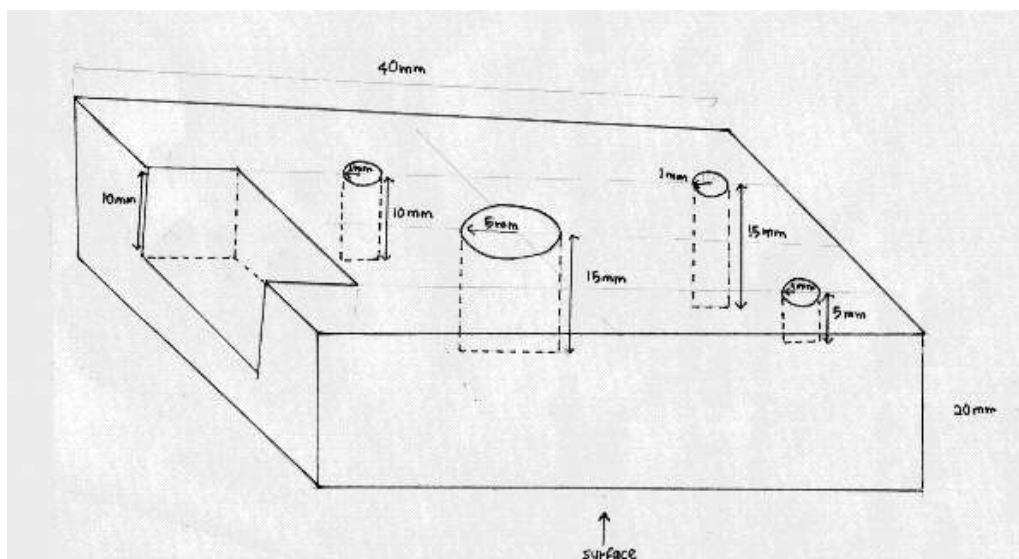


Figure 3A(a): First sketch of test sample

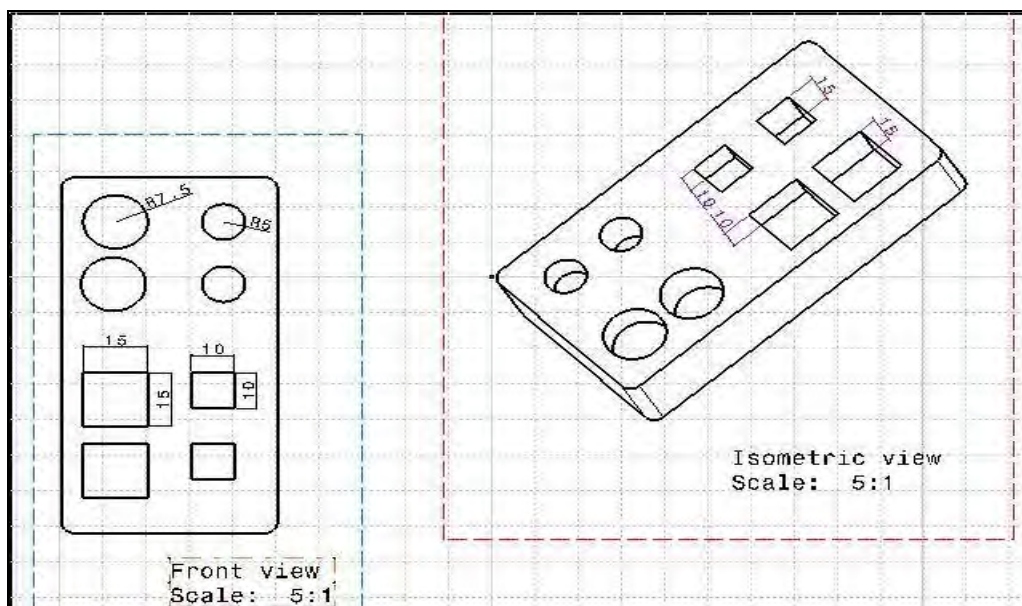


Figure 3A(b): Second Design of Test sample

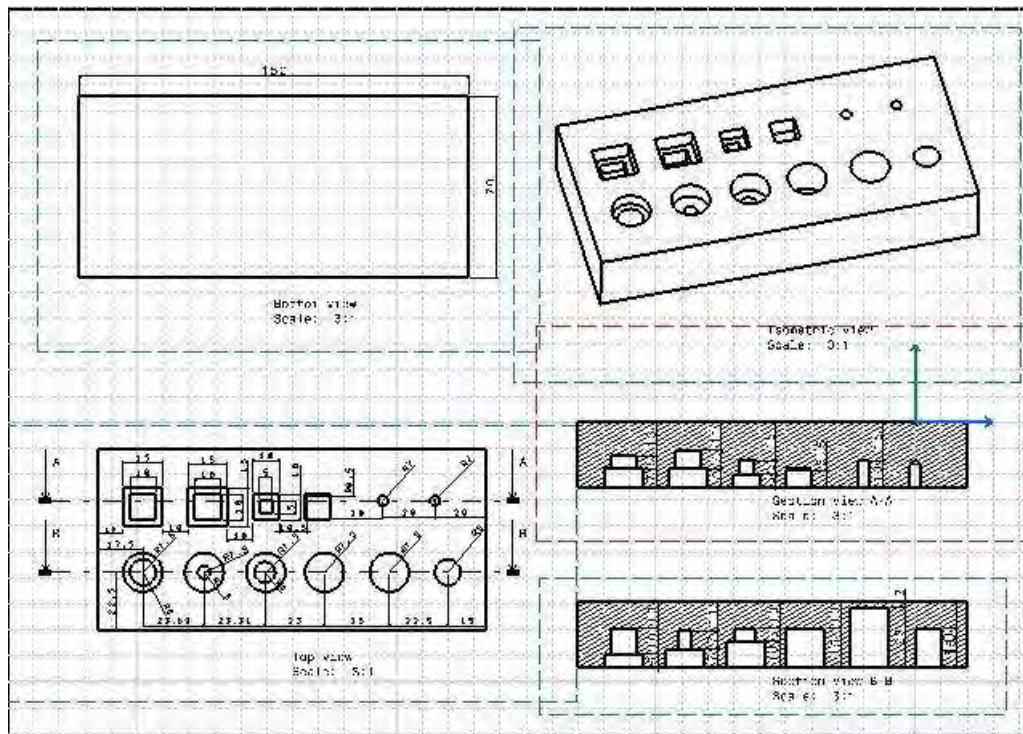


Figure 3A(c): Third Design of Test sample

Appendix 3B

Final Test Sample Design

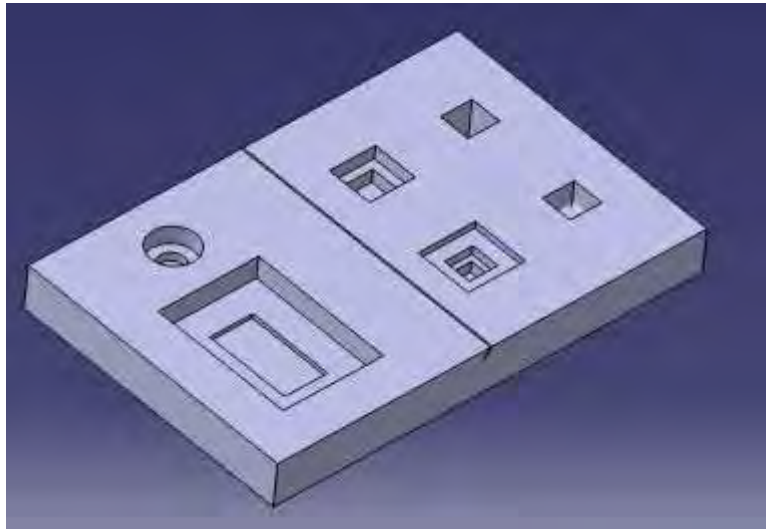


Figure 3B(a): Isometric View of Final Test Sample

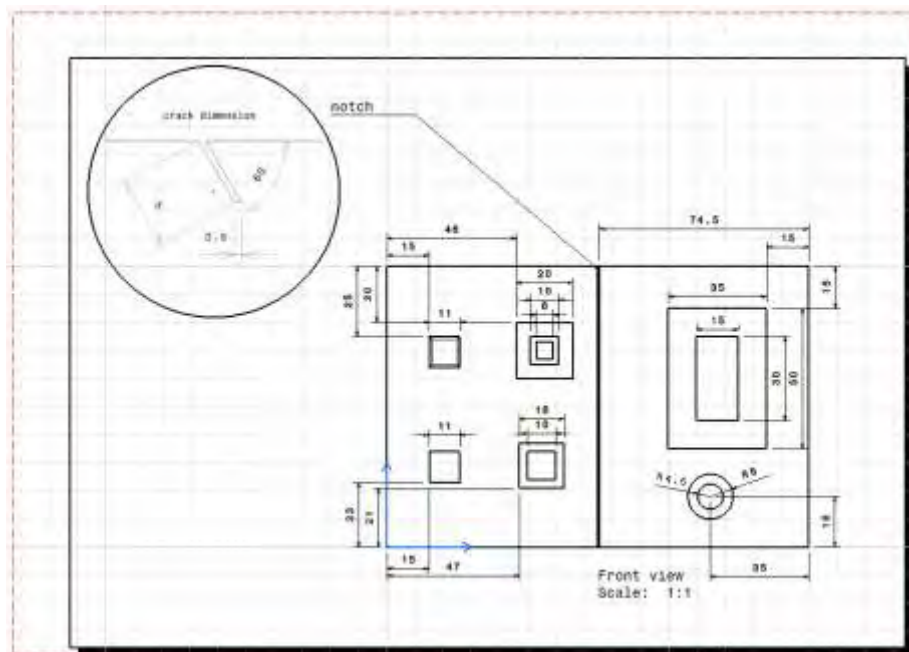
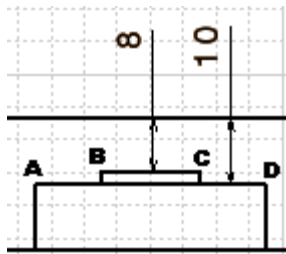
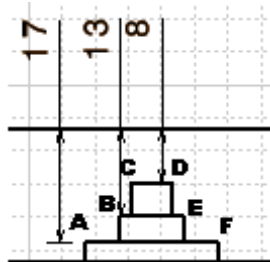
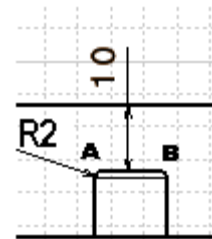
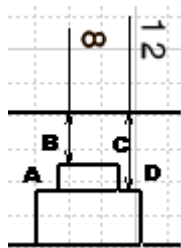
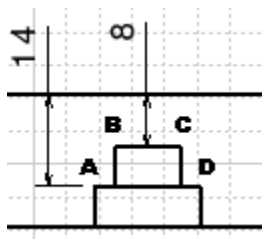
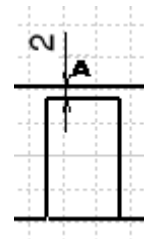


Figure 3B(b): Top View of Final Test Sample

APPENDIX 3C

Crack Cross Section

Figure 3C(a): Cross Section of
Crack 1Figure 3C(b): Cross Section of
Crack 2Figure 3C(c): Cross Section of
Crack 3Figure 3C(d): Cross Section of
Crack 4Figure 3C(e): Cross Section of
Crack 5Figure 3C(f): Cross Section of
Crack 6

APPENDIX 3D

The CNC 5-Axis Face Milling (DMG-DMU250) technical specification[22]

X- / Y- / Z-axis	in	70.9 / 78.7 / 43.3
Main drive (40 / 100% DC)	hp	59.0 / 42.9
Torque (40 / 100% DC)	ft/lbs	208.3 / 135.2
Speed range up to	rpm	10,000*
Rapid traverse X / Y / Z / Feed	ipm	2,362.2 / 1,574.8 / 1,574.8
Tool fitting		HSK-A100
Magazine pockets		60 (120 / 180)**
Table size (NC-rotary table)	in	ø 72.8
Table rpm. in turning operation	rpm	200
DMG ControlPanel with 15" TFT-screen and 3D-software		

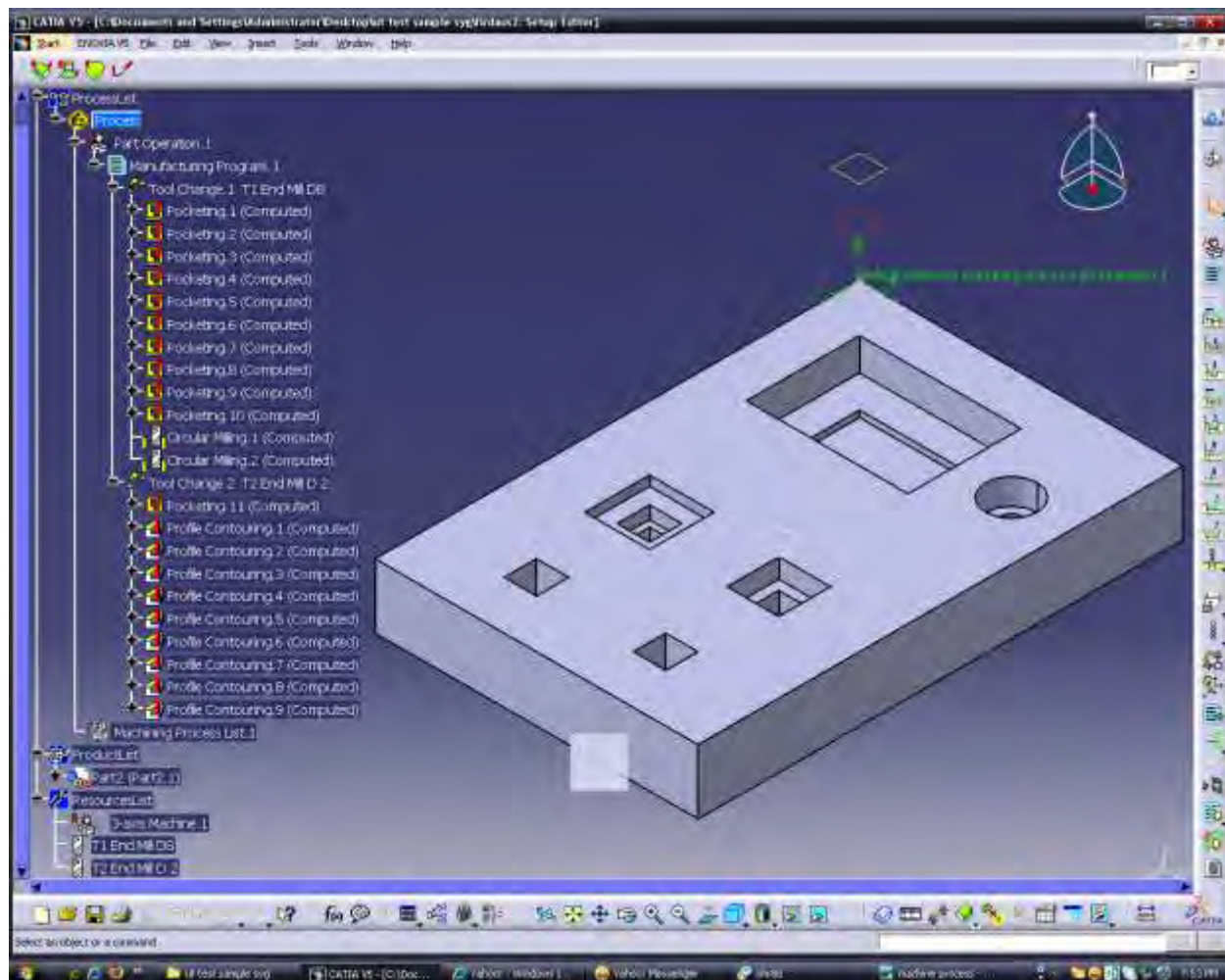
Table 3D: DMG-DMU250 Technical Specification [22]

Two technologies are combine in a single machine with these Milling Centres. As a result, both 5-sided and/or 5-axis milling and turning processes can be carried out with just one setup of the workpiece, accommodating weights up to 7 tons. This is a complete solution that not only saves costs and time, but also achieving results that are more flexible and far more accurate.

The combination of milling and turning is achieved by using the new “turning” NC rotary table as direct drive table with 51 hp. The rotational speeds of up to 200 rpm, for the table, a torque of 5 162.2 ft/lbs, and a holding torque of 6 195.5 ft/lbs allow this highly-productive unit to achieve a range of milling/turning applications that have never been attained before. In addition, these machines are fully-functional milling machines that are in no way inferior to machines designed exclusively for milling.

APPENDIX 3E

TEST SAMPLE CATprocess FILE



0 BEGIN PGM stud MM 94 L Y+37.3
 1 BLK FORM 0.1 Z X+0 Y+0 Z- 95 L X+87.7
 20 96 L Y+22.7
 2 BLK FORM 0.2 X+150 Y+100 97 L X+102.3
 Z=0 98 L Y+37.3
 3 M127 ; DREHACHSEN 99 L X+93.175
 WEGOPTIMIERT AUS 100 L Z+15. FQ4
 4 M129 ; TCPM OFF 101 L Y+32.3 FMAX
 5 ; * RUECKSETZEN 102 L Z-.8 FQ3
 ARBEITSEBENE * 103 L X+92.7
 6 LBL 1 104 L Y+27.7
 7 CYCL DEF 7.0 DATUM 105 L X+97.3
 SHIFT 106 L Y+32.3
 8 CYCL DEF 7.1 X+0 107 L X+93.175
 9 CYCL DEF 7.2 Y+0 108 L Y+33.55
 10 CYCL DEF 7.3 Z+0 109 L Y+34.8
 11 PLANE RESET STAY 110 L X+90.2
 12 LBL 0 111 L Y+25.2
 13 112 L X+99.8
 14 L B+0 C+0 R0 FMAX 113 L Y+34.8
 15 TOOL CALL 6 Z S10000 114 L X+93.175
 16 CALL LBL 1 115 L Y+36.05
 17 ; Bmin: 0 116 L Y+37.3
 18 ; Bmax: 0 117 L X+87.7
 19 FN 0: Q2 +=25000 118 L Y+22.7
 20 FN 0: Q3 +=300 119 L X+102.3
 21 FN 0: Q4 +=1000 120 L Y+37.3
 22 L M126 ; DREHACHSEN 121 L X+93.175
 WEGOPTIMIERT EIN 122 L Z+15. FQ4
 23 123 L Y+32.3 FMAX
 24 124 L Z-1. FQ3
 25 L X+0.0 Y+0.0 Z+100. R0 125 L X+92.7
 FMAX M13 126 L Y+27.7
 26 L X+96.95 Y+27.7 FMAX 127 L X+97.3
 27 L Z+15. FMAX 128 L Y+32.3
 28 L Z+9.8 FQ3 M91 129 L X+93.175
 29 L X+97.3 Z+9.673 130 L Y+33.55
 30 L Y+32.3 Z+7.998 131 L Y+34.8
 31 L X+93.175 Z+6.497 132 L X+90.2
 32 L X+92.7 Z+6.324 133 L Y+25.2
 33 L Y+27.7 Z+4.65 134 L X+99.8
 34 L X+97.3 Z+2.976 135 L Y+34.8
 35 L Y+32.3 Z+1.301 136 L X+93.175
 36 L X+93.175 Z-.2 137 L Y+36.05
 37 L X+92.7 138 L Y+37.3
 38 L Y+27.7 139 L X+87.7
 39 L X+97.3 140 L Y+22.7
 40 L Y+32.3 141 L X+102.3
 41 L X+93.175 142 L Y+37.3
 42 L Y+33.55 143 L X+93.175
 43 L Y+34.8 144 L Z+15. FQ4
 44 L X+90.2 145 L Y+32.3 FMAX
 45 L Y+25.2 146 L Z-1.2 FQ3
 46 L X+99.8 147 L X+92.7
 47 L Y+34.8 148 L Y+27.7
 48 L X+93.175 149 L X+97.3
 49 L Y+36.05 150 L Y+32.3
 50 L Y+37.3 151 L X+93.175
 51 L X+87.7 152 L Y+33.55
 52 L Y+22.7 153 L Y+34.8
 53 L X+102.3 154 L X+90.2
 54 L Y+37.3 155 L Y+25.2
 55 L X+93.175 156 L X+99.8
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 57 L Y+32.3 FMAX 158 L X+93.175
 58 L Z-.4 FQ3 159 L Y+36.05
 59 L X+92.7 160 L Y+37.3
 60 L Y+27.7 161 L X+87.7
 61 L X+97.3 162 L Y+22.7
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 63 L X+93.175 164 L Y+37.3
 64 L Y+33.55 165 L X+93.175
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 66 L X+90.2 167 L Y+32.3 FMAX
 67 L Y+25.2 168 L Z-1.4 FQ3
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 72 L Y+37.3 173 L X+93.175
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 74 L Y+22.7 175 L Y+34.8
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 229 L X+102.3
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 233 L Y+32.3 FMAX
 234 L Z-.2. FQ3
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 292 L Y+37.3
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 392 L X+35.1 Y+82. Z+8.176
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 394 L X+34.9 Y+82. Z+8.068
 395 L X+35. Y+81.9 Z+8.017
 396 L X+35.1 Y+82. Z+7.965
 397 L X+34.988 Y+82.099
 Z+7.905
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 Z+6.851
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 419 L X+35. Y+81.9 Z+6.751
 420 L X+35.1 Y+82. Z+6.699
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 Z+6.64
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 431 L X+35. Y+81.9 Z+6.118
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 434 L X+34.9 Y+82. Z+5.958
 435 L X+35. Y+81.9 Z+5.907
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 Z+5.796
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 455 L X+35. Y+81.9 Z+4.852
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 544 L X+35.1 Y+82. Z+ 159
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 551 L X+35. Y+81.9 Z- 211
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 555 L X+35. Y+81.9 Z- 422
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 563 L X+34.837 Y+83.34
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 566 L X+33.323 Y+83.987
 567 L X+32.825 Y+83.425
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 575 L X+35. Y+79.4
 576 L X+35.673 Y+79.489
 577 L X+36.3 Y+79.748
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 587 L X+34.687 Y+84.581
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 606 L X+36.952 Y+77.288
 607 L X+37.833 Y+77.76
 608 L X+38.606 Y+78.394
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 FMAX
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 687 L Z+15. FQ4
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 FMAX
 689 L Z-1.6 FQ3
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 697 L X+33.962 Y+84.384
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 700 L X+32.509 Y+82.743
 701 L X+32.4 Y+82.
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 705 L X+33.7 Y+79.748
 706 L X+34.327 Y+79.489
 707 L X+35. Y+79.4
 708 L X+35.673 Y+79.489
 709 L X+36.3 Y+79.748
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 719 L X+34.687 Y+84.581
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 753 L Z+15. FQ4
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 FMAX
 755 L Z-2.133 FQ3
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 758 L X+35.1 Y+82.
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 763 L X+33.962 Y+84.384
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 766 L X+32.509 Y+82.743
 767 L X+32.4 Y+82.
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 769 L X+32.748 Y+80.7
 770 L X+33.162 Y+80.162
 771 L X+33.7 Y+79.748
 772 L X+34.327 Y+79.489
 773 L X+35. Y+79.4
 774 L X+35.673 Y+79.489
 775 L X+36.3 Y+79.748
 776 L X+36.838 Y+80.162
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 785 L X+34.687 Y+84.581
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 787 L X+34.385 Y+87.063
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 792 L X+30.331 Y+84.053
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 799 L X+32.167 Y+77.76
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 FMAX
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 831 L X+32.825 Y+83.425
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 833 L X+32.4 Y+82.
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 836 L X+33.162 Y+80.162
 837 L X+33.7 Y+79.748
 838 L X+34.327 Y+79.489
 839 L X+35. Y+79.4
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 FMAX
 887 L Z-3.2 FQ3
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 899 L X+32.4 Y+82.
 900 L X+32.489 Y+81.327
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 902 L X+33.162 Y+80.162
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 904 L X+34.327 Y+79.489
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 906 L X+35.673 Y+79.489
 907 L X+36.3 Y+79.748
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 930 L X+31.394 Y+78.394
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 933 L X+34.005 Y+76.998
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 944 L X+39.651 Y+84.093
 945 L X+39.108 Y+85.023
 946 L X+38.382 Y+85.817
 947 L X+37.505 Y+86.442
 948 L X+36.724 Y+83.946
 949 L X+35.462 Y+87.079

950 L X+34.385 Y+87.063
951 L Z+15. FQ4
952 L X+34.988 Y+82.099
FMAX
953 L Z-3.733 FQ3
954 L X+34.9 Y+82.
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963 L X+32.825 Y+83.425
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971 L X+35. Y+79.4
972 L X+35.673 Y+79.489
973 L X+36.3 Y+79.748
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1017 L Z+15. FQ4
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FMAX
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FMAX
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FMAX
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FMAX
1217 L Z-5.867 FQ3
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FMAX
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FMAX
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FMAX
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1477 L X+35.462 Y+87.079
1478 L X+34.385 Y+87.063
1479 L Z+15. FQ4
1480 L X+34.988 Y+82.099 FMAX
1481 L Z-8. FQ3
1482 L X+34.9 Y+82.
1483 L X+35. Y+81.9
1484 L X+35.1 Y+82.
1485 L X+35.066 Y+82.075
1486 L X+34.988 Y+82.099
1487 L X+34.837 Y+83.34
1488 L X+34.687 Y+84.581
1489 L X+33.962 Y+84.384
1490 L X+33.323 Y+83.987
1491 L X+32.825 Y+83.425
1492 L X+32.509 Y+82.743
1493 L X+32.4 Y+82.
1494 L X+32.489 Y+81.327
1495 L X+32.748 Y+80.7
1496 L X+33.162 Y+80.162
1497 L X+33.7 Y+79.748
1498 L X+34.327 Y+79.489
1499 L X+35. Y+79.4
1500 L X+35.673 Y+79.489
1501 L X+36.3 Y+79.748
1502 L X+36.838 Y+80.162
1503 L X+37.252 Y+80.7
1504 L X+37.511 Y+81.327
1505 L X+37.6 Y+82.
1506 L X+37.497 Y+82.723
1507 L X+37.197 Y+83.39
1508 L X+36.724 Y+83.946
1509 L X+36.115 Y+84.349
1510 L X+35.417 Y+84.566
1511 L X+34.687 Y+84.581
1512 L X+34.536 Y+85.822
1513 L X+34.385 Y+87.063
1514 L X+33.357 Y+86.828
1515 L X+32.399 Y+86.387
1516 L X+31.553 Y+85.758
1517 L X+30.853 Y+84.969
1518 L X+30.331 Y+84.053
1519 L X+30.009 Y+83.049
1520 L X+29.9 Y+82.
1521 L X+29.998 Y+81.005
1522 L X+30.288 Y+80.048
1523 L X+30.76 Y+79.167
1524 L X+31.394 Y+78.394
1525 L X+32.167 Y+77.76
1526 L X+33.048 Y+77.288
1527 L X+34.005 Y+76.998
1528 L X+35. Y+76.9
1529 L X+35.995 Y+76.998
1530 L X+36.952 Y+77.288
1531 L X+37.833 Y+77.76
1532 L X+38.606 Y+78.394
1533 L X+39.241 Y+79.167
1534 L X+39.712 Y+80.048
1535 L X+40.002 Y+81.005
1536 L X+40.1 Y+82.
1537 L X+39.986 Y+83.07
1538 L X+39.651 Y+84.093
1539 L X+39.108 Y+85.023
1540 L X+38.382 Y+85.817
1541 L X+37.505 Y+86.442
1542 L X+36.517 Y+86.869
1543 L X+35.462 Y+87.079
1544 L X+34.385 Y+87.063
1545 L Z+15. FQ4
1546 L X+0.0 Y+0.0 Z+100. FMAX
1547 L X+94.875 Y+32.3 FMAX
1548 L Z+15. FMAX
1549 L Z+6.733 FQ3
1550 L X+92.7 Z+5.942
1551 L Y+27.7 Z+4.268
1552 L X+95. Z+3.43
1553 L X+97.3 Z+2.593
1554 L Y+32.3 Z+9.19
1555 L X+92.7 Z-.755
1556 L Y+27.7 Z-2.43
1557 L X+95. Z-3.267
1558 L X+97.3
1559 L Y+32.3
1560 L X+92.7
1561 L Y+27.7
1562 L X+95.
1563 L Z+15. FQ4
1564 L Z-3.533 FQ3
1565 L X+97.3
1566 L Y+32.3
1567 L X+92.7
1568 L Y+27.7
1569 L X+95.
1570 L Z+15. FQ4
1571 L Z-3.8 FQ3
1572 L X+97.3
1573 L Y+32.3
1574 L X+92.7
1575 L Y+27.7
1576 L X+95.
1577 L Z+15. FQ4
1578 L Z-4.067 FQ3
1579 L X+97.3
1580 L Y+32.3
1581 L X+92.7
1582 L Y+27.7
1583 L X+95.
1584 L Z+15. FQ4
1585 L Z-4.333 FQ3
1586 L X+97.3
1587 L Y+32.3
1588 L X+92.7
1589 L Y+27.7
1590 L X+95.
1591 L Z+15. FQ4
1592 L Z-4.6 FQ3
1593 L X+97.3
1594 L Y+32.3
1595 L X+92.7
1596 L Y+27.7
1597 L X+95.
1598 L Z+15. FQ4
1599 L Z-4.867 FQ3
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1601 L Y+32.3
1602 L X+92.7
1603 L Y+27.7
1604 L X+95.
1605 L Z+15. FQ4
1606 L Z-5.133 FQ3
1607 L X+97.3
1608 L Y+32.3
1609 L X+92.7
1610 L Y+27.7
1611 L X+95.
1612 L Z+15. FQ4
1613 L Z-5.4 FQ3
1614 L X+97.3
1615 L Y+32.3
1616 L X+92.7
1617 L Y+27.7
1618 L X+95.
1619 L Z+15. FQ4
1620 L Z-5.667 FQ3
1621 L X+97.3
1622 L Y+32.3
1623 L X+92.7
1624 L Y+27.7
1625 L X+95.
1626 L Z+15. FQ4
1627 L Z-5.933 FQ3
1628 L X+97.3
1629 L Y+32.3
1630 L X+92.7
1631 L Y+27.7
1632 L X+95.
1633 L Z+15. FQ4
1634 L Z-6.2 FQ3
1635 L X+97.3
1636 L Y+32.3
1637 L X+92.7
1638 L Y+27.7
1639 L X+95.
1640 L Z+15. FQ4
1641 L Z-6.467 FQ3
1642 L X+97.3
1643 L Y+32.3
1644 L X+92.7
1645 L Y+27.7
1646 L X+95.
1647 L Z+15. FQ4
1648 L Z-6.733 FQ3
1649 L X+97.3
1650 L Y+32.3
1651 L X+92.7
1652 L Y+27.7
1653 L X+95.
1654 L Z+15. FQ4
1655 L Z-7. FQ3
1656 L X+97.3
1657 L Y+32.3
1658 L X+92.7
1659 L Y+27.7
1660 L X+95.
1661 L Z+15. FQ4
1662 L X+0.0 Y+0.0 Z+100. FMAX
1663 L X+94.5 Y+70.5 FMAX
1664 L Z+15. FMAX
1665 L Z+9.609 FQ3
1666 L Y+69.5 Z+9.245
1667 L X+95.5 Z+8.881
1668 L Y+70.5 Z+8.517
1669 L X+95. Z+8.335
1670 L X+94.5 Z+8.153
1671 L Y+69.5 Z+7.789
1672 L X+95.5 Z+7.425
1673 L Y+70.5 Z+7.061
1674 L X+95. Z+6.879
1675 L X+94.5 Z+6.697
1676 L Y+69.5 Z+6.333
1677 L X+95.5 Z+5.969
1678 L Y+70.5 Z+5.606
1679 L X+95. Z+5.424
1680 L X+94.5 Z+5.242
1681 L Y+69.5 Z+4.878
1682 L X+95.5 Z+4.514
1683 L Y+70.5 Z+4.15
1684 L X+95. Z+3.968
1685 L X+94.5 Z+3.786
1686 L Y+69.5 Z+3.422
1687 L X+95.5 Z+3.058
1688 L Y+70.5 Z+2.694
1689 L X+95. Z+2.512
1690 L X+94.5 Z+2.33
1691 L Y+69.5 Z+1.966
1692 L X+95.5 Z+1.602
1693 L Y+70.5 Z+1.238
1694 L X+95. Z+1.056
1695 L X+94.5 Z+.874
1696 L Y+69.5 Z+.51
1697 L X+95.5 Z+.146
1698 L Y+70.5 Z-.218
1699 L X+95. Z-.4
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1706 L Y+73.
1707 L X+92.
1708 L Y+67.
1709 L X+98.
1710 L Y+73.
1711 L X+95.
1712 L Z+15. FQ4
1713 L Y+75.5
1714 L X+89.5
1715 L Y+64.5
1716 L X+100.5
1717 L Y+75.5
1718 L X+95.
1719 L Z+15. FQ4
1720 L Y+70.5 FMAX
1721 L Z-.8 FQ3
1722 L X+94.5
1723 L Y+69.5
1724 L X+95.5
1725 L Y+70.5
1726 L X+95.
1727 L Y+71.75
1728 L Y+73.
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1735 L Y+75.5
1736 L X+89.5
1737 L Y+64.5
1738 L X+100.5
1739 L Y+75.5
1740 L X+95.
1741 L Z+15. FQ4
1742 L Y+70.5 FMAX
1743 L Z-1.2 FQ3
1744 L X+94.5
1745 L Y+69.5
1746 L X+95.5
1747 L Y+70.5
1748 L X+95.
1749 L Y+71.75
1750 L Y+73.
1751 L X+92.
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1756 L Y+74.25
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1758 L X+89.5
1759 L Y+64.5
1760 L X+100.5
1761 L Y+75.5
1762 L X+95.
1763 L Z+15. FQ4
1764 L Y+70.5 FMAX
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1785 L Z+15. FQ4
1786 L Y+70.5 FMAX
1787 L Z-2. FQ3
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1803 L Y+64.5
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1805 L Y+75.5
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1807 L Z+15. FQ4
1808 L Y+70.5 FMAX
1809 L Z-2.4 FQ3
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1824 L X+89.5
1825 L Y+64.5
1826 L X+100.5
1827 L Y+75.5
1828 L X+95.
1829 L Z+15. FQ4
1830 L Y+70.5 FMAX
1831 L Z-2.8 FQ3
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1847 L Y+64.5
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1849 L Y+75.5
1850 L X+95.
1851 L Z+15. FQ4
1852 L Y+70.5 FMAX
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1855 L Y+69.5
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1869 L Y+64.5
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1871 L Y+75.5
1872 L X+95.
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1874 L Y+70.5 FMAX
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1897 L Z-4. FQ3
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1914 L X+100.5
1915 L Y+75.5
1916 L X+95.
1917 L Z+15. FQ4
1918 L Y+70.5 FMAX
1919 L Z-4.4 FQ3
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1921 L Y+69.5
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1923 L Y+70.5
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1925 L Y+71.75
1926 L Y+73.
1927 L X+92.
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1933 L Y+75.5
1934 L X+89.5
1935 L Y+64.5
1936 L X+100.5
1937 L Y+75.5
1938 L X+95.
1939 L Z+15. FQ4
1940 L Y+70.5 FMAX
1941 L Z-4.8 FQ3
1942 L X+94.5
1943 L Y+69.5
1944 L X+95.5
1945 L Y+70.5
1946 L X+95.
1947 L Y+71.75

1948 L Y+73.
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 1957 L Y+64.5
 1958 L X+100.5
 1959 L Y+75.5
 1960 L X+95.
 1961 L Z+15. FQ4
 1962 L Y+70.5 FMAX
 1963 L Z-5.2 FQ3
 1964 L X+94.5
 1965 L Y+69.5
 1966 L X+95.5
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 1977 L Y+75.5
 1978 L X+89.5
 1979 L Y+64.5
 1980 L X+100.5
 1981 L Y+75.5
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 1983 L Z+15. FQ4
 1984 L Y+70.5 FMAX
 1985 L Z-5.6 FQ3
 1986 L X+94.5
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 2001 L Y+64.5
 2002 L X+100.5
 2003 L Y+75.5
 2004 L X+95.
 2005 L Z+15. FQ4
 2006 L Y+70.5 FMAX
 2007 L Z-6. FQ3
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 2009 L Y+69.5
 2010 L X+95.5
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 2013 L Y+71.75
 2014 L Y+73.
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 2017 L X+98.
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 2019 L X+95.
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 2021 L Y+75.5
 2022 L X+89.5
 2023 L Y+64.5
 2024 L X+100.5
 2025 L Y+75.5
 2026 L X+95.
 2027 L Z+15. FQ4
 2028 L X+0.0 Y+0.0 Z+100. FMAX
 2029 L X+92.5 Y+72.5 FMAX
 2030 L Z+15. FMAX
 2031 L Z+3.609 FQ3
 2032 L Y+67.5 Z+1.789
 2033 L X+95. Z+879
 2034 L X+97.5 Z-.031
 2035 L Y+72.5 Z-1.85
 2036 L X+92.5 Z-3.67
 2037 L Y+67.5 Z-5.49
 2038 L X+95. Z-6.4
 2039 L X+97.5
 2040 L Y+72.5
 2041 L X+92.5
 2042 L Y+67.5
 2043 L X+95.
 2044 L Z+15. FQ4
 2045 L Z-6.8 FQ3
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 2047 L Y+72.5
 2048 L X+92.5
 2049 L Y+67.5
 2050 L X+95.
 2051 L Z+15. FQ4
 2052 L Z-7.2 FQ3
 2053 L X+97.5
 2054 L Y+72.5
 2055 L X+92.5
 2056 L Y+67.5
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 2059 L Z-7.6 FQ3
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 2061 L Y+72.5
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 2065 L Z+15. FQ4
 2066 L Z-8. FQ3
 2067 L X+97.5
 2068 L Y+72.5
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 2071 L X+95.
 2072 L Z+15. FQ4
 2073 L Z-8.4 FQ3
 2074 L X+97.5
 2075 L Y+72.5
 2076 L X+92.5
 2077 L Y+67.5
 2078 L X+95.
 2079 L Z+15. FQ4
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 2085 L X+95.
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 2087 L Z-9.2 FQ3
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 2089 L Y+72.5
 2090 L X+92.5
 2091 L Y+67.5
 2092 L X+95.
 2093 L Z+15. FQ4
 2094 L Z-9.6 FQ3
 2095 L X+97.5
 2096 L Y+72.5
 2097 L X+92.5
 2098 L Y+67.5
 2099 L X+95.
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 2101 L Z-10. FQ3
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 2103 L Y+72.5
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 2107 L Z+15. FQ4
 2108 L Z-10.4 FQ3
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 2113 L X+95.
 2114 L Z+15. FQ4
 2115 L Z-10.8 FQ3
 2116 L X+97.5
 2117 L Y+72.5
 2118 L X+92.5
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 2122 L Z-11.2 FQ3
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 2124 L Y+72.5
 2125 L X+92.5
 2126 L Y+67.5
 2127 L X+95.
 2128 L Z+15. FQ4
 2129 L Z-11.6 FQ3
 2130 L X+97.5
 2131 L Y+72.5
 2132 L X+92.5
 2133 L Y+67.5
 2134 L X+95.
 2135 L Z+15. FQ4
 2136 L Z-12. FQ3
 2137 L X+97.5
 2138 L Y+72.5
 2139 L X+92.5
 2140 L Y+67.5
 2141 L X+95.
 2142 L Z+15. FQ4
 2143 L X+0.0 Y+0.0 Z+100. FMAX
 2144 L X+37.5 Y+82. FMAX
 2145 L Z+15. FMAX
 2146 L Z+1.707 FQ3
 2147 L X+37.399 Y+82.704 Z+1.448
 2148 L X+37.103 Y+83.352 Z+1.189
 2149 L X+36.637 Y+83.889 Z+93
 2150 L X+36.039 Y+84.274 Z+671
 2151 L X+35.356 Y+84.475 Z+412
 2152 L X+34.644 Z+153
 2153 L X+33.961 Y+84.274 Z-106
 2154 L X+33.363 Y+83.889 Z-365
 2155 L X+32.897 Y+83.352 Z-624
 2156 L X+32.601 Y+82.704 Z-.883
 2157 L X+32.5 Y+82. Z-1.142
 2158 L X+32.585 Y+81.353 Z-1.38
 2159 L X+32.835 Y+80.75 Z-1.617
 2160 L X+33.232 Y+80.232 Z-1.855
 2161 L X+33.75 Y+79.835 Z-2.092
 2162 L X+34.353 Y+79.585 Z-2.33
 2163 L X+35. Y+79.5 Z-2.567
 2164 L X+35.647 Y+79.585 Z-2.805
 2165 L X+36.25 Y+79.835 Z-3.042
 2166 L X+36.768 Y+80.232 Z-3.28
 2167 L X+37.165 Y+80.75 Z-3.517
 2168 L X+37.415 Y+81.353 Z-3.755
 2169 L X+37.5 Y+82. Z-3.993
 2170 L X+37.399 Y+82.704 Z-4.252
 2171 L X+37.103 Y+83.352 Z-4.511
 2172 L X+36.637 Y+83.889 Z-4.77
 2173 L X+36.039 Y+84.274 Z-5.028
 2174 L X+35.356 Y+84.475 Z-5.287
 2175 L X+34.644 Z-5.546
 2176 L X+33.961 Y+84.274 Z-5.805
 2177 L X+33.363 Y+83.889 Z-6.064
 2178 L X+32.897 Y+83.352 Z-6.323
 2179 L X+32.601 Y+82.704 Z-6.582
 2180 L X+32.5 Y+82. Z-6.841
 2181 L X+32.585 Y+81.353 Z-7.079
 2182 L X+32.835 Y+80.75 Z-7.317
 2183 L X+33.232 Y+80.232 Z-7.554
 2184 L X+33.75 Y+79.835 Z-7.792
 2185 L X+34.353 Y+79.585 Z-8.029
 2186 L X+35. Y+79.5 Z-8.267
 2187 L X+35.647 Y+79.585
 2188 L X+36.25 Y+79.835
 2189 L X+36.768 Y+80.232
 2190 L X+37.165 Y+80.75
 2191 L X+37.415 Y+81.353
 2192 L X+37.5 Y+82.
 2193 L X+37.399 Y+82.704
 2194 L X+37.103 Y+83.352
 2195 L X+36.637 Y+83.889
 2196 L X+36.039 Y+84.274
 2197 L X+35.356 Y+84.475
 2198 L X+34.644
 2199 L X+33.961 Y+84.274
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 2201 L X+32.897 Y+83.352
 2202 L X+32.601 Y+82.704
 2203 L X+32.5 Y+82.
 2204 L X+32.585 Y+81.353
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 2206 L X+33.232 Y+80.232
 2207 L X+33.75 Y+79.835
 2208 L X+34.353 Y+79.585
 2209 L X+35. Y+79.5
 2210 L Z+15. FQ4
 2211 L Z-8.533 FQ3
 2212 L X+35.647 Y+79.585
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 2234 L X+35. Y+79.5
 2235 L Z+15. FQ4
 2236 L Z-8.8 FQ3
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 2258 L X+34.353 Y+79.585
 2259 L X+35. Y+79.5
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 2285 L Z+15. FQ4
 2286 L Z-9.333 FQ3
 2287 L X+35.647 Y+79.585
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 2311 L Z-9.6 FQ3
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 2334 L X+35. Y+79.5
 2335 L Z+15. FQ4
 2336 L Z-9.867 FQ3
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 2356 L X+33.232 Y+80.232
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 2358 L X+34.353 Y+79.585
 2359 L X+35. Y+79.5
 2360 L Z+15. FQ4
 2361 L Z-10.133 FQ3
 2362 L X+35.647 Y+79.585
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 2373 L X+34.644
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 2382 L X+33.75 Y+79.835
 2383 L X+34.353 Y+79.585
 2384 L X+35. Y+79.5
 2385 L Z+15. FQ4
 2386 L Z-10.4 FQ3
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 2398 L X+34.644
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 2408 L X+34.353 Y+79.585
 2409 L X+35. Y+79.5
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 2411 L Z-10.667 FQ3
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2423 L X+34.644
2424 L X+33.961 Y+84.274
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2429 L X+32.585 Y+81.353
2430 L X+32.835 Y+80.75
2431 L X+33.232 Y+80.232
2432 L X+33.75 Y+79.835
2433 L X+34.353 Y+79.585
2434 L X+35. Y+79.5
2435 L Z+15. FQ4
2436 L Z-10.933 FQ3
2437 L X+35.647 Y+79.585
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2448 L X+34.644
2449 L X+33.961 Y+84.274
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2458 L X+34.353 Y+79.585
2459 L X+35. Y+79.5
2460 L Z+15. FQ4
2461 L Z-11.2 FQ3
2462 L X+35.647 Y+79.585
2463 L X+36.25 Y+79.835
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2473 L X+34.644
2474 L X+33.961 Y+84.274
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2479 L X+32.585 Y+81.353
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2481 L X+33.232 Y+80.232
2482 L X+33.75 Y+79.835
2483 L X+34.353 Y+79.585
2484 L X+35. Y+79.5
2485 L Z+15. FQ4
2486 L Z-11.467 FQ3
2487 L X+35.647 Y+79.585
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2496 L X+36.039 Y+84.274
2497 L X+35.356 Y+84.475
2498 L X+34.644
2499 L X+33.961 Y+84.274
2500 L X+33.363 Y+83.889
2501 L X+32.897 Y+83.352
2502 L X+32.601 Y+82.704
2503 L X+32.5 Y+82.
2504 L X+32.585 Y+81.353
2505 L X+32.835 Y+80.75
2506 L X+33.232 Y+80.232
2507 L X+33.75 Y+79.835
2508 L X+34.353 Y+79.585
2509 L X+35. Y+79.5
2510 L Z+15. FQ4
2511 L Z-11.733 FQ3
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2522 L X+35.356 Y+84.475
2523 L X+34.644
2524 L X+33.961 Y+84.274
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2526 L X+32.897 Y+83.352
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2528 L X+32.5 Y+82.
2529 L X+32.585 Y+81.353
2530 L X+32.835 Y+80.75
2531 L X+33.232 Y+80.232
2532 L X+33.75 Y+79.835
2533 L X+34.353 Y+79.585
2534 L X+35. Y+79.5
2535 L Z+15. FQ4
2536 L Z-12. FQ3
2537 L X+35.647 Y+79.585
2538 L X+36.25 Y+79.835
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2548 L X+34.644
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2555 L X+32.835 Y+80.75
2556 L X+33.232 Y+80.232
2557 L X+33.75 Y+79.835
2558 L X+34.353 Y+79.585
2559 L X+35. Y+79.5
2560 L Z+15. FQ4
2561 L X+0.0 Y+0.0 Z+100.
FMAX
2562 L X+127.5 Y+72.5 FMAX
2563 L Z+15. FMAX
2564 L Z+8.809 FQ3
2565 L Y+67.5 Z+6.989
2566 L X+130. Z+6.079
2567 L X+132.5 Z+5.169
2568 L Y+72.5 Z+3.35
2569 L X+127.5 Z+1.53
2570 L Y+67.5 Z-.29
2571 L X+130. Z-1.2
2572 L X+132.5
2573 L Y+72.5
2574 L X+127.5
2575 L Y+67.5
2576 L X+130.
2577 L Z+15. FQ4
2578 L Z-2.4 FQ3
2579 L X+132.5
2580 L Y+72.5
2581 L X+127.5
2582 L Y+67.5
2583 L X+130.
2584 L Z+15. FQ4
2585 L Z-3.6 FQ3
2586 L X+132.5
2587 L Y+72.5
2588 L X+127.5
2589 L Y+67.5
2590 L X+130.
2591 L Z+15. FQ4
2592 L Z-4.8 FQ3
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2594 L Y+72.5
2595 L X+127.5
2596 L Y+67.5
2597 L X+130.
2598 L Z+15. FQ4
2599 L Z-6. FQ3
2600 L X+132.5
2601 L Y+72.5
2602 L X+127.5
2603 L Y+67.5
2604 L X+130.
2605 L Z+15. FQ4
2606 L Z-7.2 FQ3
2607 L X+132.5
2608 L Y+72.5
2609 L X+127.5
2610 L Y+67.5
2611 L X+130.
2612 L Z+15. FQ4
2613 L Z-8.4 FQ3
2614 L X+132.5
2615 L Y+72.5
2616 L X+127.5
2617 L Y+67.5
2618 L X+130.
2619 L Z+15. FQ4
2620 L Z-9.6 FQ3
2621 L X+132.5
2622 L Y+72.5
2623 L X+127.5
2624 L Y+67.5
2625 L X+130.
2626 L Z+15. FQ4
2627 L Z-10.8 FQ3
2628 L X+132.5
2629 L Y+72.5
2630 L X+127.5
2631 L Y+67.5
2632 L X+130.
2633 L Z+15. FQ4
2634 L Z-12. FQ3
2635 L X+132.5
2636 L Y+72.5
2637 L X+127.5
2638 L Y+67.5
2639 L X+130.
2640 L Z+15. FQ4
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2642 L X+132.5
2643 L Y+72.5
2644 L X+127.5
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2646 L X+130.
2647 L Z+15. FQ4
2648 L Z-14.4 FQ3
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2653 L X+130.
2654 L Z+15. FQ4
2655 L Z-15.6 FQ3
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2659 L Y+67.5
2660 L X+130.
2661 L Z+15. FQ4
2662 L Z-16.8 FQ3
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2665 L X+127.5
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2667 L X+130.
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2669 L Z-18. FQ3
2670 L X+132.5
2671 L Y+72.5
2672 L X+127.5
2673 L Y+67.5
2674 L X+130.
2675 L Z+15. FQ4
2676 L X+0.0 Y+0.0 Z+100.
FMAX
2677 L X+31.075 Y+30.2 FMAX
2678 L Z+15. FMAX
2679 L Z+9.333 FQ3
2680 L X+34.8 Z+7.978
2681 L Y+49.8 Z+.844
2682 L X+30.65 Z-.667
2683 L X+30.2
2684 L Y+30.2
2685 L X+34.8
2686 L Y+49.8
2687 L X+30.65
2688 L X+30.2
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2689 L Y+52.3
2690 L X+27.7
2691 L Y+27.7
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2692 L X+37.3
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2696 L X+27.7
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2698 L Y+20.2
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2719 L Y+17.7
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2721 L Y+62.3
2722 L X+30.65
2723 L Z+15. FQ4
2724 L Y+49.8 FMAX
2725 L Z-1.333 FQ3
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2727 L Y+30.2
2728 L X+34.8
2729 L Y+49.8
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2762 L Y+17.7
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2764 L Y+62.3
2765 L X+30.65
2766 L Z+15. FQ4
2767 L Y+49.8 FMAX
2768 L Z-2. FQ3
2769 L X+30.2
2770 L Y+30.2
2771 L X+34.8
2772 L Y+49.8
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2784 L Y+25.2
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2787 L X+30.65
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2789 L Y+57.3
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2791 L Y+22.7
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2793 L Y+57.3
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2795 L Y+58.55
2796 L Y+59.8
2797 L X+20.2
2798 L Y+20.2
2799 L X+44.8
2800 L Y+59.8
2801 L X+30.65
2802 L Y+61.05
2803 L Y+62.3
2804 L X+17.7
2805 L Y+17.7
2806 L X+47.3
2807 L Y+62.3
2808 L X+30.65
2809 L Z+15. FQ4
2810 L Y+49.8 FMAX
2811 L Z-2.667 FQ3
2812 L X+30.2
2813 L Y+30.2
2814 L X+34.8
2815 L Y+49.8
2816 L X+30.65
2817 L Y+51.05
2818 L Y+52.3
2819 L X+27.7
2820 L Y+27.7
2821 L X+37.3
2822 L Y+52.3
2823 L X+30.65
2824 L Y+53.55
2825 L Y+54.8
2826 L X+25.2
2827 L Y+25.2
2828 L X+39.8
2829 L Y+54.8
2830 L X+30.65
2831 L Y+56.05
2832 L Y+57.3
2833 L X+22.7
2834 L Y+22.7
2835 L X+42.3
2836 L Y+57.3
2837 L X+30.65
2838 L Y+58.55
2839 L Y+59.8
2840 L X+20.2
2841 L Y+20.2
2842 L X+44.8
2843 L Y+59.8
2844 L X+30.65
2845 L Y+61.05
2846 L Y+62.3
2847 L X+17.7
2848 L Y+17.7
2849 L X+47.3
2850 L Y+62.3
2851 L X+30.65
2852 L Z+15. FQ4
2853 L Y+49.8 FMAX
2854 L Z-3.333 FQ3
2855 L X+20.2
2856 L Y+30.2
2857 L X+34.8
2858 L Y+49.8
2859 L X+30.65
2860 L Y+61.05
2861 L Y+52.3
2862 L X+27.7
2863 L Y+27.7
2864 L X+37.3
2865 L Y+52.3
2866 L X+30.65
2867 L Y+53.55
2868 L Y+54.8
2869 L X+25.2
2870 L Y+25.2
2871 L X+39.8
2872 L Y+54.8
2873 L X+30.65
2874 L Y+56.05
2875 L Y+57.3
2876 L X+22.7
2877 L Y+22.7
2878 L X+42.3
2879 L Y+57.3
2880 L X+30.65
2881 L Y+58.55
2882 L Y+59.8
2883 L X+20.2
2884 L Y+20.2
2885 L X+44.8
2886 L Y+59.8
2887 L X+30.65
2888 L Y+61.05
2889 L Y+62.3
2890 L X+17.7
2891 L Y+17.7
2892 L X+47.3
2893 L Y+62.3
2894 L X+30.65
2895 L Z+15. FQ4
2896 L Y+49.8 FMAX
2897 L Z-4. FQ3
2898 L X+30.2
2899 L Y+30.2
2900 L X+34.8
2901 L Y+49.8
2902 L X+30.65
2903 L Y+51.05
2904 L Y+52.3
2905 L X+27.7
2906 L Y+27.7
2907 L X+37.3
2908 L Y+52.3
2909 L X+30.65
2910 L Y+53.55
2911 L Y+54.8
2912 L X+25.2
2913 L Y+25.2
2914 L X+39.8
2915 L Y+54.8
2916 L X+30.65
2917 L Y+56.05
2918 L Y+57.3
2919 L X+22.7

2920 L Y+22.7	3021 L X+47.3	3122 L X+37.3	3223 L Y+57.3	3324 L X+30.65
2921 L X+42.3	3022 L Y+62.3	3123 L Y+52.3	3224 L X+30.65	3325 L Z+15. FQ4
2922 L Y+57.3	3023 L X+30.65	3124 L X+30.65	3225 L Y+58.55	3326 L X+0.0 Y+0.0 Z+100.
2923 L X+30.65	3024 L Z+15. FQ4	3125 L Y+53.55	3226 L Y+59.8	FMAX
2924 L Y+58.55	3025 L Y+49.8 FMAX	3126 L Y+54.8	3227 L X+20.2	3327 L X+31.025 Y+30.2 FMAX
2925 L Y+59.8	3026 L Z-6. FQ3	3127 L X+25.2	3228 L Y+20.2	3328 L Z+15. FMAX
2926 L X+20.2	3027 L X+30.2	3128 L Y+25.2	3229 L X+44.8	3329 L Z-133 FQ3
2927 L Y+20.2	3028 L Y+30.2	3129 L X+39.8	3230 L Y+59.8	3330 L X+34.8 Z-1.507
2928 L X+44.8	3029 L X+34.8	3130 L Y+54.8	3231 L X+30.65	3331 L Y+49.8 Z-8.641
2929 L Y+59.8	3030 L Y+49.8	3131 L X+30.65	3232 L Y+61.05	3332 L X+30.7 Z-10.133
2930 L X+30.65	3031 L X+30.65	3132 L Y+56.05	3233 L Y+62.3	3333 L X+30.2
2931 L Y+61.05	3032 L Y+51.05	3133 L Y+57.3	3234 L X+17.7	3334 L Y+30.2
2932 L Y+62.3	3033 L Y+52.3	3134 L X+22.7	3235 L Y+17.7	3335 L X+34.8
2933 L X+17.7	3034 L X+27.7	3135 L Y+22.7	3236 L X+47.3	3336 L Y+49.8
2934 L Y+17.7	3035 L Y+27.7	3136 L X+42.3	3237 L Y+62.3	3337 L X+30.7
2935 L X+47.3	3036 L X+37.3	3137 L Y+57.3	3238 L X+30.65	3338 L Y+51.05
2936 L Y+62.3	3037 L Y+52.3	3138 L X+30.65	3239 L Z+15. FQ4	3339 L Y+52.3
2937 L X+30.65	3038 L X+30.65	3139 L Y+58.55	3240 L Y+49.8 FMAX	3340 L X+27.7
2938 L Z+15. FQ4	3039 L Y+53.55	3140 L Y+59.8	3241 L Z-9.333 FQ3	3341 L Y+27.7
2939 L Y+49.8 FMAX	3040 L Y+54.8	3141 L X+20.2	3242 L X+30.2	3342 L X+37.3
2940 L Z-4.667 FQ3	3041 L X+25.2	3142 L Y+20.2	3243 L Y+30.2	3343 L Y+52.3
2941 L X+30.2	3042 L Y+25.2	3143 L X+44.8	3244 L X+34.8	3344 L X+30.7
2942 L Y+30.2	3043 L X+39.8	3144 L Y+59.8	3245 L Y+49.8	3345 L Z+15. FQ4
2943 L X+34.8	3044 L Y+54.8	3145 L X+30.65	3246 L X+30.65	3346 L Y+49.8 FMAX
2944 L Y+49.8	3045 L X+30.65	3146 L Y+61.05	3247 L Y+51.05	3347 L Z-10.267 FQ3
2945 L X+30.65	3046 L Y+56.05	3147 L Y+62.3	3248 L Y+52.3	3348 L X+30.2
2946 L Y+51.05	3047 L Y+57.3	3148 L X+17.7	3249 L X+27.7	3349 L Y+30.2
2947 L Y+52.3	3048 L X+22.7	3149 L Y+17.7	3250 L Y+27.7	3350 L X+34.8
2948 L X+27.7	3049 L Y+22.7	3150 L X+47.3	3251 L X+37.3	3351 L Y+49.8
2949 L Y+27.7	3050 L X+42.3	3151 L Y+62.3	3252 L Y+52.3	3352 L X+30.7
2950 L X+37.3	3051 L Y+57.3	3152 L X+30.65	3253 L X+30.65	3353 L Y+51.05
2951 L Y+52.3	3052 L X+30.65	3153 L Z+15. FQ4	3254 L Y+53.55	3354 L Y+52.3
2952 L X+30.65	3053 L Y+58.55	3154 L Y+49.8 FMAX	3255 L Y+54.8	3355 L X+27.7
2953 L Y+53.55	3054 L Y+59.8	3155 L Z-8. FQ3	3256 L X+25.2	3356 L Y+27.7
2954 L Y+54.8	3055 L X+20.2	3156 L X+30.2	3257 L Y+25.2	3357 L X+37.3
2955 L X+25.2	3056 L Y+20.2	3157 L Y+30.2	3258 L X+39.8	3358 L Y+52.3
2956 L Y+25.2	3057 L X+44.8	3158 L X+34.8	3259 L Y+54.8	3359 L X+30.7
2957 L X+39.8	3058 L Y+59.8	3159 L Y+49.8	3260 L X+30.65	3360 L Z+15. FQ4
2958 L Y+54.8	3059 L X+30.65	3160 L X+30.65	3261 L Y+56.05	3361 L Y+49.8 FMAX
2959 L X+30.65	3060 L Y+61.05	3161 L Y+51.05	3262 L Y+57.3	3362 L Z-10.4 FQ3
2960 L Y+56.05	3061 L Y+62.3	3162 L Y+52.3	3263 L X+22.7	3363 L X+30.2
2961 L Y+57.3	3062 L X+17.7	3163 L X+27.7	3264 L Y+22.7	3364 L Y+30.2
2962 L X+22.7	3063 L Y+17.7	3164 L Y+27.7	3265 L X+42.3	3365 L X+34.8
2963 L Y+22.7	3064 L X+47.3	3165 L X+37.3	3266 L Y+57.3	3366 L Y+49.8
2964 L X+42.3	3065 L Y+62.3	3166 L Y+52.3	3267 L X+30.65	3367 L X+30.7
2965 L Y+57.3	3066 L X+30.65	3167 L X+30.65	3268 L Y+58.55	3368 L Y+51.05
2966 L X+30.65	3067 L Z+15. FQ4	3168 L Y+53.55	3269 L Y+59.8	3369 L Y+52.3
2967 L Y+58.55	3068 L Y+49.8 FMAX	3169 L Y+54.8	3270 L X+20.2	3370 L X+27.7
2968 L Y+59.8	3069 L Z-6.667 FQ3	3170 L X+25.2	3271 L Y+20.2	3371 L Y+27.7
2969 L X+20.2	3070 L X+30.2	3171 L Y+25.2	3272 L X+44.8	3372 L X+37.3
2970 L Y+20.2	3071 L Y+30.2	3172 L X+39.8	3273 L Y+59.8	3373 L Y+52.3
2971 L X+44.8	3072 L X+34.8	3173 L Y+54.8	3274 L X+30.65	3374 L X+30.7
2972 L Y+59.8	3073 L Y+49.8	3174 L X+30.65	3275 L Y+61.05	3375 L Z+15. FQ4
2973 L X+30.65	3074 L X+30.65	3175 L Y+56.05	3276 L Y+62.3	3376 L Y+49.8 FMAX
2974 L Y+61.05	3075 L Y+51.05	3176 L Y+57.3	3277 L X+17.7	3377 L Z-10.533 FQ3
2975 L Y+62.3	3076 L Y+52.3	3177 L X+22.7	3278 L Y+17.7	3378 L X+30.2
2976 L X+17.7	3077 L X+27.7	3178 L Y+22.7	3279 L X+47.3	3379 L Y+30.2
2977 L Y+17.7	3078 L Y+27.7	3179 L X+42.3	3280 L Y+62.3	3380 L X+34.8
2978 L X+47.3	3079 L X+37.3	3180 L Y+57.3	3281 L X+30.65	3381 L Y+49.8
2979 L Y+62.3	3080 L Y+52.3	3181 L X+30.65	3282 L Z+15. FQ4	3382 L X+30.7
2980 L X+30.65	3081 L X+30.65	3182 L Y+58.55	3283 L Y+49.8 FMAX	3383 L Y+51.05
2981 L Z+15. FQ4	3082 L Y+53.55	3183 L Y+59.8	3284 L Z-10. FQ3	3384 L Y+52.3
2982 L Y+49.8 FMAX	3083 L Y+54.8	3184 L X+20.2	3285 L X+30.2	3385 L X+27.7
2983 L Z-5.333 FQ3	3084 L X+25.2	3185 L Y+20.2	3286 L Y+30.2	3386 L Y+27.7
2984 L X+30.2	3085 L Y+25.2	3186 L X+44.8	3287 L X+34.8	3387 L X+37.3
2985 L Y+30.2	3086 L X+39.8	3187 L Y+59.8	3288 L Y+49.8	3388 L Y+52.3
2986 L X+34.8	3087 L Y+54.8	3188 L X+30.65	3289 L X+30.65	3389 L X+30.7
2987 L Y+49.8	3088 L X+30.65	3189 L Y+61.05	3290 L Y+51.05	3390 L Z+15. FQ4
2988 L X+30.65	3089 L Y+56.05	3190 L Y+62.3	3291 L Y+52.3	3391 L Y+49.8 FMAX
2989 L Y+51.05	3090 L Y+57.3	3191 L X+17.7	3292 L X+27.7	3392 L Z-10.667 FQ3
2990 L Y+52.3	3091 L X+22.7	3192 L Y+17.7	3293 L Y+27.7	3393 L X+30.2
2991 L X+27.7	3092 L Y+22.7	3193 L X+47.3	3294 L X+37.3	3394 L Y+30.2
2992 L Y+27.7	3093 L X+42.3	3194 L Y+62.3	3295 L Y+52.3	3395 L X+34.8
2993 L X+37.3	3094 L Y+57.3	3195 L X+30.65	3296 L X+30.65	3396 L Y+49.8
2994 L Y+52.3	3095 L X+30.65	3196 L Z+15. FQ4	3297 L Y+53.55	3397 L X+30.7
2995 L X+30.65	3096 L Y+58.55	3197 L Y+49.8 FMAX	3298 L Y+54.8	3398 L Y+51.05
2996 L Y+53.55	3097 L Y+59.8	3198 L Z-8.667 FQ3	3299 L X+25.2	3399 L Y+52.3
2997 L Y+54.8	3098 L X+20.2	3199 L X+30.2	3300 L Y+25.2	3400 L X+27.7
2998 L X+25.2	3099 L Y+20.2	3200 L Y+30.2	3301 L X+39.8	3401 L Y+27.7
2999 L Y+25.2	3100 L X+44.8	3201 L X+34.8	3302 L Y+54.8	3402 L X+37.3
3000 L X+39.8	3101 L Y+59.8	3202 L Y+49.8	3303 L X+30.65	3403 L Y+52.3
3001 L Y+54.8	3102 L X+30.65	3203 L X+30.65	3304 L Y+56.05	3404 L X+30.7
3002 L X+30.65	3103 L Y+61.05	3204 L Y+51.05	3305 L Y+57.3	3405 L Z+15. FQ4
3003 L Y+56.05	3104 L Y+62.3	3205 L Y+52.3	3306 L X+22.7	3406 L Y+49.8 FMAX
3004 L Y+57.3	3105 L X+17.7	3206 L X+27.7	3307 L Y+22.7	3407 L Z-10.8 FQ3
3005 L X+22.7	3106 L Y+17.7	3207 L Y+27.7	3308 L X+42.3	3408 L X+30.2
3006 L Y+22.7	3107 L X+47.3	3208 L X+37.3	3309 L Y+57.3	3409 L Y+30.2
3007 L X+42.3	3108 L Y+62.3	3209 L Y+52.3	3310 L X+30.65	3410 L X+34.8
3008 L Y+57.3	3109 L X+30.65	3210 L X+30.65	3311 L Y+58.55	3411 L Y+49.8
3009 L X+30.65	3110 L Z+15. FQ4	3211 L Y+53.55	3312 L Y+59.8	3412 L X+30.7
3010 L Y+58.55	3111 L Y+49.8 FMAX	3212 L Y+54.8	3313 L X+20.2	3413 L Y+51.05
3011 L Y+59.8	3112 L Z-7.333 FQ3	3213 L X+25.2	3314 L Y+20.2	3414 L Y+52.3
3012 L X+20.2	3113 L X+30.2	3214 L Y+25.2	3315 L X+44.8	3415 L X+27.7
3013 L Y+20.2	3114 L Y+30.2	3215 L X+39.8	3316 L Y+59.8	3416 L Y+27.7
3014 L X+44.8	3115 L X+34.8	3216 L Y+54.8	3317 L X+30.65	3417 L X+37.3
3015 L Y+59.8	3116 L Y+49.8	3217 L X+30.65	3318 L Y+61.05	3418 L Y+52.3
3016 L X+30.65	3117 L X+30.65	3218 L Y+56.05	3319 L Y+62.3	3419 L X+30.7
3017 L Y+61.05	3118 L Y+51.05	3219 L Y+57.3	3320 L X+17.7	3420 L Z+15. FQ4
3018 L Y+62.3	3119 L Y+52.3	3220 L X+22.7	3321 L Y+17.7	3421 L Y+49.8 FMAX
3019 L X+17.7	3120 L X+27.7	3221 L Y+22.7	3322 L X+47.3	3422 L Z-10.933 FQ3
3020 L Y+17.7	3121 L Y+27.7	3222 L X+42.3	3323 L Y+62.3	3423 L X+30.2

3424 L Y+30.2	3525 L Z+15. FQ4	3624 L X+49.	3725 L X+16.097 Y+38.244 FQ4	3826 L X+18.176 Y+36.116
3425 L X+34.8	3526 L Y+49.8 FMAX	3625 L Y+64.	3726 L X+16.371 Y+37.555	3827 L X+19. Y+36.
3426 L Y+49.8	3527 L Z-11.867 FQ3	3626 L X+16.	3727 L X+16.637 Y+37.151	3828 L Z+15.
3427 L X+30.7	3528 L X+30.2	3627 L Y+40.	3728 L X+16.961 Y+36.8	3829 L Y+44. FMAX
3428 L Y+51.05	3529 L Y+30.2	3628 L Y+39.	3729 L X+17.463 Y+36.424	3830 L Z-2.308 FQ3
3429 L Y+52.3	3530 L X+34.8	3629 L X+16.097 Y+38.244 FQ4	3730 L X+18.176 Y+36.116	3831 L X+18.244 Y+43.903
3430 L X+27.7	3531 L Y+49.8	3630 L X+16.371 Y+37.555	3731 L X+19. Y+36.	3832 L X+17.555 Y+43.629
3431 L Y+27.7	3532 L X+30.7	3631 L X+16.637 Y+37.151	3732 L Z+15.	3833 L X+17.151 Y+43.363
3432 L X+37.3	3533 L Y+51.05	3632 L X+16.961 Y+36.8	3733 L Y+44. FMAX	3834 L X+16.8 Y+43.039
3433 L Y+52.3	3534 L Y+52.3	3633 L X+17.463 Y+36.424	3734 L Z-1.538 FQ3	3835 L X+16.424 Y+42.537
3434 L X+30.7	3535 L X+27.7	3634 L X+18.176 Y+36.116	3735 L X+18.244 Y+43.903	3836 L X+16.116 Y+41.824
3435 L Z+15. FQ4	3536 L Y+27.7	3635 L X+19. Y+36.	3736 L X+17.555 Y+43.629	3837 L X+16. Y+41.
3436 L Y+49.8 FMAX	3537 L X+37.3	3636 L Z+15.	3737 L X+17.151 Y+43.363	3838 L Y+40.
3437 L Z-11.067 FQ3	3538 L Y+52.3	3637 L Y+44. FMAX	3738 L X+16.8 Y+43.039	3839 L Y+16.
3438 L X+30.2	3539 L X+30.7	3638 L Z-769 FQ3	3739 L X+16.424 Y+42.537	3840 L X+49.
3439 L Y+30.2	3540 L Z+15. FQ4	3639 L X+18.244 Y+43.903	3740 L X+16.116 Y+41.824	3841 L Y+64.
3440 L X+34.8	3541 L Y+49.8 FMAX	3640 L X+17.555 Y+43.629	3741 L X+16. Y+41.	3842 L X+16.
3441 L Y+49.8	3542 L Z-12. FQ3	3641 L X+17.151 Y+43.363	3742 L Y+40.	3843 L Y+40.
3442 L X+30.7	3543 L X+30.2	3642 L X+16.8 Y+43.039	3743 L Y+16.	3844 L Y+39.
3443 L Y+51.05	3544 L Y+30.2	3643 L X+16.424 Y+42.537	3744 L X+49.	3845 L X+16.097 Y+38.244 FQ4
3444 L Y+52.3	3545 L X+34.8	3644 L X+16.116 Y+41.824	3745 L Y+64.	3846 L X+16.371 Y+37.555
3445 L X+27.7	3546 L Y+49.8	3645 L X+16. Y+41.	3746 L X+16.	3847 L X+16.637 Y+37.151
3446 L Y+27.7	3547 L X+30.7	3646 L Y+40.	3747 L Y+40.	3848 L X+16.961 Y+36.8
3447 L X+37.3	3548 L Y+51.05	3647 L Y+16.	3748 L Y+39.	3849 L X+17.463 Y+36.424
3448 L Y+52.3	3549 L Y+52.3	3648 L X+49.	3749 L X+16.097 Y+38.244 FQ4	3850 L X+18.176 Y+36.116
3449 L X+30.7	3550 L X+27.7	3649 L Y+64.	3750 L X+16.371 Y+37.555	3851 L X+19. Y+36.
3450 L Z+15. FQ4	3551 L Y+27.7	3650 L X+16.	3751 L X+16.637 Y+37.151	3852 L Z+15.
3451 L Y+49.8 FMAX	3552 L X+37.3	3651 L Y+40.	3752 L X+16.961 Y+36.8	3853 L Y+44. FMAX
3452 L Z-11.2 FQ3	3553 L Y+52.3	3652 L Y+39.	3753 L X+17.463 Y+36.424	3854 L Z-2.5 FQ3
3453 L X+30.2	3554 L X+30.7	3653 L X+16.097 Y+38.244 FQ4	3754 L X+18.176 Y+36.116	3855 L X+18.244 Y+43.903
3454 L Y+30.2	3555 L Z+15. FQ4	3654 L X+16.371 Y+37.555	3755 L X+19. Y+36.	3856 L X+17.555 Y+43.629
3455 L X+34.8	3556 M129	3655 L X+16.637 Y+37.151	3756 L Z+15.	3857 L X+17.151 Y+43.363
3456 L Y+49.8	3557 L B+0 C+0 R0 FMAX	3656 L X+16.961 Y+36.8	3757 L Y+44. FMAX	3858 L X+16.8 Y+43.039
3457 L X+30.7	3558 TOOL CALL 2 Z S16000	3657 L X+17.463 Y+36.424	3758 L Z-1.731 FQ3	3859 L X+16.424 Y+42.537
3458 L Y+51.05	3559 CALL LBL 1	3658 L X+18.176 Y+36.116	3759 L X+18.244 Y+43.903	3860 L X+16.116 Y+41.824
3459 L Y+52.3	3560 L M126 ; DREHACHSEN	3659 L X+19. Y+36.	3760 L X+17.555 Y+43.629	3861 L X+16. Y+41.
3460 L X+27.7	WEGOPTIMIERT EIN	3660 L Z+15.	3761 L X+17.151 Y+43.363	3862 L Y+40.
3461 L Y+27.7	3561 L A0. R0 FMAX	3661 L Y+44. FMAX	3762 L X+16.8 Y+43.039	3863 L Y+16.
3462 L X+37.3	3562 L M128 ; TCPM ON	3662 L Z-962 FQ3	3763 L X+16.424 Y+42.537	3864 L X+49.
3463 L Y+52.3	3563 L X+0.0 Y+0.0 Z+100.	3663 L X+18.244 Y+43.903	3764 L X+16.116 Y+41.824	3865 L Y+64.
3464 L X+30.7	FMAX M13	3664 L X+17.555 Y+43.629	3765 L X+16. Y+41.	3866 L X+16.
3465 L Z+15. FQ4	3564 L X+19. Y+44. FMAX	3665 L X+17.151 Y+43.363	3766 L Y+40.	3867 L Y+40.
3466 L Y+49.8 FMAX	3565 L Z+15. FMAX	3666 L X+16.8 Y+43.039	3767 L Y+16.	3868 L Y+39.
3467 L Z-11.333 FQ3	3566 L Z-.192 FQ3	3667 L X+16.424 Y+42.537	3768 L X+49.	3869 L X+16.097 Y+38.244 FQ4
3468 L X+30.2	3567 L X+18.244 Y+43.903	3668 L X+16.116 Y+41.824	3769 L Y+64.	3870 L X+16.371 Y+37.555
3469 L Y+30.2	3568 L X+17.555 Y+43.629	3669 L X+16. Y+41.	3770 L X+16.	3871 L X+16.637 Y+37.151
3470 L X+34.8	3569 L X+17.151 Y+43.363	3670 L Y+40.	3771 L Y+40.	3872 L X+16.961 Y+36.8
3471 L Y+49.8	3570 L X+16.8 Y+43.039	3671 L Y+16.	3772 L Y+39.	3873 L X+17.463 Y+36.424
3472 L X+30.7	3571 L X+16.424 Y+42.537	3672 L X+49.	3773 L X+16.097 Y+38.244 FQ4	3874 L X+18.176 Y+36.116
3473 L Y+51.05	3572 L X+16.116 Y+41.824	3673 L Y+64.	3774 L X+16.371 Y+37.555	3875 L X+19. Y+36.
3474 L Y+52.3	3573 L X+16. Y+41.	3674 L X+16.	3775 L X+16.637 Y+37.151	3876 L Z+15.
3475 L X+27.7	3574 L Y+40.	3675 L Y+40.	3776 L X+16.961 Y+36.8	3877 L Y+44. FMAX
3476 L Y+27.7	3575 L Y+16.	3676 L Y+39.	3777 L X+17.463 Y+36.424	3878 L Z-2.692 FQ3
3477 L X+37.3	3576 L X+49.	3677 L X+16.097 Y+38.244 FQ4	3778 L X+18.176 Y+36.116	3879 L X+18.244 Y+43.903
3478 L Y+52.3	3577 L Y+64.	3678 L X+16.371 Y+37.555	3779 L X+19. Y+36.	3880 L X+17.555 Y+43.629
3479 L X+30.7	3578 L X+16.	3679 L X+16.637 Y+37.151	3780 L Z+15.	3881 L X+17.151 Y+43.363
3480 L Z+15. FQ4	3579 L Y+40.	3680 L X+16.961 Y+36.8	3781 L Y+44. FMAX	3882 L X+16.8 Y+43.039
3481 L Y+49.8 FMAX	3580 L Y+39.	3681 L X+17.463 Y+36.424	3782 L Z-1.923 FQ3	3883 L X+16.424 Y+42.537
3482 L Z-11.467 FQ3	3581 L X+16.097 Y+38.244 FQ4	3682 L X+18.176 Y+36.116	3783 L X+18.244 Y+43.903	3884 L X+16.116 Y+41.824
3483 L X+30.2	3582 L X+16.371 Y+37.555	3683 L X+19. Y+36.	3784 L X+17.555 Y+43.629	3885 L X+16. Y+41.
3484 L Y+30.2	3583 L X+16.637 Y+37.151	3684 L Z+15.	3785 L X+17.151 Y+43.363	3886 L Y+40.
3485 L X+34.8	3584 L X+16.961 Y+36.8	3685 L Y+44. FMAX	3786 L X+16.8 Y+43.039	3887 L Y+16.
3486 L Y+49.8	3585 L X+17.463 Y+36.424	3686 L Z-1.154 FQ3	3787 L X+16.424 Y+42.537	3888 L X+49.
3487 L X+30.7	3586 L X+18.176 Y+36.116	3687 L X+18.244 Y+43.903	3788 L X+16.116 Y+41.824	3889 L Y+64.
3488 L Y+51.05	3587 L X+19. Y+36.	3688 L X+17.555 Y+43.629	3789 L X+16. Y+41.	3890 L X+16.
3489 L Y+52.3	3588 L Z+15.	3689 L X+17.151 Y+43.363	3790 L Y+40.	3891 L Y+40.
3490 L X+27.7	3589 L Y+44. FMAX	3690 L X+16.8 Y+43.039	3791 L Y+16.	3892 L Y+39.
3491 L Y+27.7	3590 L Z-.385 FQ3	3691 L X+16.424 Y+42.537	3792 L X+49.	3893 L X+16.097 Y+38.244 FQ4
3492 L X+37.3	3591 L X+18.244 Y+43.903	3692 L X+16.116 Y+41.824	3793 L Y+64.	3894 L X+16.371 Y+37.555
3493 L Y+52.3	3592 L X+17.555 Y+43.629	3693 L X+16. Y+41.	3794 L X+16.	3895 L X+16.637 Y+37.151
3494 L X+30.7	3593 L X+17.151 Y+43.363	3694 L Y+40.	3795 L Y+40.	3896 L X+16.961 Y+36.8
3495 L Z+15. FQ4	3594 L X+16.8 Y+43.039	3695 L Y+16.	3796 L Y+39.	3897 L X+17.463 Y+36.424
3496 L Y+49.8 FMAX	3595 L X+16.424 Y+42.537	3696 L X+49.	3797 L X+16.097 Y+38.244 FQ4	3898 L X+18.176 Y+36.116
3497 L Z-11.6 FQ3	3596 L X+16.116 Y+41.824	3697 L Y+64.	3798 L X+16.371 Y+37.555	3899 L X+19. Y+36.
3498 L X+30.2	3597 L X+16. Y+41.	3698 L X+16.	3799 L X+16.637 Y+37.151	3900 L Z+15.
3499 L Y+30.2	3598 L Y+40.	3699 L Y+40.	3800 L X+16.961 Y+36.8	3901 L Y+44. FMAX
3500 L X+34.8	3599 L Y+16.	3700 L Y+39.	3801 L X+17.463 Y+36.424	3902 L Z-2.885 FQ3
3501 L Y+49.8	3600 L X+49.	3701 L X+16.097 Y+38.244 FQ4	3802 L X+18.176 Y+36.116	3903 L X+18.244 Y+43.903
3502 L X+30.7	3601 L Y+64.	3702 L X+16.371 Y+37.555	3803 L X+19. Y+36.	3904 L X+17.555 Y+43.629
3503 L Y+51.05	3602 L X+16.	3703 L X+16.637 Y+37.151	3804 L Z+15.	3905 L X+17.151 Y+43.363
3504 L Y+52.3	3603 L Y+40.	3704 L X+16.961 Y+36.8	3805 L Y+44. FMAX	3906 L X+16.8 Y+43.039
3505 L X+27.7	3604 L Y+39.	3705 L X+17.463 Y+36.424	3806 L Z-2.115 FQ3	3907 L X+16.424 Y+42.537
3506 L Y+27.7	3605 L X+16.097 Y+38.244 FQ4	3706 L X+18.176 Y+36.116	3807 L X+18.244 Y+43.903	3908 L X+16.116 Y+41.824
3507 L X+37.3	3606 L X+16.371 Y+37.555	3707 L X+19. Y+36.	3808 L X+17.555 Y+43.629	3909 L X+16. Y+41.
3508 L Y+52.3	3607 L X+16.637 Y+37.151	3708 L Z+15.	3809 L X+17.151 Y+43.363	3910 L Y+40.
3509 L X+30.7	3608 L X+16.961 Y+36.8	3709 L Y+44. FMAX	3810 L X+16.8 Y+43.039	3911 L Y+16.
3510 L Z+15. FQ4	3609 L X+17.463 Y+36.424	3710 L Z-1.346 FQ3	3811 L X+16.424 Y+42.537	3912 L X+49.
3511 L Y+49.8 FMAX	3610 L X+18.176 Y+36.116	3711 L X+18.244 Y+43.903	3812 L X+16.116 Y+41.824	3913 L Y+64.
3512 L Z-11.733 FQ3	3611 L X+19. Y+36.	3712 L X+17.555 Y+43.629	3813 L X+16. Y+41.	3914 L X+16.
3513 L X+30.2	3612 L Z+15.	3713 L X+17.151 Y+43.363	3814 L Y+40.	3915 L Y+40.
3514 L Y+30.2	3613 L Y+44. FMAX	3714 L X+16.8 Y+43.039	3815 L Y+16.	3916 L Y+39.
3515 L X+34.8	3614 L Z-.577 FQ3	3715 L X+16.424 Y+42.537	3816 L X+49.	3917 L X+16.097 Y+38.244 FQ4
3516 L Y+49.8	3615 L X+18.244 Y+43.903	3716 L X+16.116 Y+41.824	3817 L Y+64.	3918 L X+16.371 Y+37.555
3517 L X+30.7	3616 L X+17.555 Y+43.629	3717 L X+16. Y+41.	3818 L X+16.	3919 L X+16.637 Y+37.151
3518 L Y+51.05	3617 L X+17.151 Y+43.363	3718 L Y+40.	3819 L Y+40.	3920 L X+16.961 Y+36.8
3519 L Y+52.3	3618 L X+16.8 Y+43.039	3719 L Y+16.	3820 L Y+39.	3921 L X+17.463 Y+36.424
3520 L X+27.7	3619 L X+16.424 Y+42.537	3720 L X+49.	3821 L X+16.097 Y+38.244 FQ4	3922 L X+18.176 Y+36.116
3521 L Y+27.7	3620 L X+16.116 Y+41.824	3721 L Y+64.	3822 L X+16.371 Y+37.555	3923 L X+19. Y+36.
3522 L X+37.3	3621 L X+16. Y+41.	3722 L X+16.	3823 L X+16.637 Y+37.151	3924 L Z+15.
3523 L Y+52.3	3622 L Y+40.	3723 L Y+40.	3824 L X+16.961 Y+36.8	3925 L Y+44. FMAX
3524 L X+30.7	3623 L Y+16.	3724 L Y+39.	3825 L X+17.463 Y+36.424	3926 L Z-3.077 FQ3

3927 L X+18.244 Y+43.903
 3928 L X+17.555 Y+43.629
 3929 L X+17.151 Y+43.363
 3930 L X+16.8 Y+43.039
 3931 L X+16.424 Y+42.537
 3932 L X+16.116 Y+41.824
 3933 L X+16. Y+41.
 3934 L Y+40.
 3935 L Y+16.
 3936 L X+49.
 3937 L Y+64.
 3938 L X+16.
 3939 L Y+40.
 3940 L Y+39.
 3941 L X+16.097 Y+38.244 FQ4
 3942 L X+16.371 Y+37.555
 3943 L X+16.637 Y+37.151
 3944 L X+16.961 Y+36.8
 3945 L X+17.463 Y+36.424
 3946 L X+18.176 Y+36.116
 3947 L X+19. Y+36.
 3948 L Z+15.
 3949 L Y+44. FMAX
 3950 L Z-3.269 FQ3
 3951 L X+18.244 Y+43.903
 3952 L X+17.555 Y+43.629
 3953 L X+17.151 Y+43.363
 3954 L X+16.8 Y+43.039
 3955 L X+16.424 Y+42.537
 3956 L X+16.116 Y+41.824
 3957 L X+16. Y+41.
 3958 L Y+40.
 3959 L Y+16.
 3960 L X+49.
 3961 L Y+64.
 3962 L X+16.
 3963 L Y+40.
 3964 L Y+39.
 3965 L X+16.097 Y+38.244 FQ4
 3966 L X+16.371 Y+37.555
 3967 L X+16.637 Y+37.151
 3968 L X+16.961 Y+36.8
 3969 L X+17.463 Y+36.424
 3970 L X+18.176 Y+36.116
 3971 L X+19. Y+36.
 3972 L Z+15.
 3973 L Y+44. FMAX
 3974 L Z-3.462 FQ3
 3975 L X+18.244 Y+43.903
 3976 L X+17.555 Y+43.629
 3977 L X+17.151 Y+43.363
 3978 L X+16.8 Y+43.039
 3979 L X+16.424 Y+42.537
 3980 L X+16.116 Y+41.824
 3981 L X+16. Y+41.
 3982 L Y+40.
 3983 L Y+16.
 3984 L X+49.
 3985 L Y+64.
 3986 L X+16.
 3987 L Y+40.
 3988 L Y+39.
 3989 L X+16.097 Y+38.244 FQ4
 3990 L X+16.371 Y+37.555
 3991 L X+16.637 Y+37.151
 3992 L X+16.961 Y+36.8
 3993 L X+17.463 Y+36.424
 3994 L X+18.176 Y+36.116
 3995 L X+19. Y+36.
 3996 L Z+15.
 3997 L Y+44. FMAX
 3998 L Z-3.654 FQ3
 3999 L X+18.244 Y+43.903
 4000 L X+17.555 Y+43.629
 4001 L X+17.151 Y+43.363
 4002 L X+16.8 Y+43.039
 4003 L X+16.424 Y+42.537
 4004 L X+16.116 Y+41.824
 4005 L X+16. Y+41.
 4006 L Y+40.
 4007 L Y+16.
 4008 L X+49.
 4009 L Y+64.
 4010 L X+16.
 4011 L Y+40.
 4012 L Y+39.
 4013 L X+16.097 Y+38.244 FQ4
 4014 L X+16.371 Y+37.555
 4015 L X+16.637 Y+37.151
 4016 L X+16.961 Y+36.8
 4017 L X+17.463 Y+36.424
 4018 L X+18.176 Y+36.116
 4019 L X+19. Y+36.
 4020 L Z+15.
 4021 L Y+44. FMAX
 4022 L Z-3.846 FQ3
 4023 L X+18.244 Y+43.903
 4024 L X+17.555 Y+43.629
 4025 L X+17.151 Y+43.363
 4026 L X+16.8 Y+43.039
 4027 L X+16.424 Y+42.537
 4028 L X+16.116 Y+41.824
 4029 L X+16. Y+41.
 4030 L Y+40.
 4031 L Y+16.
 4032 L X+49.
 4033 L Y+64.
 4034 L X+16.
 4035 L Y+40.
 4036 L Y+39.
 4037 L X+16.097 Y+38.244 FQ4
 4038 L X+16.371 Y+37.555
 4039 L X+16.637 Y+37.151
 4040 L X+16.961 Y+36.8
 4041 L X+17.463 Y+36.424
 4042 L X+18.176 Y+36.116
 4043 L X+19. Y+36.
 4044 L Z+15.
 4045 L Y+44. FMAX
 4046 L Z-4.038 FQ3
 4047 L X+18.244 Y+43.903
 4048 L X+17.555 Y+43.629
 4049 L X+17.151 Y+43.363
 4050 L X+16.8 Y+43.039
 4051 L X+16.424 Y+42.537
 4052 L X+16.116 Y+41.824
 4053 L X+16. Y+41.
 4054 L Y+40.
 4055 L Y+16.
 4056 L X+49.
 4057 L Y+64.
 4058 L X+16.
 4059 L Y+40.
 4060 L Y+39.
 4061 L X+16.097 Y+38.244 FQ4
 4062 L X+16.371 Y+37.555
 4063 L X+16.637 Y+37.151
 4064 L X+16.961 Y+36.8
 4065 L X+17.463 Y+36.424
 4066 L X+18.176 Y+36.116
 4067 L X+19. Y+36.
 4068 L Z+15.
 4069 L Y+44. FMAX
 4070 L Z-4.231 FQ3
 4071 L X+18.244 Y+43.903
 4072 L X+17.555 Y+43.629
 4073 L X+17.151 Y+43.363
 4074 L X+16.8 Y+43.039
 4075 L X+16.424 Y+42.537
 4076 L X+16.116 Y+41.824
 4077 L X+16. Y+41.
 4078 L Y+40.
 4079 L Y+16.
 4080 L X+49.
 4081 L Y+64.
 4082 L X+16.
 4083 L Y+40.
 4084 L Y+39.
 4085 L X+16.097 Y+38.244 FQ4
 4086 L X+16.371 Y+37.555
 4087 L X+16.637 Y+37.151
 4088 L X+16.961 Y+36.8
 4089 L X+17.463 Y+36.424
 4090 L X+18.176 Y+36.116
 4091 L X+19. Y+36.
 4092 L Z+15.
 4093 L Y+44. FMAX
 4094 L Z-4.423 FQ3
 4095 L X+18.244 Y+43.903
 4096 L X+17.555 Y+43.629
 4097 L X+17.151 Y+43.363
 4098 L X+16.8 Y+43.039
 4099 L X+16.424 Y+42.537
 4100 L X+16.116 Y+41.824
 4101 L X+16. Y+41.
 4102 L Y+40.
 4103 L Y+16.
 4104 L X+49.
 4105 L Y+64.
 4106 L X+16.
 4107 L Y+40.
 4108 L Y+39.
 4109 L X+16.097 Y+38.244 FQ4
 4110 L X+16.371 Y+37.555
 4111 L X+16.637 Y+37.151
 4112 L X+16.961 Y+36.8
 4113 L X+17.463 Y+36.424
 4114 L X+18.176 Y+36.116
 4115 L X+19. Y+36.
 4116 L Z+15.
 4117 L Y+44. FMAX
 4118 L Z-4.615 FQ3
 4119 L X+18.244 Y+43.903
 4120 L X+17.555 Y+43.629
 4121 L X+17.151 Y+43.363
 4122 L X+16.8 Y+43.039
 4123 L X+16.424 Y+42.537
 4124 L X+16.116 Y+41.824
 4125 L X+16. Y+41.
 4126 L Y+40.
 4127 L Y+16.
 4128 L X+49.
 4129 L Y+64.
 4130 L X+16.
 4131 L Y+40.
 4132 L Y+39.
 4133 L X+16.097 Y+38.244 FQ4
 4134 L X+16.371 Y+37.555
 4135 L X+16.637 Y+37.151
 4136 L X+16.961 Y+36.8
 4137 L X+17.463 Y+36.424
 4138 L X+18.176 Y+36.116
 4139 L X+19. Y+36.
 4140 L Z+15.
 4141 L Y+44. FMAX
 4142 L Z-4.808 FQ3
 4143 L X+18.244 Y+43.903
 4144 L X+17.555 Y+43.629
 4145 L X+17.151 Y+43.363
 4146 L X+16.8 Y+43.039
 4147 L X+16.424 Y+42.537
 4148 L X+16.116 Y+41.824
 4149 L X+16. Y+41.
 4150 L Y+40.
 4151 L Y+16.
 4152 L X+49.
 4153 L Y+64.
 4154 L X+16.
 4155 L Y+40.
 4156 L Y+39.
 4157 L X+16.097 Y+38.244 FQ4
 4158 L X+16.371 Y+37.555
 4159 L X+16.637 Y+37.151
 4160 L X+16.961 Y+36.8
 4161 L X+17.463 Y+36.424
 4162 L X+18.176 Y+36.116
 4163 L X+19. Y+36.
 4164 L Z+15.
 4165 L Y+44. FMAX
 4166 L Z-5. FQ3
 4167 L X+18.244 Y+43.903
 4168 L X+17.555 Y+43.629
 4169 L X+17.151 Y+43.363
 4170 L X+16.8 Y+43.039
 4171 L X+16.424 Y+42.537
 4172 L X+16.116 Y+41.824
 4173 L X+16. Y+41.
 4174 L Y+40.
 4175 L Y+16.
 4176 L X+49.
 4177 L Y+64.
 4178 L X+16.
 4179 L Y+40.
 4180 L Y+39.
 4181 L X+16.097 Y+38.244 FQ4
 4182 L X+16.371 Y+37.555
 4183 L X+16.637 Y+37.151
 4184 L X+16.961 Y+36.8
 4185 L X+17.463 Y+36.424
 4186 L X+18.176 Y+36.116
 4187 L X+19. Y+36.
 4188 L Z+15.
 4189 L Y+44. FMAX
 4190 L Z-5.192 FQ3
 4191 L X+18.244 Y+43.903
 4192 L X+17.555 Y+43.629
 4193 L X+17.151 Y+43.363
 4194 L X+16.8 Y+43.039
 4195 L X+16.424 Y+42.537
 4196 L X+16.116 Y+41.824
 4197 L X+16. Y+41.
 4198 L Y+40.
 4199 L Y+16.
 4200 L X+49.
 4201 L Y+64.
 4202 L X+16.
 4203 L Y+40.
 4204 L Y+39.
 4205 L X+16.097 Y+38.244 FQ4
 4206 L X+16.371 Y+37.555
 4207 L X+16.637 Y+37.151
 4208 L X+16.961 Y+36.8
 4209 L X+17.463 Y+36.424
 4210 L X+18.176 Y+36.116
 4211 L X+19. Y+36.
 4212 L Z+15.
 4213 L Y+44. FMAX
 4214 L Z-5.385 FQ3
 4215 L X+18.244 Y+43.903
 4216 L X+17.555 Y+43.629
 4217 L X+17.151 Y+43.363
 4218 L X+16.8 Y+43.039
 4219 L X+16.424 Y+42.537
 4220 L X+16.116 Y+41.824
 4221 L X+16. Y+41.
 4222 L Y+40.
 4223 L Y+16.
 4224 L X+49.
 4225 L Y+64.
 4226 L X+16.
 4227 L Y+40.
 4228 L Y+39.
 4229 L X+16.097 Y+38.244 FQ4
 4230 L X+16.371 Y+37.555
 4231 L X+16.637 Y+37.151
 4232 L X+16.961 Y+36.8
 4233 L X+17.463 Y+36.424
 4234 L X+18.176 Y+36.116
 4235 L X+19. Y+36.
 4236 L Z+15.
 4237 L Y+44. FMAX
 4238 L Z-5.577 FQ3
 4239 L X+18.244 Y+43.903
 4240 L X+17.555 Y+43.629
 4241 L X+17.151 Y+43.363
 4242 L X+16.8 Y+43.039
 4243 L X+16.424 Y+42.537
 4244 L X+16.116 Y+41.824
 4245 L X+16. Y+41.
 4246 L Y+40.
 4247 L Y+16.
 4248 L X+49.
 4249 L Y+64.
 4250 L X+16.
 4251 L Y+40.
 4252 L Y+39.
 4253 L X+16.097 Y+38.244 FQ4
 4254 L X+16.371 Y+37.555
 4255 L X+16.637 Y+37.151
 4256 L X+16.961 Y+36.8
 4257 L X+17.463 Y+36.424
 4258 L X+18.176 Y+36.116
 4259 L X+19. Y+36.
 4260 L Z+15.
 4261 L Y+44. FMAX
 4262 L Z-5.769 FQ3
 4263 L X+18.244 Y+43.903
 4264 L X+17.555 Y+43.629
 4265 L X+17.151 Y+43.363
 4266 L X+16.8 Y+43.039
 4267 L X+16.424 Y+42.537
 4268 L X+16.116 Y+41.824
 4269 L X+16. Y+41.
 4270 L Y+40.
 4271 L Y+16.
 4272 L X+49.
 4273 L Y+64.
 4274 L X+16.
 4275 L Y+40.
 4276 L Y+39.
 4277 L X+16.097 Y+38.244 FQ4
 4278 L X+16.371 Y+37.555
 4279 L X+16.637 Y+37.151
 4280 L X+16.961 Y+36.8
 4281 L X+17.463 Y+36.424
 4282 L X+18.176 Y+36.116
 4283 L X+19. Y+36.
 4284 L Z+15.
 4285 L Y+44. FMAX
 4286 L Z-5.962 FQ3
 4287 L X+18.244 Y+43.903
 4288 L X+17.555 Y+43.629
 4289 L X+17.151 Y+43.363
 4290 L X+16.8 Y+43.039
 4291 L X+16.424 Y+42.537
 4292 L X+16.116 Y+41.824
 4293 L X+16. Y+41.
 4294 L Y+40.
 4295 L Y+16.
 4296 L X+49.
 4297 L Y+64.
 4298 L X+16.
 4299 L Y+40.
 4300 L Y+39.
 4301 L X+16.097 Y+38.244 FQ4
 4302 L X+16.371 Y+37.555
 4303 L X+16.637 Y+37.151
 4304 L X+16.961 Y+36.8
 4305 L X+17.463 Y+36.424
 4306 L X+18.176 Y+36.116
 4307 L X+19. Y+36.
 4308 L Z+15.
 4309 L Y+44. FMAX
 4310 L Z-6.154 FQ3
 4311 L X+18.244 Y+43.903
 4312 L X+17.555 Y+43.629
 4313 L X+17.151 Y+43.363
 4314 L X+16.8 Y+43.039
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 4317 L X+16. Y+41.
 4318 L Y+40.
 4319 L Y+16.
 4320 L X+49.
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 4322 L X+16.
 4323 L Y+40.
 4324 L Y+39.
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 4326 L X+16.371 Y+37.555
 4327 L X+16.637 Y+37.151
 4328 L X+16.961 Y+36.8
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 4330 L X+18.176 Y+36.116
 4331 L X+19. Y+36.
 4332 L Z+15.
 4333 L Y+44. FMAX
 4334 L Z-6.346 FQ3
 4335 L X+18.244 Y+43.903
 4336 L X+17.555 Y+43.629
 4337 L X+17.151 Y+43.363
 4338 L X+16.8 Y+43.039
 4339 L X+16.424 Y+42.537
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 4342 L Y+40.
 4343 L Y+16.
 4344 L X+49.
 4345 L Y+64.
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 4347 L Y+40.
 4348 L Y+39.
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 4350 L X+16.371 Y+37.555
 4351 L X+16.637 Y+37.151
 4352 L X+16.961 Y+36.8
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 4354 L X+18.176 Y+36.116
 4355 L X+19. Y+36.
 4356 L Z+15.
 4357 L Y+44. FMAX
 4358 L Z-6.538 FQ3
 4359 L X+18.244 Y+43.903
 4360 L X+17.555 Y+43.629
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 4362 L X+16.8 Y+43.039
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 4365 L X+16. Y+41.
 4366 L Y+40.
 4367 L Y+16.
 4368 L X+49.
 4369 L Y+64.
 4370 L X+16.
 4371 L Y+40.
 4372 L Y+39.
 4373 L X+16.097 Y+38.244 FQ4
 4374 L X+16.371 Y+37.555
 4375 L X+16.637 Y+37.151
 4376 L X+16.961 Y+36.8
 4377 L X+17.463 Y+36.424
 4378 L X+18.176 Y+36.116
 4379 L X+19. Y+36.
 4380 L Z+15.
 4381 L Y+44. FMAX
 4382 L Z-6.731 FQ3
 4383 L X+18.244 Y+43.903
 4384 L X+17.555 Y+43.629
 4385 L X+17.151 Y+43.363
 4386 L X+16.8 Y+43.039
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 4388 L X+16.116 Y+41.824
 4389 L X+16. Y+41.
 4390 L Y+40.
 4391 L Y+16.
 4392 L X+49.
 4393 L Y+64.
 4394 L X+16.
 4395 L Y+40.
 4396 L Y+39.
 4397 L X+16.097 Y+38.244 FQ4
 4398 L X+16.371 Y+37.555
 4399 L X+16.637 Y+37.151
 4400 L X+16.961 Y+36.8
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 4403 L X+19. Y+36.
 4404 L Z+15.
 4405 L Y+44. FMAX
 4406 L Z-6.923 FQ3
 4407 L X+18.244 Y+43.903
 4408 L X+17.555 Y+43.629
 4409 L X+17.151 Y+43.363
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 4417 L Y+64.
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 4419 L Y+40.
 4420 L Y+39.
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 4422 L X+16.371 Y+37.555
 4423 L X+16.637 Y+37.151
 4424 L X+16.961 Y+36.8
 4425 L X+17.463 Y+36.424
 4426 L X+18.176 Y+36.116
 4427 L X+19. Y+36.
 4428 L Z+15.
 4429 L Y+44. FMAX
 4430 L Z-7.115 FQ3
 4431 L X+18.244 Y+43.903

4432 L X+17.555 Y+43.629
4433 L X+17.151 Y+43.363
4434 L X+16.8 Y+43.039
4435 L X+16.424 Y+42.537
4436 L X+16.116 Y+41.824
4437 L X+16. Y+41.
4438 L Y+40.
4439 L Y+16.
4440 L X+49.
4441 L Y+64.
4442 L X+16.
4443 L Y+40.
4444 L Y+39.
4445 L X+16.097 Y+38.244 FQ4
4446 L X+16.371 Y+37.555
4447 L X+16.637 Y+37.151
4448 L X+16.961 Y+36.8
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4454 L Z-7.308 FQ3
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4467 L Y+40.
4468 L Y+39.
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4470 L X+16.371 Y+37.555
4471 L X+16.637 Y+37.151
4472 L X+16.961 Y+36.8
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4474 L X+18.176 Y+36.116
4475 L X+19. Y+36.
4476 L Z+15.
4477 L Y+44. FMAX
4478 L Z-7.5 FQ3
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4481 L X+17.151 Y+43.363
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4488 L X+49.
4489 L Y+64.
4490 L X+16.
4491 L Y+40.
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4496 L X+16.961 Y+36.8
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4522 L X+18.176 Y+36.116
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4524 L Z+15.
4525 L Y+44. FMAX
4526 L Z-7.885 FQ3
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4532 L X+16.116 Y+41.824

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4534 L Y+40.
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4536 L X+49.
4537 L Y+64.
4538 L X+16.
4539 L Y+40.
4540 L Y+39.
4541 L X+16.097 Y+38.244 FQ4
4542 L X+16.371 Y+37.555
4543 L X+16.637 Y+37.151
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4546 L X+18.176 Y+36.116
4547 L X+19. Y+36.
4548 L Z+15.
4549 L Y+44. FMAX
4550 L Z-8.077 FQ3
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4557 L X+16. Y+41.
4558 L Y+40.
4559 L Y+16.
4560 L X+49.
4561 L Y+64.
4562 L X+16.
4563 L Y+40.
4564 L Y+39.
4565 L X+16.097 Y+38.244 FQ4
4566 L X+16.371 Y+37.555
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4574 L Z-8.269 FQ3
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4585 L Y+64.
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4587 L Y+40.
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4591 L X+16.637 Y+37.151
4592 L X+16.961 Y+36.8
4593 L X+17.463 Y+36.424
4594 L X+18.176 Y+36.116
4595 L X+19. Y+36.
4596 L Z+15.
4597 L Y+44. FMAX
4598 L Z-8.462 FQ3
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4601 L X+17.151 Y+43.363
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4604 L X+16.116 Y+41.824
4605 L X+16. Y+41.
4606 L Y+40.
4607 L Y+16.
4608 L X+49.
4609 L Y+64.
4610 L X+16.
4611 L Y+40.
4612 L Y+39.
4613 L X+16.097 Y+38.244 FQ4
4614 L X+16.371 Y+37.555
4615 L X+16.637 Y+37.151
4616 L X+16.961 Y+36.8
4617 L X+17.463 Y+36.424
4618 L X+18.176 Y+36.116
4619 L X+19. Y+36.
4620 L Z+15.
4621 L Y+44. FMAX
4622 L Z-8.654 FQ3
4623 L X+18.244 Y+43.903
4624 L X+17.555 Y+43.629
4625 L X+17.151 Y+43.363
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4628 L X+16.116 Y+41.824
4629 L X+16. Y+41.
4630 L Y+40.
4631 L Y+16.
4632 L X+49.
4633 L Y+64.

4634 L X+16.
4635 L Y+40.
4636 L Y+39.
4637 L X+16.097 Y+38.244 FQ4
4638 L X+16.371 Y+37.555
4639 L X+16.637 Y+37.151
4640 L X+16.961 Y+36.8
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4642 L X+18.176 Y+36.116
4643 L X+19. Y+36.
4644 L Z+15.
4645 L Y+44. FMAX
4646 L Z-8.846 FQ3
4647 L X+18.244 Y+43.903
4648 L X+17.555 Y+43.629
4649 L X+17.151 Y+43.363
4650 L X+16.8 Y+43.039
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4652 L X+16.116 Y+41.824
4653 L X+16. Y+41.
4654 L Y+40.
4655 L Y+16.
4656 L X+49.
4657 L Y+64.
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4659 L Y+40.
4660 L Y+39.
4661 L X+16.097 Y+38.244 FQ4
4662 L X+16.371 Y+37.555
4663 L X+16.637 Y+37.151
4664 L X+16.961 Y+36.8
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4666 L X+18.176 Y+36.116
4667 L X+19. Y+36.
4668 L Z+15.
4669 L Y+44. FMAX
4670 L Z-9.038 FQ3
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4672 L X+17.555 Y+43.629
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4675 L X+16.424 Y+42.537
4676 L X+16.116 Y+41.824
4677 L X+16. Y+41.
4678 L Y+40.
4679 L Y+16.
4680 L X+49.
4681 L Y+64.
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4683 L Y+40.
4684 L Y+39.
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4686 L X+16.371 Y+37.555
4687 L X+16.637 Y+37.151
4688 L X+16.961 Y+36.8
4689 L X+17.463 Y+36.424
4690 L X+18.176 Y+36.116
4691 L X+19. Y+36.
4692 L Z+15.
4693 L Y+44. FMAX
4694 L Z-9.231 FQ3
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4696 L X+17.555 Y+43.629
4697 L X+17.151 Y+43.363
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4701 L X+16. Y+41.
4702 L Y+40.
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4705 L Y+64.
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4707 L Y+40.
4708 L Y+39.
4709 L X+16.097 Y+38.244 FQ4
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4714 L X+18.176 Y+36.116
4715 L X+19. Y+36.
4716 L Z+15.
4717 L Y+44. FMAX
4718 L Z-9.423 FQ3
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4720 L X+17.555 Y+43.629
4721 L X+17.151 Y+43.363
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4725 L X+16. Y+41.
4726 L Y+40.
4727 L Y+16.
4728 L X+49.
4729 L Y+64.
4730 L X+16.
4731 L Y+40.
4732 L Y+39.
4733 L X+16.097 Y+38.244 FQ4
4734 L X+16.371 Y+37.555

4735 L X+16.637 Y+37.151
4736 L X+16.961 Y+36.8
4737 L X+17.463 Y+36.424
4738 L X+18.176 Y+36.116
4739 L X+19. Y+36.
4740 L Z+15.
4741 L Y+44. FMAX
4742 L Z-9.615 FQ3
4743 L X+18.244 Y+43.903
4744 L X+17.555 Y+43.629
4745 L X+17.151 Y+43.363
4746 L X+16.8 Y+43.039
4747 L X+16.424 Y+42.537
4748 L X+16.116 Y+41.824
4749 L X+16. Y+41.
4750 L Y+40.
4751 L Y+16.
4752 L X+49.
4753 L Y+64.
4754 L X+16.
4755 L Y+40.
4756 L Y+39.
4757 L X+16.097 Y+38.244 FQ4
4758 L X+16.371 Y+37.555
4759 L X+16.637 Y+37.151
4760 L X+16.961 Y+36.8
4761 L X+17.463 Y+36.424
4762 L X+18.176 Y+36.116
4763 L X+19. Y+36.
4764 L Z+15.
4765 L Y+44. FMAX
4766 L Z-9.808 FQ3
4767 L X+18.244 Y+43.903
4768 L X+17.555 Y+43.629
4769 L X+17.151 Y+43.363
4770 L X+16.8 Y+43.039
4771 L X+16.424 Y+42.537
4772 L X+16.116 Y+41.824
4773 L X+16. Y+41.
4774 L Y+40.
4775 L Y+16.
4776 L X+49.
4777 L Y+64.
4778 L X+16.
4779 L Y+40.
4780 L Y+39.
4781 L X+16.097 Y+38.244 FQ4
4782 L X+16.371 Y+37.555
4783 L X+16.637 Y+37.151
4784 L X+16.961 Y+36.8
4785 L X+17.463 Y+36.424
4786 L X+18.176 Y+36.116
4787 L X+19. Y+36.
4788 L Z+15.
4789 L Y+44. FMAX
4790 L Z-10. FQ3
4791 L X+18.244 Y+43.903
4792 L X+17.555 Y+43.629
4793 L X+17.151 Y+43.363
4794 L X+16.8 Y+43.039
4795 L X+16.424 Y+42.537
4796 L X+16.116 Y+41.824
4797 L X+16. Y+41.
4798 L Y+40.
4799 L Y+16.
4800 L X+49.
4801 L Y+64.
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4803 L Y+40.
4804 L Y+39.
4805 L X+16.097 Y+38.244 FQ4
4806 L X+16.371 Y+37.555
4807 L X+16.637 Y+37.151
4808 L X+16.961 Y+36.8
4809 L X+17.463 Y+36.424
4810 L X+18.176 Y+36.116
4811 L X+19. Y+36.
4812 L Z+15.
4813 L X+0.0 Y+0.0 Z+100.
4814 L X+29. Y+44. FMAX
4815 L Z+15. FMAX
4816 L Z-10.033 FQ3
4817 L X+28.244 Y+43.903
4818 L X+27.555 Y+43.629
4819 L X+27.151 Y+43.363
4820 L X+26.8 Y+43.039
4821 L X+26.424 Y+42.537
4822 L X+26.116 Y+41.824
4823 L X+26. Y+41.
4824 L Y+40.
4825 L Y+26.
4826 L X+39.
4827 L Y+54.
4828 L X+26.
4829 L Y+40.
4830 L Y+39.
4831 L X+26.097 Y+38.244 FQ4
4832 L X+26.371 Y+37.555
4833 L X+26.637 Y+37.151
4834 L X+26.961 Y+36.8

4835 L X+27.463 Y+36.424
4836 L X+28.176 Y+36.116
4837 L X+29. Y+36.
4838 L Z+15.
4839 L Y+44. FMAX
4840 L Z-10.067 FQ3
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4843 L X+27.151 Y+43.363
4844 L X+26.8 Y+43.039
4845 L X+26.424 Y+42.537
4846 L X+26.116 Y+41.824
4847 L X+26. Y+41.
4848 L Y+40.
4849 L Y+26.
4850 L X+39.
4851 L Y+54.
4852 L X+26.
4853 L Y+40.
4854 L Y+39.
4855 L X+26.097 Y+38.244 FQ4
4856 L X+26.371 Y+37.555
4857 L X+26.637 Y+37.151
4858 L X+26.961 Y+36.8
4859 L X+27.463 Y+36.424
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4861 L X+29. Y+36.
4862 L Z+15.
4863 L Y+44. FMAX
4864 L Z-10.1 FQ3
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4868 L X+26.8 Y+43.039
4869 L X+26.424 Y+42.537
4870 L X+26.116 Y+41.824
4871 L X+26. Y+41.
4872 L Y+40.
4873 L Y+26.
4874 L X+39.
4875 L Y+54.
4876 L X+26.
4877 L Y+40.
4878 L Y+39.
4879 L X+26.097 Y+38.244 FQ4
4880 L X+26.371 Y+37.555
4881 L X+26.637 Y+37.151
4882 L X+26.961 Y+36.8
4883 L X+27.463 Y+36.424
4884 L X+28.176 Y+36.116
4885 L X+29. Y+36.
4886 L Z+15.
4887 L Y+44. FMAX
4888 L Z-10.133 FQ3
4889 L X+28.244 Y+43.903
4890 L X+27.555 Y+43.629
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4892 L X+26.8 Y+43.039
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4896 L Y+40.
4897 L Y+26.
4898 L X+39.
4899 L Y+54.
4900 L X+26.
4901 L Y+40.
4902 L Y+39.
4903 L X+26.097 Y+38.244 FQ4
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4906 L X+26.961 Y+36.8
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4908 L X+28.176 Y+36.116
4909 L X+29. Y+36.
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4911 L Y+44. FMAX
4912 L Z-10.167 FQ3
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4914 L X+27.555 Y+43.629
4915 L X+27.151 Y+43.363
4916 L X+26.8 Y+43.039
4917 L X+26.424 Y+42.537
4918 L X+26.116 Y+41.824
4919 L X+26. Y+41.
4920 L Y+40.
4921 L Y+26.
4922 L X+39.
4923 L Y+54.
4924 L X+26.
4925 L Y+40.
4926 L Y+39.
4927 L X+26.097 Y+38.244 FQ4
4928 L X+26.371 Y+37.555
4929 L X+26.637 Y+37.151
4930 L X+26.961 Y+36.8
4931 L X+27.463 Y+36.424
4932 L X+28.176 Y+36.116
4933 L X+29. Y+36.
4934 L Z+15.
4935 L Y+44. FMAX

4936 L Z-10.2 FQ3
4937 L X+28.244 Y+43.903
4938 L X+27.555 Y+43.629
4939 L X+27.151 Y+43.363
4940 L X+26.8 Y+43.039
4941 L X+26.424 Y+42.537
4942 L X+26.116 Y+41.824
4943 L X+26. Y+41.
4944 L Y+40.
4945 L Y+26.
4946 L X+39.
4947 L Y+54.
4948 L X+26.
4949 L Y+40.
4950 L Y+39.
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4952 L X+26.371 Y+37.555
4953 L X+26.637 Y+37.151
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4956 L X+28.176 Y+36.116
4957 L X+29. Y+36.
4958 L Z+15.
4959 L Y+44. FMAX
4960 L Z-10.233 FQ3
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4980 L X+28.176 Y+36.116
4981 L X+29. Y+36.
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4983 L Y+44. FMAX
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5125 L X+29. Y+36.
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5127 L Y+44. FMAX
5128 L Z-10.467 FQ3
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5137 L Y+26.

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5148 L X+28.176 Y+36.116
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5222 L Z+15.
5223 L Y+44. FMAX
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5227 L X+27.151 Y+43.363
5228 L X+26.8 Y+43.039
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5231 L X+26. Y+41.
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5237 L Y+40.
5238 L Y+39.

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5240 L X+26.371 Y+37.555
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5244 L X+28.176 Y+36.116
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5246 L Z+15.
5247 L Y+44. FMAX
5248 L Z-10.633 FQ3
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5263 L X+26.097 Y+38.244 FQ4
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5271 L Y+44. FMAX
5272 L Z-10.667 FQ3
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5290 L X+26.961 Y+36.8
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5293 L X+29. Y+36.
5294 L Z+15.
5295 L Y+44. FMAX
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5309 L Y+40.
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5318 L Z+15.
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5320 L Z-10.733 FQ3
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5338 L X+26.961 Y+36.8
5339 L X+27.463 Y+36.424

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5342 L Z+15.
5343 L Y+44. FMAX
5344 L Z-10.767 FQ3
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5429 L Y+40.
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5433 L X+26.637 Y+37.151
5434 L X+26.961 Y+36.8
5435 L X+27.463 Y+36.424
5436 L X+28.176 Y+36.116
5437 L X+29. Y+36.
5438 L Z+15.
5439 L Y+44. FMAX
5440 L Z-10.9 FQ3

5441 L X+28.244 Y+43.903	5542 L X+26.116 Y+41.824	5643 L Y+54.	5744 L X+26.371 Y+37.555	5845 L X+29. Y+36.
5442 L X+27.555 Y+43.629	5543 L X+26. Y+41.	5644 L X+26.	5745 L X+26.637 Y+37.151	5846 L X+29. Y+36.
5443 L X+27.151 Y+43.363	5544 L Y+40.	5645 L Y+40.	5746 L X+26.961 Y+36.8	5847 L Y+44. FMAX
5444 L X+26.8 Y+43.039	5545 L Y+26.	5646 L Y+39.	5747 L X+27.463 Y+36.424	5848 L Z-11.467 FQ3
5445 L X+26.424 Y+42.537	5546 L X+39.	5647 L X+26.097 Y+38.244 FQ4	5748 L X+28.176 Y+36.116	5849 L X+28.244 Y+43.903
5446 L X+26.116 Y+41.824	5547 L Y+54.	5648 L X+26.371 Y+37.555	5749 L X+29. Y+36.	5850 L X+27.555 Y+43.629
5447 L X+26. Y+41.	5548 L X+26.	5649 L X+26.637 Y+37.151	5750 L Z+15.	5851 L X+27.151 Y+43.363
5448 L Y+40.	5549 L Y+40.	5650 L X+26.961 Y+36.8	5751 L Y+44. FMAX	5852 L X+26.8 Y+43.039
5449 L Y+26.	5550 L Y+39.	5651 L X+27.463 Y+36.424	5752 L Z-11.333 FQ3	5853 L X+26.424 Y+42.537
5450 L X+39.	5551 L X+26.097 Y+38.244 FQ4	5652 L X+28.176 Y+36.116	5753 L X+28.244 Y+43.903	5854 L X+26.116 Y+41.824
5451 L Y+54.	5552 L X+26.371 Y+37.555	5653 L X+29. Y+36.	5754 L X+27.555 Y+43.629	5855 L X+26. Y+41.
5452 L X+26.	5553 L X+26.637 Y+37.151	5654 L Z+15.	5755 L X+27.151 Y+43.363	5856 L Y+40.
5453 L Y+40.	5554 L X+26.961 Y+36.8	5655 L Y+44. FMAX	5756 L X+26.8 Y+43.039	5857 L Y+26.
5454 L Y+39.	5555 L X+27.463 Y+36.424	5656 L Z-11.2 FQ3	5757 L X+26.424 Y+42.537	5858 L X+39.
5455 L X+26.097 Y+38.244 FQ4	5556 L X+28.176 Y+36.116	5657 L X+28.244 Y+43.903	5758 L X+26.116 Y+41.824	5859 L Y+54.
5456 L X+26.371 Y+37.555	5557 L X+29. Y+36.	5658 L X+27.555 Y+43.629	5759 L X+26. Y+41.	5860 L X+26.
5457 L X+26.637 Y+37.151	5558 L Z+15.	5659 L X+27.151 Y+43.363	5760 L Y+40.	5861 L Y+40.
5458 L X+26.961 Y+36.8	5559 L Y+44. FMAX	5660 L X+26.8 Y+43.039	5761 L Y+26.	5862 L Y+39.
5459 L X+27.463 Y+36.424	5560 L Z-11.067 FQ3	5661 L X+26.424 Y+42.537	5762 L X+39.	5863 L X+26.097 Y+38.244 FQ4
5460 L X+28.176 Y+36.116	5561 L X+28.244 Y+43.903	5662 L X+26.116 Y+41.824	5763 L Y+54.	5864 L X+26.371 Y+37.555
5461 L X+29. Y+36.	5562 L X+27.555 Y+43.629	5663 L X+26. Y+41.	5764 L X+26.	5865 L X+26.637 Y+37.151
5462 L Z+15.	5563 L X+27.151 Y+43.363	5664 L Y+40.	5765 L Y+40.	5866 L X+26.961 Y+36.8
5463 L Y+44. FMAX	5564 L X+26.8 Y+43.039	5665 L Y+26.	5766 L Y+39.	5867 L X+27.463 Y+36.424
5464 L Z-10.933 FQ3	5565 L X+26.424 Y+42.537	5666 L X+39.	5767 L X+26.097 Y+38.244 FQ4	5868 L X+28.176 Y+36.116
5465 L X+28.244 Y+43.903	5566 L X+26.116 Y+41.824	5667 L Y+54.	5768 L X+26.371 Y+37.555	5869 L X+29. Y+36.
5466 L X+27.555 Y+43.629	5567 L X+26. Y+41.	5668 L X+26.	5769 L X+26.637 Y+37.151	5870 L Z+15.
5467 L X+27.151 Y+43.363	5568 L Y+40.	5669 L Y+40.	5770 L X+26.961 Y+36.8	5871 L Y+44. FMAX
5468 L X+26.8 Y+43.039	5569 L Y+26.	5670 L Y+39.	5771 L X+27.463 Y+36.424	5872 L Z-11.5 FQ3
5469 L X+26.424 Y+42.537	5570 L X+39.	5671 L X+26.097 Y+38.244 FQ4	5772 L X+28.176 Y+36.116	5873 L X+28.244 Y+43.903
5470 L X+26.116 Y+41.824	5571 L Y+54.	5672 L X+26.371 Y+37.555	5773 L X+29. Y+36.	5874 L X+27.555 Y+43.629
5471 L X+26. Y+41.	5572 L X+26.	5673 L X+26.637 Y+37.151	5774 L Z+15.	5875 L X+27.151 Y+43.363
5472 L Y+40.	5573 L Y+40.	5674 L X+26.961 Y+36.8	5775 L Y+44. FMAX	5876 L X+26.8 Y+43.039
5473 L Y+26.	5574 L Y+39.	5675 L X+27.463 Y+36.424	5776 L Z-11.367 FQ3	5877 L X+26.424 Y+42.537
5474 L X+39.	5575 L X+26.097 Y+38.244 FQ4	5676 L X+28.176 Y+36.116	5777 L X+28.244 Y+43.903	5878 L X+26.116 Y+41.824
5475 L Y+54.	5576 L X+26.371 Y+37.555	5677 L X+29. Y+36.	5778 L X+27.555 Y+43.629	5879 L X+26. Y+41.
5476 L X+26.	5577 L X+26.637 Y+37.151	5678 L Z+15.	5779 L X+27.151 Y+43.363	5880 L Y+40.
5477 L Y+40.	5578 L X+26.961 Y+36.8	5679 L Y+44. FMAX	5780 L X+26.8 Y+43.039	5881 L Y+26.
5478 L Y+39.	5579 L X+27.463 Y+36.424	5680 L Z-11.233 FQ3	5781 L X+26.424 Y+42.537	5882 L X+39.
5479 L X+26.097 Y+38.244 FQ4	5580 L X+28.176 Y+36.116	5681 L X+28.244 Y+43.903	5782 L X+26.116 Y+41.824	5883 L Y+54.
5480 L X+26.371 Y+37.555	5581 L X+29. Y+36.	5682 L X+27.555 Y+43.629	5783 L X+26. Y+41.	5884 L X+26.
5481 L X+26.637 Y+37.151	5582 L Z+15.	5683 L X+27.151 Y+43.363	5784 L Y+40.	5885 L Y+40.
5482 L X+26.961 Y+36.8	5583 L Y+44. FMAX	5684 L X+26.8 Y+43.039	5785 L Y+26.	5886 L Y+39.
5483 L X+27.463 Y+36.424	5584 L Z-11.1 FQ3	5685 L X+26.424 Y+42.537	5786 L X+39.	5887 L X+26.097 Y+38.244 FQ4
5484 L X+28.176 Y+36.116	5585 L X+28.244 Y+43.903	5686 L X+26.116 Y+41.824	5787 L Y+54.	5888 L X+26.371 Y+37.555
5485 L X+29. Y+36.	5586 L X+27.555 Y+43.629	5687 L X+26. Y+41.	5788 L X+26.	5889 L X+26.637 Y+37.151
5486 L Z+15.	5587 L X+27.151 Y+43.363	5688 L Y+40.	5789 L Y+40.	5890 L X+26.961 Y+36.8
5487 L Y+44. FMAX	5588 L X+26.8 Y+43.039	5689 L Y+26.	5790 L Y+39.	5891 L X+27.463 Y+36.424
5488 L Z-10.967 FQ3	5589 L X+26.424 Y+42.537	5690 L X+39.	5791 L X+26.097 Y+38.244 FQ4	5892 L X+28.176 Y+36.116
5489 L X+28.244 Y+43.903	5590 L X+26.116 Y+41.824	5691 L Y+54.	5792 L X+26.371 Y+37.555	5893 L X+29. Y+36.
5490 L X+27.555 Y+43.629	5591 L X+26. Y+41.	5692 L X+26.	5793 L X+26.637 Y+37.151	5894 L Z+15.
5491 L X+27.151 Y+43.363	5592 L Y+40.	5693 L Y+40.	5794 L X+26.961 Y+36.8	5895 L Y+44. FMAX
5492 L X+26.8 Y+43.039	5593 L Y+26.	5694 L Y+39.	5795 L X+27.463 Y+36.424	5896 L Z-11.533 FQ3
5493 L X+26.424 Y+42.537	5594 L X+39.	5695 L X+26.097 Y+38.244 FQ4	5796 L X+28.176 Y+36.116	5897 L X+28.244 Y+43.903
5494 L X+26.116 Y+41.824	5595 L Y+54.	5696 L X+26.371 Y+37.555	5797 L X+29. Y+36.	5898 L X+27.555 Y+43.629
5495 L X+26. Y+41.	5596 L X+26.	5697 L X+26.637 Y+37.151	5798 L Z+15.	5899 L X+27.151 Y+43.363
5496 L Y+40.	5597 L Y+40.	5698 L X+26.961 Y+36.8	5799 L Y+44. FMAX	5900 L X+26.8 Y+43.039
5497 L Y+26.	5598 L Y+39.	5699 L X+27.463 Y+36.424	5800 L Z-11.4 FQ3	5901 L X+26.424 Y+42.537
5498 L X+39.	5599 L X+26.097 Y+38.244 FQ4	5700 L X+28.176 Y+36.116	5801 L X+28.244 Y+43.903	5902 L X+26.116 Y+41.824
5499 L Y+54.	5600 L X+26.371 Y+37.555	5701 L X+29. Y+36.	5802 L X+27.555 Y+43.629	5903 L X+26. Y+41.
5500 L X+26.	5601 L X+26.637 Y+37.151	5702 L Z+15.	5803 L X+27.151 Y+43.363	5904 L Y+40.
5501 L Y+40.	5602 L X+26.961 Y+36.8	5703 L Y+44. FMAX	5804 L X+26.8 Y+43.039	5905 L Y+26.
5502 L Y+39.	5603 L X+27.463 Y+36.424	5704 L Z-11.267 FQ3	5805 L X+26.424 Y+42.537	5906 L X+39.
5503 L X+26.097 Y+38.244 FQ4	5604 L X+28.176 Y+36.116	5705 L X+28.244 Y+43.903	5806 L X+26.116 Y+41.824	5907 L Y+54.
5504 L X+26.371 Y+37.555	5605 L X+29. Y+36.	5706 L X+27.555 Y+43.629	5807 L X+26. Y+41.	5908 L X+26.
5505 L X+26.637 Y+37.151	5606 L Z+15.	5707 L X+27.151 Y+43.363	5808 L Y+40.	5909 L Y+40.
5506 L X+26.961 Y+36.8	5607 L Y+44. FMAX	5708 L X+26.8 Y+43.039	5809 L Y+26.	5910 L Y+39.
5507 L X+27.463 Y+36.424	5608 L Z-11.133 FQ3	5709 L X+26.424 Y+42.537	5810 L X+39.	5911 L X+26.097 Y+38.244 FQ4
5508 L X+28.176 Y+36.116	5609 L X+28.244 Y+43.903	5710 L X+26.116 Y+41.824	5811 L Y+54.	5912 L X+26.371 Y+37.555
5509 L X+29. Y+36.	5610 L X+27.555 Y+43.629	5711 L X+26. Y+41.	5812 L X+26.	5913 L X+26.637 Y+37.151
5510 L Z+15.	5611 L X+27.151 Y+43.363	5712 L Y+40.	5813 L Y+40.	5914 L X+26.961 Y+36.8
5511 L Y+44. FMAX	5612 L X+26.8 Y+43.039	5713 L Y+26.	5814 L Y+39.	5915 L X+27.463 Y+36.424
5512 L Z-11.1 FQ3	5613 L X+26.424 Y+42.537	5714 L X+39.	5815 L X+26.097 Y+38.244 FQ4	5916 L X+28.176 Y+36.116
5513 L X+28.244 Y+43.903	5614 L X+26.116 Y+41.824	5715 L Y+54.	5816 L X+26.371 Y+37.555	5917 L X+29. Y+36.
5514 L X+27.555 Y+43.629	5615 L X+26. Y+41.	5716 L X+26.	5817 L X+26.637 Y+37.151	5918 L Z+15.
5515 L X+27.151 Y+43.363	5616 L Y+40.	5717 L Y+40.	5818 L X+26.961 Y+36.8	5919 L Y+44. FMAX
5516 L X+26.8 Y+43.039	5617 L Y+26.	5718 L Y+39.	5819 L X+27.463 Y+36.424	5920 L Z-11.567 FQ3
5517 L X+26.424 Y+42.537	5618 L X+39.	5719 L X+26.097 Y+38.244 FQ4	5820 L X+28.176 Y+36.116	5921 L X+28.244 Y+43.903
5518 L X+26.116 Y+41.824	5619 L Y+54.	5720 L X+26.371 Y+37.555	5821 L X+29. Y+36.	5922 L X+27.555 Y+43.629
5519 L X+26. Y+41.	5620 L X+26.	5721 L X+26.637 Y+37.151	5822 L Z+15.	5923 L X+27.151 Y+43.363
5520 L Y+40.	5621 L Y+40.	5722 L X+26.961 Y+36.8	5823 L Y+44. FMAX	5924 L X+26.8 Y+43.039
5521 L Y+26.	5622 L Y+39.	5723 L X+27.463 Y+36.424	5824 L Z-11.433 FQ3	5925 L X+26.424 Y+42.537
5522 L X+39.	5623 L X+26.097 Y+38.244 FQ4	5724 L X+28.176 Y+36.116	5825 L X+28.244 Y+43.903	5926 L X+26.116 Y+41.824
5523 L Y+54.	5624 L X+26.371 Y+37.555	5725 L X+29. Y+36.	5826 L X+27.555 Y+43.629	5927 L X+26. Y+41.
5524 L X+26.	5625 L X+26.637 Y+37.151	5726 L Z+15.	5827 L X+27.151 Y+43.363	5928 L Y+40.
5525 L Y+40.	5626 L X+26.961 Y+36.8	5727 L Y+44. FMAX	5828 L X+26.8 Y+43.039	5929 L Y+26.
5526 L Y+39.	5627 L X+27.463 Y+36.424	5728 L Z-11.3 FQ3	5829 L X+26.424 Y+42.537	5930 L X+39.
5527 L X+26.097 Y+38.244 FQ4	5628 L X+28.176 Y+36.116	5729 L X+28.244 Y+43.903	5830 L X+26.116 Y+41.824	5931 L Y+54.
5528 L X+26.371 Y+37.555	5629 L X+29. Y+36.	5730 L X+27.555 Y+43.629	5831 L X+26. Y+41.	5932 L X+26.
5529 L X+26.637 Y+37.151	5630 L Z+15.	5731 L X+27.151 Y+43.363	5832 L Y+40.	5933 L Y+40.
5530 L X+26.961 Y+36.8	5631 L Y+44. FMAX	5732 L X+26.8 Y+43.039	5833 L Y+26.	5934 L Y+39.
5531 L X+27.463 Y+36.424	5632 L Z-11.167 FQ3	5733 L X+26.424 Y+42.537	5834 L X+39.	5935 L X+26.097 Y+38.244 FQ4
5532 L X+28.176 Y+36.116	5633 L X+28.244 Y+43.903	5734 L X+26.116 Y+41.824	5835 L Y+54.	5936 L X+26.371 Y+37.555
5533 L X+29. Y+36.	5634 L X+27.555 Y+43.629	5735 L X+26. Y+41.	5836 L X+26.	5937 L X+26.637 Y+37.151
5534 L Z+15.	5635 L X+27.151 Y+43.363	5736 L Y+40.	5837 L Y+40.	5938 L X+26.961 Y+36.8
5535 L Y+44. FMAX	5636 L X+26.8 Y+43.039	5737 L Y+26.	5838 L Y+39.	5939 L X+27.463 Y+36.424
5536 L Z-11.033 FQ3	5637 L X+26.424 Y+42.537	5738 L X+39.	5839 L X+26.097 Y+38.244 FQ4	5940 L X+28.176 Y+36.116
5537 L X+28.244 Y+43.903	5638 L X+26.116 Y+41.824	5739 L Y+54.	5840 L X+26.371 Y+37.555	5941 L X+29. Y+36.
5538 L X+27.555 Y+43.629	5639 L X+26. Y+41.	5740 L X+26.	5841 L X+26.637 Y+37.151	5942 L Z+15.
5539 L X+27.151 Y+43.363	5640 L Y+40.	5741 L Y+40.	5842 L X+26.961 Y+36.8	5943 L Y+44. FMAX
5540 L X+26.8 Y+43.039	5641 L Y+26.	5742 L Y+39.	5843 L X+27.463 Y+36.424	5944 L X+28.176 Y+36.116
5541 L X+26.424 Y+42.537	5642 L X+39.	5743 L X+26.097 Y+38.244 FQ4	5844 L X+28.176 Y+36.116	5945 L X+26.424 Y+43.903

5946 L X+27.555 Y+43.629
5947 L X+27.151 Y+43.363
5948 L X+26.8 Y+43.039
5949 L X+26.424 Y+42.537
5950 L X+26.116 Y+41.824
5951 L X+26. Y+41.
5952 L Y+40.
5953 L Y+26.
5954 L X+39.
5955 L Y+54.
5956 L X+26.
5957 L Y+40.
5958 L Y+39.
5959 L X+26.097 Y+38.244 FQ4
5960 L X+26.371 Y+37.555
5961 L X+26.637 Y+37.151
5962 L X+26.961 Y+36.8
5963 L X+27.463 Y+36.424
5964 L X+28.176 Y+36.116
5965 L X+29. Y+36.
5966 L Z+15.
5967 L Y+44. FMAX
5968 L Z-11.633 FQ3
5969 L X+28.244 Y+43.903
5970 L X+27.555 Y+43.629
5971 L X+27.151 Y+43.363
5972 L X+26.8 Y+43.039
5973 L X+26.424 Y+42.537
5974 L X+26.116 Y+41.824
5975 L X+26. Y+41.
5976 L Y+40.
5977 L Y+26.
5978 L X+39.
5979 L Y+54.
5980 L X+26.
5981 L Y+40.
5982 L Y+39.
5983 L X+26.097 Y+38.244 FQ4
5984 L X+26.371 Y+37.555
5985 L X+26.637 Y+37.151
5986 L X+26.961 Y+36.8
5987 L X+27.463 Y+36.424
5988 L X+28.176 Y+36.116
5989 L X+29. Y+36.
5990 L Z+15.
5991 L Y+44. FMAX
5992 L Z-11.667 FQ3
5993 L X+28.244 Y+43.903
5994 L X+27.555 Y+43.629
5995 L X+27.151 Y+43.363
5996 L X+26.8 Y+43.039
5997 L X+26.424 Y+42.537
5998 L X+26.116 Y+41.824
5999 L X+26. Y+41.
6000 L Y+40.
6001 L Y+26.
6002 L X+39.
6003 L Y+54.
6004 L X+26.
6005 L Y+40.
6006 L Y+39.
6007 L X+26.097 Y+38.244 FQ4
6008 L X+26.371 Y+37.555
6009 L X+26.637 Y+37.151
6010 L X+26.961 Y+36.8
6011 L X+27.463 Y+36.424
6012 L X+28.176 Y+36.116
6013 L X+29. Y+36.
6014 L Z+15.
6015 L Y+44. FMAX
6016 L Z-11.7 FQ3
6017 L X+28.244 Y+43.903
6018 L X+27.555 Y+43.629
6019 L X+27.151 Y+43.363
6020 L X+26.8 Y+43.039
6021 L X+26.424 Y+42.537
6022 L X+26.116 Y+41.824
6023 L X+26. Y+41.
6024 L Y+40.
6025 L Y+26.
6026 L X+39.
6027 L Y+54.
6028 L X+26.
6029 L Y+40.
6030 L Y+39.
6031 L X+26.097 Y+38.244 FQ4
6032 L X+26.371 Y+37.555
6033 L X+26.637 Y+37.151
6034 L X+26.961 Y+36.8
6035 L X+27.463 Y+36.424
6036 L X+28.176 Y+36.116
6037 L X+29. Y+36.
6038 L Z+15.
6039 L Y+44. FMAX
6040 L Z-11.733 FQ3
6041 L X+28.244 Y+43.903
6042 L X+27.555 Y+43.629
6043 L X+27.151 Y+43.363
6044 L X+26.8 Y+43.039
6045 L X+26.424 Y+42.537
6046 L X+26.116 Y+41.824
6047 L X+26. Y+41.
6048 L Y+40.
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6050 L X+39.
6051 L Y+54.
6052 L X+26.
6053 L Y+40.
6054 L Y+39.
6055 L X+26.097 Y+38.244 FQ4
6056 L X+26.371 Y+37.555
6057 L X+26.637 Y+37.151
6058 L X+26.961 Y+36.8
6059 L X+27.463 Y+36.424
6060 L X+28.176 Y+36.116
6061 L X+29. Y+36.
6062 L Z+15.
6063 L Y+44. FMAX
6064 L Z-11.767 FQ3
6065 L X+28.244 Y+43.903
6066 L X+27.555 Y+43.629
6067 L X+27.151 Y+43.363
6068 L X+26.8 Y+43.039
6069 L X+26.424 Y+42.537
6070 L X+26.116 Y+41.824
6071 L X+26. Y+41.
6072 L Y+40.
6073 L Y+26.
6074 L X+39.
6075 L Y+54.
6076 L X+26.
6077 L Y+40.
6078 L Y+39.
6079 L X+26.097 Y+38.244 FQ4
6080 L X+26.371 Y+37.555
6081 L X+26.637 Y+37.151
6082 L X+26.961 Y+36.8
6083 L X+27.463 Y+36.424
6084 L X+28.176 Y+36.116
6085 L X+29. Y+36.
6086 L Z+15.
6087 L Y+44. FMAX
6088 L Z-11.8 FQ3
6089 L X+28.244 Y+43.903
6090 L X+27.555 Y+43.629
6091 L X+27.151 Y+43.363
6092 L X+26.8 Y+43.039
6093 L X+26.424 Y+42.537
6094 L X+26.116 Y+41.824
6095 L X+26. Y+41.
6096 L Y+40.
6097 L Y+26.
6098 L X+39.
6099 L Y+54.
6100 L X+26.
6101 L Y+40.
6102 L Y+39.
6103 L X+26.097 Y+38.244 FQ4
6104 L X+26.371 Y+37.555
6105 L X+26.637 Y+37.151
6106 L X+26.961 Y+36.8
6107 L X+27.463 Y+36.424
6108 L X+28.176 Y+36.116
6109 L X+29. Y+36.
6110 L Z+15.
6111 L Y+44. FMAX
6112 L Z-11.833 FQ3
6113 L X+28.244 Y+43.903
6114 L X+27.555 Y+43.629
6115 L X+27.151 Y+43.363
6116 L X+26.8 Y+43.039
6117 L X+26.424 Y+42.537
6118 L X+26.116 Y+41.824
6119 L X+26. Y+41.
6120 L Y+40.
6121 L Y+26.
6122 L X+39.
6123 L Y+54.
6124 L X+26.
6125 L Y+40.
6126 L Y+39.
6127 L X+26.097 Y+38.244 FQ4
6128 L X+26.371 Y+37.555
6129 L X+26.637 Y+37.151
6130 L X+26.961 Y+36.8
6131 L X+27.463 Y+36.424
6132 L X+28.176 Y+36.116
6133 L X+29. Y+36.
6134 L Z+15.
6135 L Y+44. FMAX
6136 L Z-11.867 FQ3
6137 L X+28.244 Y+43.903
6138 L X+27.555 Y+43.629
6139 L X+27.151 Y+43.363
6140 L X+26.8 Y+43.039
6141 L X+26.424 Y+42.537
6142 L X+26.116 Y+41.824
6143 L X+26. Y+41.
6144 L Y+40.
6145 L Y+26.
6146 L X+39.
6147 L Y+54.
6148 L X+26.
6149 L Y+40.
6150 L Y+39.
6151 L X+26.097 Y+38.244 FQ4
6152 L X+26.371 Y+37.555
6153 L X+26.637 Y+37.151
6154 L X+26.961 Y+36.8
6155 L X+27.463 Y+36.424
6156 L X+28.176 Y+36.116
6157 L X+29. Y+36.
6158 L Z+15.
6159 L Y+44. FMAX
6160 L Z-11.9 FQ3
6161 L X+28.244 Y+43.903
6162 L X+27.555 Y+43.629
6163 L X+27.151 Y+43.363
6164 L X+26.8 Y+43.039
6165 L X+26.424 Y+42.537
6166 L X+26.116 Y+41.824
6167 L X+26. Y+41.
6168 L Y+40.
6169 L Y+26.
6170 L X+39.
6171 L Y+54.
6172 L X+26.
6173 L Y+40.
6174 L Y+39.
6175 L X+26.097 Y+38.244 FQ4
6176 L X+26.371 Y+37.555
6177 L X+26.637 Y+37.151
6178 L X+26.961 Y+36.8
6179 L X+27.463 Y+36.424
6180 L X+28.176 Y+36.116
6181 L X+29. Y+36.
6182 L Z+15.
6183 L Y+44. FMAX
6184 L Z-11.933 FQ3
6185 L X+28.244 Y+43.903
6186 L X+27.555 Y+43.629
6187 L X+27.151 Y+43.363
6188 L X+26.8 Y+43.039
6189 L X+26.424 Y+42.537
6190 L X+26.116 Y+41.824
6191 L X+26. Y+41.
6192 L Y+40.
6193 L Y+26.
6194 L X+39.
6195 L Y+54.
6196 L X+26.
6197 L Y+40.
6198 L Y+39.
6199 L X+26.097 Y+38.244 FQ4
6200 L X+26.371 Y+37.555
6201 L X+26.637 Y+37.151
6202 L X+26.961 Y+36.8
6203 L X+27.463 Y+36.424
6204 L X+28.176 Y+36.116
6205 L X+29. Y+36.
6206 L Z+15.
6207 L Y+44. FMAX
6208 L Z-11.967 FQ3
6209 L X+28.244 Y+43.903
6210 L X+27.555 Y+43.629
6211 L X+27.151 Y+43.363
6212 L X+26.8 Y+43.039
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6214 L X+26.116 Y+41.824
6215 L X+26. Y+41.
6216 L Y+40.
6217 L Y+26.
6218 L X+39.
6219 L Y+54.
6220 L X+26.
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6222 L Y+39.
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6224 L X+26.371 Y+37.555
6225 L X+26.637 Y+37.151
6226 L X+26.961 Y+36.8
6227 L X+27.463 Y+36.424
6228 L X+28.176 Y+36.116
6229 L X+29. Y+36.
6230 L Z+15.
6231 L Y+44. FMAX
6232 L Z-12. FQ3
6233 L X+28.244 Y+43.903
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6253 L X+29. Y+36.
6254 L Z+15.
6255 L X+0.0 Y+0.0 Z+100. FMAX
6256 L X+101. Y+26. FMAX
6257 L Z+15. FMAX
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6440 L Y+31.

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6807 L X+101. Y+34.
6808 L Z+15.
6809 L Y+26. FMAX
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6847 L Y+30.
6848 L Y+31.
6849 L X+103.903 Y+31.756 FQ4
6850 L X+103.629 Y+32.445
6851 L X+103.363 Y+32.849
6852 L X+103.039 Y+33.2
6853 L X+102.537 Y+33.576
6854 L X+101.824 Y+33.884
6855 L X+101. Y+34.
6856 L Z+15.
6857 L Y+26. FMAX
6858 L Z-.13 FQ3
6859 L X+101.756 Y+26.097
6860 L X+102.445 Y+26.371
6861 L X+102.849 Y+26.637
6862 L X+103.2 Y+26.961
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6864 L X+103.884 Y+28.176
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6866 L Y+30.
6867 L Y+39.
6868 L X+86.
6869 L Y+21.
6870 L X+104.
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6872 L Y+31.
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6876 L X+103.039 Y+33.2
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6878 L X+101.824 Y+33.884
6879 L X+101. Y+34.
6880 L Z+15.
6881 L Y+26. FMAX
6882 L Z-.135 FQ3
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6893 L Y+21.
6894 L X+104.
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6896 L Y+31.
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6920 L Y+31.

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7122 L Z-1.85 FQ3
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7146 L Z-1.9 FQ3
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7170 L Z-1.95 FQ3
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7194 L Z-2. FQ3
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7242 L Z-2.1 FQ3
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7266 L Z-2.15 FQ3
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7290 L Z-2.2 FQ3
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7337 L Y+26. FMAX
7338 L Z-2.3 FQ3
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7385 L Y+26. FMAX
7386 L Z-2.4 FQ3
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7396 L X+86.
7397 L Y+21.
7398 L X+104.
7399 L Y+30.
7400 L Y+31.

7401 L X+103.903 Y+31.756 FQ4	7497 L X+103.903 Y+31.756 FQ4	7593 L X+103.903 Y+31.756 FQ4	7689 L X+103.903 Y+31.756 FQ4	7788 L Z-3.333 FQ3
7402 L X+103.629 Y+32.445	7498 L X+103.629 Y+32.445	7594 L X+103.629 Y+32.445	7690 L X+103.629 Y+32.445	7789 L X+92.065 Y+27.493
7403 L X+103.363 Y+32.849	7499 L X+103.363 Y+32.849	7595 L X+103.363 Y+32.849	7691 L X+103.363 Y+32.849	7790 L X+92.346 Y+26.875
7404 L X+103.039 Y+33.2	7500 L X+103.039 Y+33.2	7596 L X+103.039 Y+33.2	7692 L X+103.039 Y+33.2	7791 L X+92.533 Y+26.641
7405 L X+102.537 Y+33.576	7501 L X+102.537 Y+33.576	7597 L X+102.537 Y+33.576	7693 L X+102.537 Y+33.576	7792 L X+92.894 Y+26.334
7406 L X+101.824 Y+33.884	7502 L X+101.824 Y+33.884	7598 L X+101.824 Y+33.884	7694 L X+101.824 Y+33.884	7793 L X+93.422 Y+26.085
7407 L X+101. Y+34.	7503 L X+101. Y+34.	7599 L X+101. Y+34.	7695 L X+101. Y+34.	7794 L X+94. Y+26.
7408 L Z+15.	7504 L Z+15.	7600 L Z+15.	7696 L Z+15.	7795 L X+95.
7409 L Y+26. FMAX	7505 L Y+26. FMAX	7601 L Y+26. FMAX	7697 L X+0.0 Y+0.0 Z+100.	7796 L X+99.
7410 L Z-2.45 FQ3	7506 L Z-2.45 FQ3	7602 L Z-2.85 FQ3	FMAX	7797 L Y+34.
7411 L X+101.756 Y+26.097	7507 L X+101.756 Y+26.097	7603 L X+101.756 Y+26.097	7698 L X+92. Y+28. FMAX	7798 L X+91.
7412 L X+102.445 Y+26.371	7508 L X+102.445 Y+26.371	7604 L X+102.445 Y+26.371	7699 L Z+15. FMAX	7799 L Y+26.
7413 L X+102.849 Y+26.637	7509 L X+102.849 Y+26.637	7605 L X+102.849 Y+26.637	7700 L Z-3.067 FQ3	7800 L X+95.
7414 L X+103.2 Y+26.961	7510 L X+103.2 Y+26.961	7606 L X+103.2 Y+26.961	7701 L X+92.065 Y+27.493	7801 L X+96.
7415 L X+103.576 Y+27.463	7511 L X+103.576 Y+27.463	7607 L X+103.576 Y+27.463	7702 L X+92.346 Y+26.875	7802 L X+96.507 Y+26.065 FQ4
7416 L X+103.884 Y+28.176	7512 L X+103.884 Y+28.176	7608 L X+103.884 Y+28.176	7703 L X+92.533 Y+26.641	7803 L X+97.125 Y+26.346
7417 L X+104. Y+29.	7513 L X+104. Y+29.	7609 L X+104. Y+29.	7704 L X+92.894 Y+26.334	7804 L X+97.359 Y+26.533
7418 L Y+30.	7514 L Y+30.	7610 L Y+30.	7705 L X+93.422 Y+26.085	7805 L X+97.666 Y+26.894
7419 L Y+39.	7515 L Y+39.	7611 L Y+39.	7706 L X+94. Y+26.	7806 L X+97.915 Y+27.422
7420 L X+86.	7516 L X+86.	7612 L X+86.	7707 L X+95.	7807 L X+98. Y+28.
7421 L Y+21.	7517 L Y+21.	7613 L Y+21.	7708 L X+99.	7808 L Z+15.
7422 L X+104.	7518 L X+104.	7614 L X+104.	7709 L Y+34.	7809 L X+92. FMAX
7423 L Y+30.	7519 L Y+30.	7615 L Y+30.	7710 L X+91.	7810 L Z-3.4 FQ3
7424 L Y+31.	7520 L Y+31.	7616 L Y+31.	7711 L Y+26.	7811 L X+92.065 Y+27.493
7425 L X+103.903 Y+31.756 FQ4	7521 L X+103.903 Y+31.756 FQ4	7617 L X+103.903 Y+31.756 FQ4	7712 L X+95.	7812 L X+92.346 Y+26.875
7426 L X+103.629 Y+32.445	7522 L X+103.629 Y+32.445	7618 L X+103.629 Y+32.445	7713 L X+96.	7813 L X+92.533 Y+26.641
7427 L X+103.363 Y+32.849	7523 L X+103.363 Y+32.849	7619 L X+103.363 Y+32.849	7714 L X+96.507 Y+26.065 FQ4	7814 L X+92.894 Y+26.334
7428 L X+103.039 Y+33.2	7524 L X+103.039 Y+33.2	7620 L X+103.039 Y+33.2	7715 L X+97.125 Y+26.346	7815 L X+93.422 Y+26.085
7429 L X+102.537 Y+33.576	7525 L X+102.537 Y+33.576	7621 L X+102.537 Y+33.576	7716 L X+97.359 Y+26.533	7816 L X+94. Y+26.
7430 L X+101.824 Y+33.884	7526 L X+101.824 Y+33.884	7622 L X+101.824 Y+33.884	7717 L X+97.666 Y+26.894	7817 L X+95.
7431 L X+101. Y+34.	7527 L X+101. Y+34.	7623 L X+101. Y+34.	7718 L X+97.915 Y+27.422	7818 L X+99.
7432 L Z+15.	7528 L Z+15.	7624 L Z+15.	7719 L X+98. Y+28.	7819 L Y+34.
7433 L Y+26. FMAX	7529 L Y+26. FMAX	7625 L Y+26. FMAX	7720 L Z+15.	7820 L X+91.
7434 L Z-2.5 FQ3	7530 L Z-2.7 FQ3	7626 L Z-2.9 FQ3	7721 L X+92. FMAX	7821 L Y+26.
7435 L X+101.756 Y+26.097	7531 L X+101.756 Y+26.097	7627 L X+101.756 Y+26.097	7722 L Z-3.133 FQ3	7822 L X+95.
7436 L X+102.445 Y+26.371	7532 L X+102.445 Y+26.371	7628 L X+102.445 Y+26.371	7723 L X+92.065 Y+27.493	7823 L X+96.
7437 L X+102.849 Y+26.637	7533 L X+102.849 Y+26.637	7629 L X+102.849 Y+26.637	7724 L X+92.346 Y+26.875	7824 L X+96.507 Y+26.065 FQ4
7438 L X+103.2 Y+26.961	7534 L X+103.2 Y+26.961	7630 L X+103.2 Y+26.961	7725 L X+92.533 Y+26.641	7825 L X+97.125 Y+26.346
7439 L X+103.576 Y+27.463	7535 L X+103.576 Y+27.463	7631 L X+103.576 Y+27.463	7726 L X+92.894 Y+26.334	7826 L X+97.359 Y+26.533
7440 L X+103.884 Y+28.176	7536 L X+103.884 Y+28.176	7632 L X+103.884 Y+28.176	7727 L X+93.422 Y+26.085	7827 L X+97.666 Y+26.894
7441 L X+104. Y+29.	7537 L X+104. Y+29.	7633 L X+104. Y+29.	7728 L X+94. Y+26.	7828 L X+97.915 Y+27.422
7442 L Y+30.	7538 L Y+30.	7634 L Y+30.	7729 L X+95.	7829 L X+98. Y+28.
7443 L Y+39.	7539 L Y+39.	7635 L Y+39.	7730 L X+99.	7830 L Z+15.
7444 L X+86.	7540 L X+86.	7636 L X+86.	7731 L Y+34.	7831 L X+92. FMAX
7445 L Y+21.	7541 L Y+21.	7637 L Y+21.	7732 L X+91.	7832 L Z-3.467 FQ3
7446 L X+104.	7542 L X+104.	7638 L X+104.	7733 L Y+26.	7833 L X+92.065 Y+27.493
7447 L Y+30.	7543 L Y+30.	7639 L Y+30.	7734 L X+95.	7834 L X+92.346 Y+26.875
7448 L Y+31.	7544 L Y+31.	7640 L Y+31.	7735 L X+96.	7835 L X+92.533 Y+26.641
7449 L X+103.903 Y+31.756 FQ4	7545 L X+103.903 Y+31.756 FQ4	7641 L X+103.903 Y+31.756 FQ4	7736 L X+96.507 Y+26.065 FQ4	7836 L X+92.894 Y+26.334
7450 L X+103.629 Y+32.445	7546 L X+103.629 Y+32.445	7642 L X+103.629 Y+32.445	7737 L X+97.125 Y+26.346	7837 L X+93.422 Y+26.085
7451 L X+103.363 Y+32.849	7547 L X+103.363 Y+32.849	7643 L X+103.363 Y+32.849	7738 L X+97.359 Y+26.533	7838 L X+94. Y+26.
7452 L X+103.039 Y+33.2	7548 L X+103.039 Y+33.2	7644 L X+103.039 Y+33.2	7739 L X+97.666 Y+26.894	7839 L X+95.
7453 L X+102.537 Y+33.576	7549 L X+102.537 Y+33.576	7645 L X+102.537 Y+33.576	7740 L X+97.915 Y+27.422	7840 L X+99.
7454 L X+101.824 Y+33.884	7550 L X+101.824 Y+33.884	7646 L X+101.824 Y+33.884	7741 L X+98. Y+28.	7841 L Y+34.
7455 L X+101. Y+34.	7551 L X+101. Y+34.	7647 L X+101. Y+34.	7742 L Z+15.	7842 L X+91.
7456 L Z+15.	7552 L Z+15.	7648 L Z+15.	7743 L X+92. FMAX	7843 L Y+26.
7457 L Y+26. FMAX	7553 L Y+26. FMAX	7649 L Y+26. FMAX	7744 L Z-3.2 FQ3	7844 L X+95.
7458 L Z-2.55 FQ3	7554 L Z-2.75 FQ3	7650 L Z-2.95 FQ3	7745 L X+92.065 Y+27.493	7845 L X+96.
7459 L X+101.756 Y+26.097	7555 L X+101.756 Y+26.097	7651 L X+101.756 Y+26.097	7746 L X+92.346 Y+26.875	7846 L X+96.507 Y+26.065 FQ4
7460 L X+102.445 Y+26.371	7556 L X+102.445 Y+26.371	7652 L X+102.445 Y+26.371	7747 L X+92.533 Y+26.641	7847 L X+97.125 Y+26.346
7461 L X+102.849 Y+26.637	7557 L X+102.849 Y+26.637	7653 L X+102.849 Y+26.637	7748 L X+92.894 Y+26.334	7848 L X+97.359 Y+26.533
7462 L X+103.2 Y+26.961	7558 L X+103.2 Y+26.961	7654 L X+103.2 Y+26.961	7749 L X+93.422 Y+26.085	7849 L X+97.666 Y+26.894
7463 L X+103.576 Y+27.463	7559 L X+103.576 Y+27.463	7655 L X+103.576 Y+27.463	7750 L X+94. Y+26.	7850 L X+97.915 Y+27.422
7464 L X+103.884 Y+28.176	7560 L X+103.884 Y+28.176	7656 L X+103.884 Y+28.176	7751 L X+95.	7851 L X+98. Y+28.
7465 L X+104. Y+29.	7561 L X+104. Y+29.	7657 L X+104. Y+29.	7752 L X+99.	7852 L Z+15.
7466 L Y+30.	7562 L Y+30.	7658 L Y+30.	7753 L Y+34.	7853 L X+92. FMAX
7467 L Y+39.	7563 L Y+39.	7659 L Y+39.	7754 L X+91.	7854 L Z-3.533 FQ3
7468 L X+86.	7564 L X+86.	7660 L X+86.	7755 L Y+26.	7855 L X+92.065 Y+27.493
7469 L Y+21.	7565 L Y+21.	7661 L Y+21.	7756 L X+95.	7856 L X+92.346 Y+26.875
7470 L X+104.	7566 L X+104.	7662 L X+104.	7757 L X+96.	7857 L X+92.533 Y+26.641
7471 L Y+30.	7567 L Y+30.	7663 L Y+30.	7758 L X+96.507 Y+26.065 FQ4	7858 L X+92.894 Y+26.334
7472 L Y+31.	7568 L Y+31.	7664 L Y+31.	7759 L X+97.125 Y+26.346	7859 L X+93.422 Y+26.085
7473 L X+103.903 Y+31.756 FQ4	7569 L X+103.903 Y+31.756 FQ4	7665 L X+103.903 Y+31.756 FQ4	7760 L X+97.359 Y+26.533	7860 L X+94. Y+26.
7474 L X+103.629 Y+32.445	7570 L X+103.629 Y+32.445	7666 L X+103.629 Y+32.445	7761 L X+97.666 Y+26.894	7861 L X+95.
7475 L X+103.363 Y+32.849	7571 L X+103.363 Y+32.849	7667 L X+103.363 Y+32.849	7762 L X+97.915 Y+27.422	7862 L X+99.
7476 L X+103.039 Y+33.2	7572 L X+103.039 Y+33.2	7668 L X+103.039 Y+33.2	7763 L X+98. Y+28.	7863 L Y+34.
7477 L X+102.537 Y+33.576	7573 L X+102.537 Y+33.576	7669 L X+102.537 Y+33.576	7764 L Z+15.	7864 L X+91.
7478 L X+101.824 Y+33.884	7574 L X+101.824 Y+33.884	7670 L X+101.824 Y+33.884	7765 L X+95.	7865 L Y+26.
7479 L X+101. Y+34.	7575 L X+101. Y+34.	7671 L X+101. Y+34.	7766 L X+92. FMAX	7866 L X+95.
7480 L Z+15.	7576 L Z+15.	7672 L Z+15.	7767 L Z-3.267 FQ3	7867 L X+96.
7481 L Y+26. FMAX	7577 L Y+26. FMAX	7673 L Y+26. FMAX	7768 L X+92.065 Y+27.493	7868 L X+96.507 Y+26.065 FQ4
7482 L Z-2.6 FQ3	7578 L Z-2.8 FQ3	7674 L Z-3. FQ3	7769 L X+92.346 Y+26.875	7869 L X+97.125 Y+26.346
7483 L X+101.756 Y+26.097	7579 L X+101.756 Y+26.097	7675 L X+101.756 Y+26.097	7770 L X+92.533 Y+26.641	7870 L X+97.359 Y+26.533
7484 L X+102.445 Y+26.371	7580 L X+102.445 Y+26.371	7676 L X+102.445 Y+26.371	7771 L X+92.894 Y+26.334	7871 L X+97.666 Y+26.894
7485 L X+102.849 Y+26.637	7581 L X+102.849 Y+26.637	7677 L X+102.849 Y+26.637	7772 L X+93.422 Y+26.085	7872 L X+97.915 Y+27.422
7486 L X+103.2 Y+26.961	7582 L X+103.2 Y+26.961	7678 L X+103.2 Y+26.961	7773 L X+95.	7873 L X+98. Y+28.
7487 L X+103.576 Y+27.463	7583 L X+103.576 Y+27.463	7679 L X+103.576 Y+27.463	7774 L X+99.	7874 L Z+15.
7488 L X+103.884 Y+28.176	7584 L X+103.884 Y+28.176	7680 L X+103.884 Y+28.176	7775 L Y+34.	7875 L X+92. FMAX
7489 L X+104. Y+29.	7585 L X+104. Y+29.	7681 L X+104. Y+29.	7776 L X+91.	7876 L Z-3.6 FQ3
7490 L Y+30.	7586 L Y+30.	7682 L Y+30.	7777 L Y+26.	7877 L X+92.065 Y+27.493
7491 L Y+39.	7587 L Y+39.	7683 L Y+39.	7778 L X+95.	7878 L X+92.346 Y+26.875
7492 L X+86.	7588 L X+86.	7684 L X+86.	7779 L X+96.	7879 L X+92.533 Y+26.641
7493 L Y+21.	7589 L Y+21.	7685 L Y+21.	7780 L X+96.507 Y+26.065 FQ4	7880 L X+92.894 Y+26.334
7494 L X+104.	7590 L X+104.	7686 L X+104.	7781 L X+97.125 Y+26.346	7881 L X+93.422 Y+26.085
7495 L Y+30.	7591 L Y+30.	7687 L Y+30.	7782 L X+97.359 Y+26.533	7882 L X+94. Y+26.
7496 L Y+31.	7592 L Y+31.	7688 L Y+31.	7783 L X+97.666 Y+26.894	7883 L X+95.
			7784 L X+97.915 Y+27.422	7884 L X+99.
			7785 L X+98. Y+28.	7885 L Y+34.
			7786 L Z+15.	7886 L X+91.
			7787 L X+92. FMAX	7887 L Y+26.
				7888 L X+95.

7889 L X+96.	7990 L X+92.894 Y+26.334	8091 L X+97.666 Y+26.894	8192 L X+99.	8293 L X+92. FMAX
7890 L X+96.507 Y+26.065 FQ4	7991 L X+93.422 Y+26.085	8092 L X+97.915 Y+27.422	8193 L Y+34.	8294 L Z-4.867 FQ3
7891 L X+97.125 Y+26.346	7992 L X+94. Y+26.	8093 L X+98. Y+28.	8194 L X+91.	8295 L X+92.065 Y+27.493
7892 L X+97.359 Y+26.533	7993 L X+95.	8094 L Z+15.	8195 L Y+26.	8296 L X+92.346 Y+26.875
7893 L X+97.666 Y+26.894	7994 L X+99.	8095 L X+92. FMAX	8196 L X+95.	8297 L X+92.533 Y+26.641
7894 L X+97.915 Y+27.422	7995 L Y+34.	8096 L Z-4.267 FQ3	8197 L X+96.	8298 L X+92.894 Y+26.334
7895 L X+98. Y+28.	7996 L X+91.	8097 L X+92.065 Y+27.493	8198 L X+96.507 Y+26.065 FQ4	8299 L X+93.422 Y+26.085
7896 L Z+15.	7997 L Y+26.	8098 L X+92.346 Y+26.875	8199 L X+97.125 Y+26.346	8300 L X+94. Y+26.
7897 L X+92. FMAX	7998 L X+95.	8099 L X+92.533 Y+26.641	8200 L X+97.359 Y+26.533	8301 L X+95.
7898 L Z-3.667 FQ3	7999 L X+96.	8100 L X+92.894 Y+26.334	8201 L X+97.666 Y+26.894	8302 L X+99.
7899 L X+92.065 Y+27.493	8000 L X+96.507 Y+26.065 FQ4	8101 L X+93.422 Y+26.085	8202 L X+97.915 Y+27.422	8303 L Y+34.
7900 L X+92.346 Y+26.875	8001 L X+97.125 Y+26.346	8102 L X+94. Y+26.	8203 L X+98. Y+28.	8304 L X+91.
7901 L X+92.533 Y+26.641	8002 L X+97.359 Y+26.533	8103 L X+95.	8204 L Z+15.	8305 L Y+26.
7902 L X+92.894 Y+26.334	8003 L X+97.666 Y+26.894	8104 L X+99.	8205 L X+92. FMAX	8306 L X+95.
7903 L X+93.422 Y+26.085	8004 L X+97.915 Y+27.422	8105 L Y+34.	8206 L Z-4.6 FQ3	8307 L X+96.
7904 L X+94. Y+26.	8005 L X+98. Y+28.	8106 L X+91.	8207 L X+92.065 Y+27.493	8308 L X+96.507 Y+26.065 FQ4
7905 L X+95.	8006 L Z+15.	8107 L Y+26.	8208 L X+92.346 Y+26.875	8309 L X+97.125 Y+26.346
7906 L X+99.	8007 L X+92. FMAX	8108 L X+95.	8209 L X+92.533 Y+26.641	8310 L X+97.359 Y+26.533
7907 L Y+34.	8008 L Z-4. FQ3	8109 L X+96.	8210 L X+92.894 Y+26.334	8311 L X+97.666 Y+26.894
7908 L X+91.	8009 L X+92.065 Y+27.493	8110 L X+96.507 Y+26.065 FQ4	8211 L X+93.422 Y+26.085	8312 L X+97.915 Y+27.422
7909 L Y+26.	8010 L X+92.346 Y+26.875	8111 L X+97.125 Y+26.346	8212 L X+94. Y+26.	8313 L X+98. Y+28.
7910 L X+95.	8011 L X+92.533 Y+26.641	8112 L X+97.359 Y+26.533	8213 L X+95.	8314 L Z+15.
7911 L X+96.	8012 L X+92.894 Y+26.334	8113 L X+97.666 Y+26.894	8214 L X+99.	8315 L X+92. FMAX
7912 L X+96.507 Y+26.065 FQ4	8013 L X+93.422 Y+26.085	8114 L X+97.915 Y+27.422	8215 L Y+34.	8316 L Z-4.933 FQ3
7913 L X+97.125 Y+26.346	8014 L X+94. Y+26.	8115 L X+98. Y+28.	8216 L X+91.	8317 L X+92.065 Y+27.493
7914 L X+97.359 Y+26.533	8015 L X+95.	8116 L Z+15.	8217 L Y+26.	8318 L X+92.346 Y+26.875
7915 L X+97.666 Y+26.894	8016 L X+99.	8117 L X+92. FMAX	8218 L X+95.	8319 L X+92.533 Y+26.641
7916 L X+97.915 Y+27.422	8017 L Y+34.	8118 L Z-4.333 FQ3	8219 L X+96.	8320 L X+92.894 Y+26.334
7917 L X+98. Y+28.	8018 L X+91.	8119 L X+92.065 Y+27.493	8220 L X+96.507 Y+26.065 FQ4	8321 L X+93.422 Y+26.085
7918 L Z+15.	8019 L Y+26.	8120 L X+92.346 Y+26.875	8221 L X+97.125 Y+26.346	8322 L X+94. Y+26.
7919 L X+92. FMAX	8020 L X+95.	8121 L X+92.533 Y+26.641	8222 L X+97.359 Y+26.533	8323 L X+95.
7920 L Z-3.733 FQ3	8021 L X+96.	8122 L X+92.894 Y+26.334	8223 L X+97.666 Y+26.894	8324 L X+99.
7921 L X+92.065 Y+27.493	8022 L X+96.507 Y+26.065 FQ4	8123 L X+93.422 Y+26.085	8224 L X+97.915 Y+27.422	8325 L Y+34.
7922 L X+92.346 Y+26.875	8023 L X+97.125 Y+26.346	8124 L X+94. Y+26.	8225 L X+98. Y+28.	8326 L X+91.
7923 L X+92.533 Y+26.641	8024 L X+97.359 Y+26.533	8125 L X+95.	8226 L Z+15.	8327 L Y+26.
7924 L X+92.894 Y+26.334	8025 L X+97.666 Y+26.894	8126 L X+99.	8227 L X+92. FMAX	8328 L X+95.
7925 L X+93.422 Y+26.085	8026 L X+97.915 Y+27.422	8127 L Y+34.	8228 L Z-4.667 FQ3	8329 L X+96.
7926 L X+94. Y+26.	8027 L X+98. Y+28.	8128 L X+91.	8229 L X+92.065 Y+27.493	8330 L X+96.507 Y+26.065 FQ4
7927 L X+95.	8028 L Z+15.	8129 L Y+26.	8230 L X+92.346 Y+26.875	8331 L X+97.125 Y+26.346
7928 L X+99.	8029 L X+92. FMAX	8130 L X+95.	8231 L X+92.533 Y+26.641	8332 L X+97.359 Y+26.533
7929 L Y+34.	8030 L Z-4.067 FQ3	8131 L X+96.	8232 L X+92.894 Y+26.334	8333 L X+97.666 Y+26.894
7930 L X+91.	8031 L X+92.065 Y+27.493	8132 L X+96.507 Y+26.065 FQ4	8233 L X+93.422 Y+26.085	8334 L X+97.915 Y+27.422
7931 L Y+26.	8032 L X+92.346 Y+26.875	8133 L X+97.125 Y+26.346	8234 L X+94. Y+26.	8335 L X+98. Y+28.
7932 L X+95.	8033 L X+92.533 Y+26.641	8134 L X+97.359 Y+26.533	8235 L X+95.	8336 L Z+15.
7933 L X+96.	8034 L X+92.894 Y+26.334	8135 L X+97.666 Y+26.894	8236 L X+99.	8337 L X+92. FMAX
7934 L X+96.507 Y+26.065 FQ4	8035 L X+93.422 Y+26.085	8136 L X+97.915 Y+27.422	8237 L Y+34.	8338 L Z-5. FQ3
7935 L X+97.125 Y+26.346	8036 L X+94. Y+26.	8137 L X+98. Y+28.	8238 L X+91.	8339 L X+92.065 Y+27.493
7936 L X+97.359 Y+26.533	8037 L X+95.	8138 L Z+15.	8239 L Y+26.	8340 L X+92.346 Y+26.875
7937 L X+97.666 Y+26.894	8038 L X+99.	8139 L X+92. FMAX	8240 L X+95.	8341 L X+92.533 Y+26.641
7938 L X+97.915 Y+27.422	8039 L Y+34.	8140 L Z-4.4 FQ3	8241 L X+96.	8342 L X+92.894 Y+26.334
7939 L X+98. Y+28.	8040 L X+91.	8141 L X+92.065 Y+27.493	8242 L X+96.507 Y+26.065 FQ4	8343 L X+93.422 Y+26.085
7940 L Z+15.	8041 L Y+26.	8142 L X+92.346 Y+26.875	8243 L X+97.125 Y+26.346	8344 L X+94. Y+26.
7941 L X+92. FMAX	8042 L X+95.	8143 L X+92.533 Y+26.641	8244 L X+97.359 Y+26.533	8345 L X+95.
7942 L Z-3.8 FQ3	8043 L X+96.	8144 L X+92.894 Y+26.334	8245 L X+97.666 Y+26.894	8346 L X+99.
7943 L X+92.065 Y+27.493	8044 L X+96.507 Y+26.065 FQ4	8145 L X+93.422 Y+26.085	8246 L X+97.915 Y+27.422	8347 L Y+34.
7944 L X+92.346 Y+26.875	8045 L X+97.125 Y+26.346	8146 L X+94. Y+26.	8247 L X+98. Y+28.	8348 L X+91.
7945 L X+92.533 Y+26.641	8046 L X+97.359 Y+26.533	8147 L X+95.	8248 L Z+15.	8349 L Y+26.
7946 L X+92.894 Y+26.334	8047 L X+97.666 Y+26.894	8148 L X+99.	8249 L X+92. FMAX	8350 L X+95.
7947 L X+93.422 Y+26.085	8048 L X+97.915 Y+27.422	8149 L Y+34.	8250 L Z-4.733 FQ3	8351 L X+96.
7948 L X+94. Y+26.	8049 L X+98. Y+28.	8150 L X+91.	8251 L X+92.065 Y+27.493	8352 L X+96.507 Y+26.065 FQ4
7949 L X+95.	8050 L Z+15.	8151 L Y+26.	8252 L X+92.346 Y+26.875	8353 L X+97.125 Y+26.346
7950 L X+99.	8051 L X+92. FMAX	8152 L X+95.	8253 L X+92.533 Y+26.641	8354 L X+97.359 Y+26.533
7951 L Y+34.	8052 L Z-4.133 FQ3	8153 L X+96.	8254 L X+92.894 Y+26.334	8355 L X+97.666 Y+26.894
7952 L X+91.	8053 L X+92.065 Y+27.493	8154 L X+96.507 Y+26.065 FQ4	8255 L X+93.422 Y+26.085	8356 L X+97.915 Y+27.422
7953 L Y+26.	8054 L X+92.346 Y+26.875	8155 L X+97.125 Y+26.346	8256 L X+94. Y+26.	8357 L X+98. Y+28.
7954 L X+95.	8055 L X+92.533 Y+26.641	8156 L X+97.359 Y+26.533	8257 L X+95.	8358 L Z+15.
7955 L X+96.	8056 L X+92.894 Y+26.334	8157 L X+97.666 Y+26.894	8258 L X+99.	8359 L X+92. FMAX
7956 L X+96.507 Y+26.065 FQ4	8057 L X+93.422 Y+26.085	8158 L X+97.915 Y+27.422	8259 L Y+34.	8360 L Z-5.067 FQ3
7957 L X+97.125 Y+26.346	8058 L X+94. Y+26.	8159 L X+98. Y+28.	8260 L X+91.	8361 L X+92.065 Y+27.493
7958 L X+97.359 Y+26.533	8059 L X+95.	8160 L Z+15.	8261 L Y+26.	8362 L X+92.346 Y+26.875
7959 L X+97.666 Y+26.894	8060 L X+99.	8161 L X+92. FMAX	8262 L X+95.	8363 L X+92.533 Y+26.641
7960 L X+97.915 Y+27.422	8061 L Y+34.	8162 L Z-4.467 FQ3	8263 L X+96.	8364 L X+92.894 Y+26.334
7961 L X+98. Y+28.	8062 L X+91.	8163 L X+92.065 Y+27.493	8264 L X+96.507 Y+26.065 FQ4	8365 L X+93.422 Y+26.085
7962 L Z+15.	8063 L Y+26.	8164 L X+92.346 Y+26.875	8265 L X+97.125 Y+26.346	8366 L X+94. Y+26.
7963 L X+92. FMAX	8064 L X+95.	8165 L X+92.533 Y+26.641	8266 L X+97.359 Y+26.533	8367 L X+95.
7964 L Z-3.867 FQ3	8065 L X+96.	8166 L X+92.894 Y+26.334	8267 L X+97.666 Y+26.894	8368 L X+99.
7965 L X+92.065 Y+27.493	8066 L X+96.507 Y+26.065 FQ4	8167 L X+93.422 Y+26.085	8268 L X+97.915 Y+27.422	8369 L Y+34.
7966 L X+92.346 Y+26.875	8067 L X+97.125 Y+26.346	8168 L X+94. Y+26.	8269 L X+98. Y+28.	8370 L X+91.
7967 L X+92.533 Y+26.641	8068 L X+97.359 Y+26.533	8169 L X+95.	8270 L Z+15.	8371 L Y+26.
7968 L X+92.894 Y+26.334	8069 L X+97.666 Y+26.894	8170 L X+99.	8271 L X+92. FMAX	8372 L X+95.
7969 L X+93.422 Y+26.085	8070 L X+97.915 Y+27.422	8171 L Y+34.	8272 L Z-4.8 FQ3	8373 L X+96.
7970 L X+94. Y+26.	8071 L X+98. Y+28.	8172 L X+91.	8273 L X+92.065 Y+27.493	8374 L X+96.507 Y+26.065 FQ4
7971 L X+95.	8072 L Z+15.	8173 L Y+26.	8274 L X+92.346 Y+26.875	8375 L X+97.125 Y+26.346
7972 L X+99.	8073 L X+92. FMAX	8174 L X+95.	8275 L X+92.533 Y+26.641	8376 L X+97.359 Y+26.533
7973 L Y+34.	8074 L Z-4.2 FQ3	8175 L X+96.	8276 L X+92.894 Y+26.334	8377 L X+97.666 Y+26.894
7974 L X+91.	8075 L X+92.065 Y+27.493	8176 L X+96.507 Y+26.065 FQ4	8277 L X+93.422 Y+26.085	8378 L X+97.915 Y+27.422
7975 L Y+26.	8076 L X+92.346 Y+26.875	8177 L X+97.125 Y+26.346	8278 L X+94. Y+26.	8379 L X+98. Y+28.
7976 L X+95.	8077 L X+92.533 Y+26.641	8178 L X+97.359 Y+26.533	8279 L X+95.	8380 L Z+15.
7977 L X+96.	8078 L X+92.894 Y+26.334	8179 L X+97.666 Y+26.894	8280 L X+99.	8381 L X+92. FMAX
7978 L X+96.507 Y+26.065 FQ4	8079 L X+93.422 Y+26.085	8180 L X+97.915 Y+27.422	8281 L Y+34.	8382 L Z-5.133 FQ3
7979 L X+97.125 Y+26.346	8080 L X+94. Y+26.	8181 L X+98. Y+28.	8282 L X+91.	8383 L X+92.065 Y+27.493
7980 L X+97.359 Y+26.533	8081 L X+95.	8182 L Z+15.	8283 L Y+26.	8384 L X+92.346 Y+26.875
7981 L X+97.666 Y+26.894	8082 L X+99.	8183 L X+92. FMAX	8284 L X+95.	8385 L X+92.533 Y+26.641
7982 L X+97.915 Y+27.422	8083 L Y+34.	8184 L Z-4.533 FQ3	8285 L X+96.	8386 L X+92.894 Y+26.334
7983 L X+98. Y+28.	8084 L X+91.	8185 L X+92.065 Y+27.493	8286 L X+96.507 Y+26.065 FQ4	8387 L X+93.422 Y+26.085
7984 L Z+15.	8085 L Y+26.	8186 L X+92.346 Y+26.875	8287 L X+97.125 Y+26.346	8388 L X+94. Y+26.
7985 L X+92. FMAX	8086 L X+95.	8187 L X+92.533 Y+26.641	8288 L X+97.359 Y+26.533	8389 L X+95.
7986 L Z-3.933 FQ3	8087 L X+96.	8188 L X+92.894 Y+26.334	8289 L X+97.666 Y+26.894	8390 L X+99.
7987 L X+92.065 Y+27.493	8088 L X+96.507 Y+26.065 FQ4	8189 L X+93.422 Y+26.085	8290 L X+97.915 Y+27.422	8391 L Y+34.
7988 L X+92.346 Y+26.875	8089 L X+97.125 Y+26.346	8190 L X+94. Y+26.	8291 L X+98. Y+28.	8392 L X+91.
7989 L X+92.533 Y+26.641	8090 L X+97.359 Y+26.533	8191 L X+95.	8292 L Z+15.	8393 L Y+26.

8394 L X+95.
8395 L X+96.
8396 L X+96.507 Y+26.065 FQ4
8397 L X+97.125 Y+26.346
8398 L X+97.359 Y+26.533
8399 L X+97.666 Y+26.894
8400 L X+97.915 Y+27.422
8401 L X+98. Y+28.
8402 L Z+15.
8403 L X+92. FMAX
8404 L Z-5.2 FQ3
8405 L X+92.065 Y+27.493
8406 L X+92.346 Y+26.875
8407 L X+92.533 Y+26.641
8408 L X+92.894 Y+26.334
8409 L X+93.422 Y+26.085
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8412 L X+99.
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8416 L X+95.
8417 L X+96.
8418 L X+96.507 Y+26.065 FQ4
8419 L X+97.125 Y+26.346
8420 L X+97.359 Y+26.533
8421 L X+97.666 Y+26.894
8422 L X+97.915 Y+27.422
8423 L X+98. Y+28.
8424 L Z+15.
8425 L X+92. FMAX
8426 L Z-5.267 FQ3
8427 L X+92.065 Y+27.493
8428 L X+92.346 Y+26.875
8429 L X+92.533 Y+26.641
8430 L X+92.894 Y+26.334
8431 L X+93.422 Y+26.085
8432 L X+94. Y+26.
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8438 L X+95.
8439 L X+96.
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8446 L Z+15.
8447 L X+92. FMAX
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8462 L X+96.507 Y+26.065 FQ4
8463 L X+97.125 Y+26.346
8464 L X+97.359 Y+26.533
8465 L X+97.666 Y+26.894
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8469 L X+92. FMAX
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8487 L X+97.666 Y+26.894
8488 L X+97.915 Y+27.422
8489 L X+98. Y+28.
8490 L Z+15.
8491 L X+92. FMAX
8492 L Z-5.467 FQ3
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8494 L X+92.346 Y+26.875

8495 L X+92.533 Y+26.641
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8518 L X+92.894 Y+26.334
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8530 L X+97.359 Y+26.533
8531 L X+97.666 Y+26.894
8532 L X+97.915 Y+27.422
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8535 L X+92. FMAX
8536 L Z-5.6 FQ3
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8540 L X+92.894 Y+26.334
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8579 L X+92. FMAX
8580 L Z-5.733 FQ3
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8597 L X+97.666 Y+26.894
8598 L X+97.915 Y+27.422
8599 L X+98. Y+28.
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8601 L X+92. FMAX
8602 L Z-5.8 FQ3
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8618 L X+97.359 Y+26.533
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8623 L X+92. FMAX
8624 L Z-5.867 FQ3
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8640 L X+97.359 Y+26.533
8641 L X+97.666 Y+26.894
8642 L X+97.915 Y+27.422
8643 L X+98. Y+28.
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8645 L X+92. FMAX
8646 L Z-5.933 FQ3
8647 L X+92.065 Y+27.493
8648 L X+92.346 Y+26.875
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8662 L X+97.359 Y+26.533
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8664 L X+97.915 Y+27.422
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8667 L X+92. FMAX
8668 L Z-6. FQ3
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8670 L X+92.346 Y+26.875
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8682 L X+96.507 Y+26.065 FQ4
8683 L X+97.125 Y+26.346
8684 L X+97.359 Y+26.533
8685 L X+97.666 Y+26.894
8686 L X+97.915 Y+27.422
8687 L X+98. Y+28.
8688 L Z+15.
8689 L X+92. FMAX
8690 L Z-6.067 FQ3
8691 L X+92.065 Y+27.493
8692 L X+92.346 Y+26.875
8693 L X+92.533 Y+26.641
8694 L X+92.894 Y+26.334
8695 L X+93.422 Y+26.085
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8703 L X+96.
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8705 L X+97.125 Y+26.346
8706 L X+97.359 Y+26.533
8707 L X+97.666 Y+26.894
8708 L X+97.915 Y+27.422
8709 L X+98. Y+28.
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8711 L X+92. FMAX
8712 L Z-6.133 FQ3
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8714 L X+92.346 Y+26.875
8715 L X+92.533 Y+26.641
8716 L X+92.894 Y+26.334
8717 L X+93.422 Y+26.085
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8724 L X+95.
8725 L X+96.
8726 L X+96.507 Y+26.065 FQ4
8727 L X+97.125 Y+26.346
8728 L X+97.359 Y+26.533
8729 L X+97.666 Y+26.894
8730 L X+97.915 Y+27.422
8731 L X+98. Y+28.
8732 L Z+15.
8733 L X+92. FMAX
8734 L Z-6.2 FQ3
8735 L X+92.065 Y+27.493
8736 L X+92.346 Y+26.875
8737 L X+92.533 Y+26.641
8738 L X+92.894 Y+26.334
8739 L X+93.422 Y+26.085
8740 L X+94. Y+26.
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8742 L X+99.
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8746 L X+95.
8747 L X+96.
8748 L X+96.507 Y+26.065 FQ4
8749 L X+97.125 Y+26.346
8750 L X+97.359 Y+26.533
8751 L X+97.666 Y+26.894
8752 L X+97.915 Y+27.422
8753 L X+98. Y+28.
8754 L Z+15.
8755 L X+92. FMAX
8756 L Z-6.267 FQ3
8757 L X+92.065 Y+27.493
8758 L X+92.346 Y+26.875
8759 L X+92.533 Y+26.641
8760 L X+92.894 Y+26.334
8761 L X+93.422 Y+26.085
8762 L X+94. Y+26.
8763 L X+95.
8764 L X+99.
8765 L Y+34.
8766 L X+91.
8767 L Y+26.
8768 L X+95.
8769 L X+96.
8770 L X+96.507 Y+26.065 FQ4
8771 L X+97.125 Y+26.346
8772 L X+97.359 Y+26.533
8773 L X+97.666 Y+26.894
8774 L X+97.915 Y+27.422
8775 L X+98. Y+28.
8776 L Z+15.
8777 L X+92. FMAX
8778 L Z-6.333 FQ3
8779 L X+92.065 Y+27.493
8780 L X+92.346 Y+26.875
8781 L X+92.533 Y+26.641
8782 L X+92.894 Y+26.334
8783 L X+93.422 Y+26.085
8784 L X+94. Y+26.
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8790 L X+95.
8791 L X+96.
8792 L X+96.507 Y+26.065 FQ4
8793 L X+97.125 Y+26.346
8794 L X+97.359 Y+26.533
8795 L X+97.666 Y+26.894
8796 L X+97.915 Y+27.422
8797 L X+98. Y+28.

8798 L Z+15.
8799 L X+92. FMAX
8800 L Z-6.4 FQ3
8801 L X+92.065 Y+27.493
8802 L X+92.346 Y+26.875
8803 L X+92.533 Y+26.641
8804 L X+92.894 Y+26.334
8805 L X+93.422 Y+26.085
8806 L X+94. Y+26.
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8814 L X+96.507 Y+26.065 FQ4
8815 L X+97.125 Y+26.346
8816 L X+97.359 Y+26.533
8817 L X+97.666 Y+26.894
8818 L X+97.915 Y+27.422
8819 L X+98. Y+28.
8820 L Z+15.
8821 L X+92. FMAX
8822 L Z-6.467 FQ3
8823 L X+92.065 Y+27.493
8824 L X+92.346 Y+26.875
8825 L X+92.533 Y+26.641
8826 L X+92.894 Y+26.334
8827 L X+93.422 Y+26.085
8828 L X+94. Y+26.
8829 L X+95.
8830 L X+99.
8831 L Y+34.
8832 L X+91.
8833 L Y+26.
8834 L X+95.
8835 L X+96.
8836 L X+96.507 Y+26.065 FQ4
8837 L X+97.125 Y+26.346
8838 L X+97.359 Y+26.533
8839 L X+97.666 Y+26.894
8840 L X+97.915 Y+27.422
8841 L X+98. Y+28.
8842 L Z+15.
8843 L X+92. FMAX
8844 L Z-6.533 FQ3
8845 L X+92.065 Y+27.493
8846 L X+92.346 Y+26.875
8847 L X+92.533 Y+26.641
8848 L X+92.894 Y+26.334
8849 L X+93.422 Y+26.085
8850 L X+94. Y+26.
8851 L X+95.
8852 L X+99.
8853 L Y+34.
8854 L X+91.
8855 L Y+26.
8856 L X+95.
8857 L X+96.
8858 L X+96.507 Y+26.065 FQ4
8859 L X+97.125 Y+26.346
8860 L X+97.359 Y+26.533
8861 L X+97.666 Y+26.894
8862 L X+97.915 Y+27.422
8863 L X+98. Y+28.
8864 L Z+15.
8865 L X+92. FMAX
8866 L Z-6.6 FQ3
8867 L X+92.065 Y+27.493
8868 L X+92.346 Y+26.875
8869 L X+92.533 Y+26.641
8870 L X+92.894 Y+26.334
8871 L X+93.422 Y+26.085
8872 L X+94. Y+26.
8873 L X+95.
8874 L X+99.
8875 L Y+34.
8876 L X+91.
8877 L Y+26.
8878 L X+95.
8879 L X+96.
8880 L X+96.507 Y+26.065 FQ4
8881 L X+97.125 Y+26.346
8882 L X+97.359 Y+26.533
8883 L X+97.666 Y+26.894
8884 L X+97.915 Y+27.422
8885 L X+98. Y+28.
8886 L Z+15.
8887 L X+92. FMAX
8888 L Z-6.667 FQ3
8889 L X+92.065 Y+27.493
8890 L X+92.346 Y+26.875
8891 L X+92.533 Y+26.641
8892 L X+92.894 Y+26.334
8893 L X+93.422 Y+26.085
8894 L X+94. Y+26.
8895 L X+95.
8896 L X+99.
8897 L Y+34.
8898 L X+91.

8899 L Y+26.	9000 L X+92.346 Y+26.875	9100 L Y+70.	9201 L X+88.641 Y+72.467	9302 L X+88.533 Y+67.641
8900 L X+95.	9001 L X+92.533 Y+26.641	9101 L Y+69.	9202 L X+88.334 Y+72.106	9303 L X+88.894 Y+67.334
8901 L X+96.	9002 L X+92.894 Y+26.334	9102 L X+88.065 Y+68.493 FQ4	9203 L X+88.085 Y+71.578	9304 L X+89.422 Y+67.085
8902 L X+96.507 Y+26.065 FQ4	9003 L X+93.422 Y+26.085	9103 L X+88.346 Y+67.875	9204 L X+88. Y+71.	9305 L X+90. Y+67.
8903 L X+97.125 Y+26.346	9004 L X+94. Y+26.	9104 L X+88.533 Y+67.641	9205 L Y+70.	9306 L Z+15.
8904 L X+97.359 Y+26.533	9005 L X+95.	9105 L X+88.894 Y+67.334	9206 L Y+63.	9307 L Y+73. FMAX
8905 L X+97.666 Y+26.894	9006 L X+99.	9106 L X+89.422 Y+67.085	9207 L X+102.	9308 L Z-1.4 FQ3
8906 L X+97.915 Y+27.422	9007 L Y+34.	9107 L X+90. Y+67.	9208 L Y+77.	9309 L X+89.493 Y+72.935
8907 L X+98. Y+28.	9008 L X+91.	9108 L Z+15.	9209 L X+88.	9310 L X+88.875 Y+72.654
8908 L Z+15.	9009 L Y+26.	9109 L Y+73. FMAX	9210 L Y+70.	9311 L X+88.641 Y+72.467
8909 L X+92. FMAX	9010 L X+95.	9110 L Z.-5 FQ3	9211 L Y+69.	9312 L X+88.334 Y+72.106
8910 L Z-6.733 FQ3	9011 L X+96.	9111 L X+89.493 Y+72.935	9212 L X+88.065 Y+68.493 FQ4	9313 L X+88.085 Y+71.578
8911 L X+92.065 Y+27.493	9012 L X+96.507 Y+26.065 FQ4	9112 L X+88.875 Y+72.654	9213 L X+88.346 Y+67.875	9314 L X+88. Y+71.
8912 L X+92.346 Y+26.875	9013 L X+97.125 Y+26.346	9113 L X+88.641 Y+72.467	9214 L X+88.533 Y+67.641	9315 L Y+70.
8913 L X+92.533 Y+26.641	9014 L X+97.359 Y+26.533	9114 L X+88.334 Y+72.106	9215 L X+88.894 Y+67.334	9316 L Y+63.
8914 L X+92.894 Y+26.334	9015 L X+97.666 Y+26.894	9115 L X+88.085 Y+71.578	9216 L X+89.422 Y+67.085	9317 L X+102.
8915 L X+93.422 Y+26.085	9016 L X+97.915 Y+27.422	9116 L X+88. Y+71.	9217 L X+90. Y+67.	9318 L Y+77.
8916 L X+94. Y+26.	9017 L X+98. Y+28.	9117 L Y+70.	9218 L Z+15.	9319 L X+88.
8917 L X+95.	9018 L Z+15.	9118 L Y+63.	9219 L Y+73. FMAX	9320 L Y+70.
8918 L X+99.	9019 L X+0.0 Y+0.0 Z+100. FMAX	9119 L X+102.	9220 L Z-1. FQ3	9321 L Y+69.
8919 L Y+34.	9020 L X+90. Y+73. FMAX	9120 L Y+77.	9221 L X+89.493 Y+72.935	9322 L X+88.065 Y+68.493 FQ4
8920 L X+91.	9021 L Z+15. FMAX	9121 L X+88.	9222 L X+88.875 Y+72.654	9323 L X+88.346 Y+67.875
8921 L Y+26.	9022 L Z.-1 FQ3	9122 L Y+70.	9223 L X+88.641 Y+72.467	9324 L X+88.533 Y+67.641
8922 L X+95.	9023 L X+89.493 Y+72.935	9123 L Y+69.	9224 L X+88.334 Y+72.106	9325 L X+88.894 Y+67.334
8923 L X+96.	9024 L X+88.875 Y+72.654	9124 L X+88.065 Y+68.493 FQ4	9225 L X+88.085 Y+71.578	9326 L X+89.422 Y+67.085
8924 L X+96.507 Y+26.065 FQ4	9025 L X+88.641 Y+72.467	9125 L X+88.346 Y+67.875	9226 L X+88. Y+71.	9327 L X+90. Y+67.
8925 L X+97.125 Y+26.346	9026 L X+88.334 Y+72.106	9126 L X+88.533 Y+67.641	9227 L Y+70.	9328 L Z+15.
8926 L X+97.359 Y+26.533	9027 L X+88.085 Y+71.578	9127 L X+88.894 Y+67.334	9228 L Y+63.	9329 L Y+73. FMAX
8927 L X+97.666 Y+26.894	9028 L X+88. Y+71.	9128 L X+89.422 Y+67.085	9229 L X+102.	9330 L Z-1.5 FQ3
8928 L X+97.915 Y+27.422	9029 L Y+70.	9129 L X+90. Y+67.	9230 L Y+77.	9331 L X+89.493 Y+72.935
8929 L X+98. Y+28.	9030 L Y+63.	9130 L Z+15.	9231 L X+88.	9332 L X+88.875 Y+72.654
8930 L Z+15.	9031 L X+102.	9131 L Y+73. FMAX	9232 L Y+70.	9333 L X+88.641 Y+72.467
8931 L X+92. FMAX	9032 L Y+77.	9132 L Z.-6 FQ3	9233 L Y+69.	9334 L X+88.334 Y+72.106
8932 L Z-6.8 FQ3	9033 L X+88.	9133 L X+89.493 Y+72.935	9234 L X+88.065 Y+68.493 FQ4	9335 L X+88.085 Y+71.578
8933 L X+92.065 Y+27.493	9034 L Y+70.	9134 L X+88.875 Y+72.654	9235 L X+88.346 Y+67.875	9336 L X+88. Y+71.
8934 L X+92.346 Y+26.875	9035 L Y+69.	9135 L X+88.641 Y+72.467	9236 L X+88.533 Y+67.641	9337 L Y+70.
8935 L X+92.533 Y+26.641	9036 L X+88.065 Y+68.493 FQ4	9136 L X+88.334 Y+72.106	9237 L X+88.894 Y+67.334	9338 L Y+63.
8936 L X+92.894 Y+26.334	9037 L X+88.346 Y+67.875	9137 L X+88.085 Y+71.578	9238 L X+89.422 Y+67.085	9339 L X+102.
8937 L X+93.422 Y+26.085	9038 L X+88.533 Y+67.641	9138 L X+88. Y+71.	9239 L X+90. Y+67.	9340 L Y+77.
8938 L X+94. Y+26.	9039 L X+88.894 Y+67.334	9139 L Y+70.	9240 L Z+15.	9341 L X+88.
8939 L X+95.	9040 L X+89.422 Y+67.085	9140 L Y+63.	9241 L Y+73. FMAX	9342 L Y+70.
8940 L X+99.	9041 L X+90. Y+67.	9141 L X+102.	9242 L Z-1.1 FQ3	9343 L Y+69.
8941 L Y+34.	9042 L Z+15.	9142 L Y+77.	9243 L X+89.493 Y+72.935	9344 L X+88.065 Y+68.493 FQ4
8942 L X+91.	9043 L Y+73. FMAX	9143 L X+88.	9244 L X+88.875 Y+72.654	9345 L X+88.346 Y+67.875
8943 L Y+26.	9044 L Z.-2 FQ3	9144 L Y+70.	9245 L X+88.641 Y+72.467	9346 L X+88.533 Y+67.641
8944 L X+95.	9045 L X+89.493 Y+72.935	9145 L Y+69.	9246 L X+88.334 Y+72.106	9347 L X+88.894 Y+67.334
8945 L X+96.	9046 L X+88.875 Y+72.654	9146 L X+88.065 Y+68.493 FQ4	9247 L X+88.085 Y+71.578	9348 L X+89.422 Y+67.085
8946 L X+96.507 Y+26.065 FQ4	9047 L X+88.641 Y+72.467	9147 L X+88.346 Y+67.875	9248 L X+88. Y+71.	9349 L X+90. Y+67.
8947 L X+97.125 Y+26.346	9048 L X+88.334 Y+72.106	9148 L X+88.533 Y+67.641	9249 L Y+70.	9350 L Z+15.
8948 L X+97.359 Y+26.533	9049 L X+88.085 Y+71.578	9149 L X+88.894 Y+67.334	9250 L Y+63.	9351 L Y+73. FMAX
8949 L X+97.666 Y+26.894	9050 L X+88. Y+71.	9150 L X+89.422 Y+67.085	9251 L X+102.	9352 L Z-1.6 FQ3
8950 L X+97.915 Y+27.422	9051 L Y+70.	9151 L X+90. Y+67.	9252 L Y+77.	9353 L X+89.493 Y+72.935
8951 L X+98. Y+28.	9052 L Y+63.	9152 L Z+15.	9253 L X+88.	9354 L X+88.875 Y+72.654
8952 L Z+15.	9053 L X+102.	9153 L Y+73. FMAX	9254 L Y+70.	9355 L X+88.641 Y+72.467
8953 L X+92. FMAX	9054 L Y+77.	9154 L Z.-7 FQ3	9255 L Y+69.	9356 L X+88.334 Y+72.106
8954 L Z-6.867 FQ3	9055 L X+88.	9155 L X+89.493 Y+72.935	9256 L X+88.065 Y+68.493 FQ4	9357 L X+88.085 Y+71.578
8955 L X+92.065 Y+27.493	9056 L Y+70.	9156 L X+88.875 Y+72.654	9257 L X+88.346 Y+67.875	9358 L X+88. Y+71.
8956 L X+92.346 Y+26.875	9057 L Y+69.	9157 L X+88.641 Y+72.467	9258 L X+88.533 Y+67.641	9359 L Y+70.
8957 L X+92.533 Y+26.641	9058 L X+88.065 Y+68.493 FQ4	9158 L X+88.334 Y+72.106	9259 L X+88.894 Y+67.334	9360 L Y+63.
8958 L X+92.894 Y+26.334	9059 L X+88.346 Y+67.875	9159 L X+88.085 Y+71.578	9260 L X+89.422 Y+67.085	9361 L X+102.
8959 L X+93.422 Y+26.085	9060 L X+88.533 Y+67.641	9160 L X+88. Y+71.	9261 L X+90. Y+67.	9362 L Y+77.
8960 L X+94. Y+26.	9061 L X+88.894 Y+67.334	9161 L Y+70.	9262 L Z+15.	9363 L X+88.
8961 L X+95.	9062 L X+89.422 Y+67.085	9162 L Y+63.	9263 L Y+73. FMAX	9364 L Y+70.
8962 L X+99.	9063 L X+90. Y+67.	9163 L X+102.	9264 L Z-1.2 FQ3	9365 L Y+69.
8963 L Y+34.	9064 L Z+15.	9164 L Y+77.	9265 L X+89.493 Y+72.935	9366 L X+88.065 Y+68.493 FQ4
8964 L X+91.	9065 L Y+73. FMAX	9165 L X+88.	9266 L X+88.875 Y+72.654	9367 L X+88.346 Y+67.875
8965 L Y+26.	9066 L Z.-3 FQ3	9166 L Y+70.	9267 L X+88.641 Y+72.467	9368 L X+88.533 Y+67.641
8966 L X+95.	9067 L X+89.493 Y+72.935	9167 L Y+69.	9268 L X+88.334 Y+72.106	9369 L X+88.894 Y+67.334
8967 L X+96.	9068 L X+88.875 Y+72.654	9168 L X+88.065 Y+68.493 FQ4	9269 L X+88.085 Y+71.578	9370 L X+89.422 Y+67.085
8968 L X+96.507 Y+26.065 FQ4	9069 L X+88.641 Y+72.467	9169 L X+88.346 Y+67.875	9270 L X+88. Y+71.	9371 L X+90. Y+67.
8969 L X+97.125 Y+26.346	9070 L X+88.334 Y+72.106	9170 L X+88.533 Y+67.641	9271 L Y+70.	9372 L Z+15.
8970 L X+97.359 Y+26.533	9071 L X+88.085 Y+71.578	9171 L X+88.894 Y+67.334	9272 L Y+63.	9373 L Y+73. FMAX
8971 L X+97.666 Y+26.894	9072 L X+88. Y+71.	9172 L X+89.422 Y+67.085	9273 L X+102.	9374 L Z-1.7 FQ3
8972 L X+97.915 Y+27.422	9073 L Y+70.	9173 L X+90. Y+67.	9274 L Y+77.	9375 L X+89.493 Y+72.935
8973 L X+98. Y+28.	9074 L Y+63.	9174 L Z+15.	9275 L X+88.	9376 L X+88.875 Y+72.654
8974 L Z+15.	9075 L X+102.	9175 L Y+73. FMAX	9276 L Y+70.	9377 L X+88.641 Y+72.467
8975 L X+92. FMAX	9076 L Y+77.	9176 L Z.-8 FQ3	9277 L Y+69.	9378 L X+88.334 Y+72.106
8976 L Z-6.933 FQ3	9077 L X+88.	9177 L X+89.493 Y+72.935	9278 L X+88.065 Y+68.493 FQ4	9379 L X+88.085 Y+71.578
8977 L X+92.065 Y+27.493	9078 L Y+70.	9178 L X+88.875 Y+72.654	9279 L X+88.346 Y+67.875	9380 L X+88. Y+71.
8978 L X+92.346 Y+26.875	9079 L Y+69.	9179 L X+88.641 Y+72.467	9280 L X+88.533 Y+67.641	9381 L Y+70.
8979 L X+92.533 Y+26.641	9080 L X+88.065 Y+68.493 FQ4	9180 L X+88.334 Y+72.106	9281 L X+88.894 Y+67.334	9382 L Y+63.
8980 L X+92.894 Y+26.334	9081 L X+88.346 Y+67.875	9181 L X+88.085 Y+71.578	9282 L X+89.422 Y+67.085	9383 L X+102.
8981 L X+93.422 Y+26.085	9082 L X+88.533 Y+67.641	9182 L X+88. Y+71.	9283 L X+90. Y+67.	9384 L Y+77.
8982 L X+94. Y+26.	9083 L X+88.894 Y+67.334	9183 L Y+70.	9284 L Z+15.	9385 L X+88.
8983 L X+95.	9084 L X+89.422 Y+67.085	9184 L Y+63.	9285 L Y+73. FMAX	9386 L Y+70.
8984 L X+99.	9085 L X+90. Y+67.	9185 L X+102.	9286 L Z-1.3 FQ3	9387 L Y+69.
8985 L Y+34.	9086 L Z+15.	9186 L Y+77.	9287 L X+89.493 Y+72.935	9388 L X+88.065 Y+68.493 FQ4
8986 L X+91.	9087 L Y+73. FMAX	9187 L X+88.	9288 L X+88.875 Y+72.654	9389 L X+88.346 Y+67.875
8987 L Y+26.	9088 L Z.-4 FQ3	9188 L Y+70.	9289 L X+88.641 Y+72.467	9390 L X+88.533 Y+67.641
8988 L X+95.	9089 L X+89.493 Y+72.935	9189 L Y+69.	9290 L X+88.334 Y+72.106	9391 L X+88.894 Y+67.334
8989 L X+96.	9090 L X+88.875 Y+72.654	9190 L X+88.065 Y+68.493 FQ4	9291 L X+88.085 Y+71.578	9392 L X+89.422 Y+67.085
8990 L X+96.507 Y+26.065 FQ4	9091 L X+88.641 Y+72.467	9191 L X+88.346 Y+67.875	9292 L X+88. Y+71.	9393 L X+90. Y+67.
8991 L X+97.125 Y+26.346	9092 L X+88.334 Y+72.106	9192 L X+88.533 Y+67.641	9293 L Y+70.	9394 L Z+15.
8992 L X+97.359 Y+26.533	9093 L X+88.085 Y+71.578	9193 L X+88.894 Y+67.334	9294 L Y+63.	9395 L Y+73. FMAX
8993 L X+97.666 Y+26.894	9094 L X+88. Y+71.	9194 L X+89.422 Y+67.085	9295 L X+102.	9396 L Z-1.8 FQ3
8994 L X+97.915 Y+27.422	9095 L Y+70.	9195 L X+90. Y+67.	9296 L Y+77.	9397 L X+89.493 Y+72.935
8995 L X+98. Y+28.	9096 L Y+63.	9196 L Z+15.	9297 L X+88.	9398 L X+88.875 Y+72.654
8996 L Z+15.	9097 L X+102.	9197 L Y+73. FMAX	9298 L Y+70.	9399 L X+88.641 Y+72.467
8997 L X+92. FMAX	9098 L Y+77.	9198 L Z.-9 FQ3	9299 L Y+69.	9400 L X+88.334 Y+72.106
8998 L Z-7. FQ3	9099 L X+88.	9199 L X+89.493 Y+72.935	9300 L X+88.065 Y+68.493 FQ4	9401 L X+88.085 Y+71.578
8999 L X+92.065 Y+27.493		9200 L X+88.875 Y+72.654	9301 L X+88.346 Y+67.875	9402 L X+88. Y+71.

9403 L Y+70.
 9404 L Y+63.
 9405 L X+102.
 9406 L Y+77.
 9407 L X+88.
 9408 L Y+70.
 9409 L Y+69.
 9410 L X+88.065 Y+68.493 FQ4
 9411 L X+88.346 Y+67.875
 9412 L X+88.533 Y+67.641
 9413 L X+88.894 Y+67.334
 9414 L X+89.422 Y+67.085
 9415 L X+90. Y+67.
 9416 L Z+15.
 9417 L Y+73. FMAX
 9418 L Z-1.9 FQ3
 9419 L X+89.493 Y+72.935
 9420 L X+88.875 Y+72.654
 9421 L X+88.641 Y+72.467
 9422 L X+88.334 Y+72.106
 9423 L X+88.085 Y+71.578
 9424 L X+88. Y+71.
 9425 L Y+70.
 9426 L Y+63.
 9427 L X+102.
 9428 L Y+77.
 9429 L X+88.
 9430 L Y+70.
 9431 L Y+69.
 9432 L X+88.065 Y+68.493 FQ4
 9433 L X+88.346 Y+67.875
 9434 L X+88.533 Y+67.641
 9435 L X+88.894 Y+67.334
 9436 L X+89.422 Y+67.085
 9437 L X+90. Y+67.
 9438 L Z+15.
 9439 L Y+73. FMAX
 9440 L Z-2. FQ3
 9441 L X+89.493 Y+72.935
 9442 L X+88.875 Y+72.654
 9443 L X+88.641 Y+72.467
 9444 L X+88.334 Y+72.106
 9445 L X+88.085 Y+71.578
 9446 L X+88. Y+71.
 9447 L Y+70.
 9448 L Y+63.
 9449 L X+102.
 9450 L Y+77.
 9451 L X+88.
 9452 L Y+70.
 9453 L Y+69.
 9454 L X+88.065 Y+68.493 FQ4
 9455 L X+88.346 Y+67.875
 9456 L X+88.533 Y+67.641
 9457 L X+88.894 Y+67.334
 9458 L X+89.422 Y+67.085
 9459 L X+90. Y+67.
 9460 L Z+15.
 9461 L Y+73. FMAX
 9462 L Z-2.1 FQ3
 9463 L X+89.493 Y+72.935
 9464 L X+88.875 Y+72.654
 9465 L X+88.641 Y+72.467
 9466 L X+88.334 Y+72.106
 9467 L X+88.085 Y+71.578
 9468 L X+88. Y+71.
 9469 L Y+70.
 9470 L Y+63.
 9471 L X+102.
 9472 L Y+77.
 9473 L X+88.
 9474 L Y+70.
 9475 L Y+69.
 9476 L X+88.065 Y+68.493 FQ4
 9477 L X+88.346 Y+67.875
 9478 L X+88.533 Y+67.641
 9479 L X+88.894 Y+67.334
 9480 L X+89.422 Y+67.085
 9481 L X+90. Y+67.
 9482 L Z+15.
 9483 L Y+73. FMAX
 9484 L Z-2.2 FQ3
 9485 L X+89.493 Y+72.935
 9486 L X+88.875 Y+72.654
 9487 L X+88.641 Y+72.467
 9488 L X+88.334 Y+72.106
 9489 L X+88.085 Y+71.578
 9490 L X+88. Y+71.
 9491 L Y+70.
 9492 L Y+63.
 9493 L X+102.
 9494 L Y+77.
 9495 L X+88.
 9496 L Y+70.
 9497 L Y+69.
 9498 L X+88.065 Y+68.493 FQ4
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 9500 L X+88.533 Y+67.641
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 162 L X+89.422 Y+67.085
 163 L X+90. Y+67.
 164 L Z+15.
 165 L Y+73. FMAX
 166 L Z-5.3 FQ3
 167 L X+89.493 Y+72.935
 168 L X+88.875 Y+72.654
 169 L X+88.641 Y+72.467
 170 L X+88.334 Y+72.106
 171 L X+88.085 Y+71.578
 172 L X+88. Y+71.
 173 L Y+70.
 174 L Y+63.
 175 L X+102.
 176 L Y+77.
 177 L X+88.
 178 L Y+70.
 179 L Y+69.
 180 L X+88.065 Y+68.493 FQ4
 181 L X+88.346 Y+67.875
 182 L X+88.533 Y+67.641
 183 L X+88.894 Y+67.334
 184 L X+89.422 Y+67.085
 185 L X+90. Y+67.
 186 L Z+15.
 187 L Y+73. FMAX
 188 L Z-5.4 FQ3
 189 L X+89.493 Y+72.935
 190 L X+88.875 Y+72.654
 191 L X+88.641 Y+72.467
 192 L X+88.334 Y+72.106
 193 L X+88.085 Y+71.578
 194 L X+88. Y+71.
 195 L Y+70.
 196 L Y+63.
 197 L X+102.
 198 L Y+77.
 199 L X+88.
 200 L Y+70.
 201 L Y+69.
 202 L X+88.065 Y+68.493 FQ4
 203 L X+88.346 Y+67.875
 204 L X+88.533 Y+67.641
 205 L X+88.894 Y+67.334
 206 L X+89.422 Y+67.085
 207 L X+90. Y+67.
 208 L Z+15.
 209 L Y+73. FMAX
 210 L Z-5.5 FQ3
 211 L X+89.493 Y+72.935
 212 L X+88.875 Y+72.654
 213 L X+88.641 Y+72.467
 214 L X+88.334 Y+72.106
 215 L X+88.085 Y+71.578
 216 L X+88. Y+71.
 217 L Y+70.
 218 L Y+63.
 219 L X+102.
 220 L Y+77.
 221 L X+88.
 222 L Y+70.
 223 L Y+69.
 224 L X+88.065 Y+68.493 FQ4
 225 L X+88.346 Y+67.875
 226 L X+88.533 Y+67.641
 227 L X+88.894 Y+67.334
 228 L X+89.422 Y+67.085
 229 L X+90. Y+67.
 230 L Z+15.
 231 L Y+73. FMAX
 232 L Z-5.6 FQ3
 233 L X+89.493 Y+72.935
 234 L X+88.875 Y+72.654
 235 L X+88.641 Y+72.467
 236 L X+88.334 Y+72.106
 237 L X+88.085 Y+71.578
 238 L X+88. Y+71.
 239 L Y+70.
 240 L Y+63.
 241 L X+102.
 242 L Y+77.
 243 L X+88.
 244 L Y+70.
 245 L Y+69.
 246 L X+88.065 Y+68.493 FQ4
 247 L X+88.346 Y+67.875
 248 L X+88.533 Y+67.641
 249 L X+88.894 Y+67.334
 250 L X+89.422 Y+67.085
 251 L X+90. Y+67.
 252 L Z+15.
 253 L Y+73. FMAX
 254 L Z-5.7 FQ3
 255 L X+89.493 Y+72.935
 256 L X+88.875 Y+72.654
 257 L X+88.641 Y+72.467
 258 L X+88.334 Y+72.106
 259 L X+88.085 Y+71.578
 260 L X+88. Y+71.
 261 L Y+70.
 262 L Y+63.
 263 L X+102.
 264 L Y+77.
 265 L X+88.
 266 L Y+70.
 267 L Y+69.
 268 L X+88.065 Y+68.493 FQ4
 269 L X+88.346 Y+67.875
 270 L X+88.533 Y+67.641
 271 L X+88.894 Y+67.334
 272 L X+89.422 Y+67.085
 273 L X+90. Y+67.
 274 L Z+15.
 275 L Y+73. FMAX
 276 L Z-5.8 FQ3
 277 L X+89.493 Y+72.935
 278 L X+88.875 Y+72.654
 279 L X+88.641 Y+72.467
 280 L X+88.334 Y+72.106
 281 L X+88.085 Y+71.578
 282 L X+88. Y+71.
 283 L Y+70.
 284 L Y+63.
 285 L X+102.
 286 L Y+77.
 287 L X+88.
 288 L Y+70.
 289 L Y+69.
 290 L X+88.065 Y+68.493 FQ4
 291 L X+88.346 Y+67.875
 292 L X+88.533 Y+67.641
 293 L X+88.894 Y+67.334
 294 L X+89.422 Y+67.085
 295 L X+90. Y+67.
 296 L Z+15.
 297 L Y+73. FMAX
 298 L Z-5.9 FQ3
 299 L X+89.493 Y+72.935
 300 L X+88.875 Y+72.654
 301 L X+88.641 Y+72.467
 302 L X+88.334 Y+72.106
 303 L X+88.085 Y+71.578
 304 L X+88. Y+71.
 305 L Y+70.
 306 L Y+63.
 307 L X+102.
 308 L Y+77.
 309 L X+88.
 310 L Y+70.
 311 L Y+69.
 312 L X+88.065 Y+68.493 FQ4
 313 L X+88.346 Y+67.875
 314 L X+88.533 Y+67.641
 315 L X+88.894 Y+67.334
 316 L X+89.422 Y+67.085
 317 L X+90. Y+67.
 318 L Z+15.
 319 L Y+73. FMAX
 320 L Z-6. FQ3
 321 L X+89.493 Y+72.935
 322 L X+88.875 Y+72.654
 323 L X+88.641 Y+72.467
 324 L X+88.334 Y+72.106
 325 L X+88.085 Y+71.578
 326 L X+88. Y+71.
 327 L Y+70.
 328 L Y+63.
 329 L X+102.
 330 L Y+77.
 331 L X+88.
 332 L Y+70.
 333 L Y+69.
 334 L X+88.065 Y+68.493 FQ4
 335 L X+88.346 Y+67.875
 336 L X+88.533 Y+67.641
 337 L X+88.894 Y+67.334
 338 L X+89.422 Y+67.085
 339 L X+90. Y+67.
 340 L Z+15.
 341 L X+0.0 Y+0.0 Z+100. FMAX
 342 L X+92. Y+68. FMAX
 343 L Z+15. FMAX
 344 L Z-6.1 FQ3
 345 L X+92.065 Y+67.493
 346 L X+92.346 Y+66.875
 347 L X+92.533 Y+66.641
 348 L X+92.894 Y+66.334
 349 L X+93.422 Y+66.085
 350 L X+94. Y+66.
 351 L X+95.
 352 L X+99.
 353 L Y+74.
 354 L X+91.
 355 L Y+66.
 356 L X+95.
 357 L X+96.
 358 L X+96.507 Y+66.065 FQ4
 359 L X+97.125 Y+66.346
 360 L X+97.359 Y+66.533
 361 L X+97.666 Y+66.894
 362 L X+97.915 Y+67.422
 363 L X+98. Y+68.
 364 L Z+15.
 365 L X+92. FMAX
 366 L Z-6.2 FQ3
 367 L X+92.065 Y+67.493
 368 L X+92.346 Y+66.875
 369 L X+92.533 Y+66.641
 370 L X+92.894 Y+66.334
 371 L X+93.422 Y+66.085
 372 L X+94. Y+66.
 373 L X+95.
 374 L X+99.
 375 L Y+74.
 376 L X+91.
 377 L Y+66.
 378 L X+95.
 379 L X+96.
 380 L X+96.507 Y+66.065 FQ4
 381 L X+97.125 Y+66.346
 382 L X+97.359 Y+66.533
 383 L X+97.666 Y+66.894
 384 L X+97.915 Y+67.422
 385 L X+98. Y+68.
 386 L Z+15.
 387 L X+92. FMAX
 388 L Z-6.3 FQ3
 389 L X+92.065 Y+67.493
 390 L X+92.346 Y+66.875
 391 L X+92.533 Y+66.641
 392 L X+92.894 Y+66.334
 393 L X+93.422 Y+66.085
 394 L X+94. Y+66.
 395 L X+95.
 396 L X+99.
 397 L Y+74.
 398 L X+91.
 399 L Y+66.
 400 L X+95.
 401 L X+96.
 402 L X+96.507 Y+66.065 FQ4
 403 L X+97.125 Y+66.346
 404 L X+97.359 Y+66.533
 405 L X+97.666 Y+66.894
 406 L X+97.915 Y+67.422
 407 L X+98. Y+68.
 408 L Z+15.
 409 L X+92. FMAX
 410 L Z-6.4 FQ3
 411 L X+92.065 Y+67.493

412 L X+92.346 Y+66.875	513 L X+97.125 Y+66.346	614 L X+94. Y+66.	715 L X+98. Y+68.	816 L X+91.
413 L X+92.533 Y+66.641	514 L X+97.359 Y+66.533	615 L X+95.	716 L Z+15.	817 L Y+66.
414 L X+92.894 Y+66.334	515 L X+97.666 Y+66.894	616 L X+99.	717 L X+92. FMAX	818 L X+95.
415 L X+93.422 Y+66.085	516 L X+97.915 Y+67.422	617 L Y+74.	718 L Z-7.8 FQ3	819 L X+96.
416 L X+94. Y+66.	517 L X+98. Y+68.	618 L X+91.	719 L X+92.065 Y+67.493	820 L X+96.507 Y+66.065 FQ4
417 L X+95.	518 L Z+15.	619 L Y+66.	720 L X+92.346 Y+66.875	821 L X+97.125 Y+66.346
418 L X+99.	519 L X+92. FMAX	620 L X+95.	721 L X+92.533 Y+66.641	822 L X+97.359 Y+66.533
419 L Y+74.	520 L Z-6.9 FQ3	621 L X+96.	722 L X+92.894 Y+66.334	823 L X+97.666 Y+66.894
420 L X+91.	521 L X+92.065 Y+67.493	622 L X+96.507 Y+66.065 FQ4	723 L X+93.422 Y+66.085	824 L X+97.915 Y+67.422
421 L Y+66.	522 L X+92.346 Y+66.875	623 L X+97.125 Y+66.346	724 L X+94. Y+66.	825 L X+98. Y+68.
422 L X+95.	523 L X+92.533 Y+66.641	624 L X+97.359 Y+66.533	725 L X+95.	826 L Z+15.
423 L X+96.	524 L X+92.894 Y+66.334	625 L X+97.666 Y+66.894	726 L X+99.	827 L X+92. FMAX
424 L X+96.507 Y+66.065 FQ4	525 L X+93.422 Y+66.085	626 L X+97.915 Y+67.422	727 L Y+74.	828 L Z-8.3 FQ3
425 L X+97.125 Y+66.346	526 L X+94. Y+66.	627 L X+98. Y+68.	728 L X+91.	829 L X+92.065 Y+67.493
426 L X+97.359 Y+66.533	527 L X+95.	628 L Z+15.	729 L Y+66.	830 L X+92.346 Y+66.875
427 L X+97.666 Y+66.894	528 L X+99.	629 L X+92. FMAX	730 L X+95.	831 L X+92.533 Y+66.641
428 L X+97.915 Y+67.422	529 L Y+74.	630 L Z-7.4 FQ3	731 L X+96.	832 L X+92.894 Y+66.334
429 L X+98. Y+68.	530 L X+91.	631 L X+92.065 Y+67.493	732 L X+96.507 Y+66.065 FQ4	833 L X+93.422 Y+66.085
430 L Z+15.	531 L Y+66.	632 L X+92.346 Y+66.875	733 L X+97.125 Y+66.346	834 L X+94. Y+66.
431 L X+92. FMAX	532 L X+95.	633 L X+92.533 Y+66.641	734 L X+97.359 Y+66.533	835 L X+95.
432 L Z-6.5 FQ3	533 L X+96.	634 L X+92.894 Y+66.334	735 L X+97.666 Y+66.894	836 L X+99.
433 L X+92.065 Y+67.493	534 L X+96.507 Y+66.065 FQ4	635 L X+93.422 Y+66.085	736 L X+97.915 Y+67.422	837 L Y+74.
434 L X+92.346 Y+66.875	535 L X+97.125 Y+66.346	636 L X+94. Y+66.	737 L X+98. Y+68.	838 L X+91.
435 L X+92.533 Y+66.641	536 L X+97.359 Y+66.533	637 L X+95.	738 L Z+15.	839 L Y+66.
436 L X+92.894 Y+66.334	537 L X+97.666 Y+66.894	638 L X+99.	739 L X+92. FMAX	840 L X+95.
437 L X+93.422 Y+66.085	538 L X+97.915 Y+67.422	639 L Y+74.	740 L Z-7.9 FQ3	841 L X+96.
438 L X+94. Y+66.	539 L X+98. Y+68.	640 L X+91.	741 L X+92.065 Y+67.493	842 L X+96.507 Y+66.065 FQ4
439 L X+95.	540 L Z+15.	641 L Y+66.	742 L X+92.346 Y+66.875	843 L X+97.125 Y+66.346
440 L X+99.	541 L X+92. FMAX	642 L X+95.	743 L X+92.533 Y+66.641	844 L X+97.359 Y+66.533
441 L Y+74.	542 L Z-7. FQ3	643 L X+96.	744 L X+92.894 Y+66.334	845 L X+97.666 Y+66.894
442 L X+91.	543 L X+92.065 Y+67.493	644 L X+96.507 Y+66.065 FQ4	745 L X+93.422 Y+66.085	846 L X+97.915 Y+67.422
443 L Y+66.	544 L X+92.346 Y+66.875	645 L X+97.125 Y+66.346	746 L X+94. Y+66.	847 L X+98. Y+68.
444 L X+95.	545 L X+92.533 Y+66.641	646 L X+97.359 Y+66.533	747 L X+95.	848 L Z+15.
445 L X+96.	546 L X+92.894 Y+66.334	647 L X+97.666 Y+66.894	748 L X+99.	849 L X+92. FMAX
446 L X+96.507 Y+66.065 FQ4	547 L X+93.422 Y+66.085	648 L X+97.915 Y+67.422	749 L Y+74.	850 L Z-8.4 FQ3
447 L X+97.125 Y+66.346	548 L X+94. Y+66.	649 L X+98. Y+68.	750 L X+91.	851 L X+92.065 Y+67.493
448 L X+97.359 Y+66.533	549 L X+95.	650 L Z+15.	751 L Y+66.	852 L X+92.346 Y+66.875
449 L X+97.666 Y+66.894	550 L X+99.	651 L X+92. FMAX	752 L X+95.	853 L X+92.533 Y+66.641
450 L X+97.915 Y+67.422	551 L Y+74.	652 L Z-7.5 FQ3	753 L X+96.	854 L X+92.894 Y+66.334
451 L X+98. Y+68.	552 L X+91.	653 L X+92.065 Y+67.493	754 L X+96.507 Y+66.065 FQ4	855 L X+93.422 Y+66.085
452 L Z+15.	553 L Y+66.	654 L X+92.346 Y+66.875	755 L X+97.125 Y+66.346	856 L X+94. Y+66.
453 L X+92. FMAX	554 L X+95.	655 L X+92.533 Y+66.641	756 L X+97.359 Y+66.533	857 L X+95.
454 L Z-6.6 FQ3	555 L X+96.	656 L X+92.894 Y+66.334	757 L X+97.666 Y+66.894	858 L X+99.
455 L X+92.065 Y+67.493	556 L X+96.507 Y+66.065 FQ4	657 L X+93.422 Y+66.085	758 L X+97.915 Y+67.422	859 L Y+74.
456 L X+92.346 Y+66.875	557 L X+97.125 Y+66.346	658 L X+94. Y+66.	759 L X+98. Y+68.	860 L X+91.
457 L X+92.533 Y+66.641	558 L X+97.359 Y+66.533	659 L X+95.	760 L Z+15.	861 L Y+66.
458 L X+92.894 Y+66.334	559 L X+97.666 Y+66.894	660 L X+99.	761 L X+92. FMAX	862 L X+95.
459 L X+93.422 Y+66.085	560 L X+97.915 Y+67.422	661 L Y+74.	762 L Z-8. FQ3	863 L X+96.
460 L X+94. Y+66.	561 L X+98. Y+68.	662 L X+91.	763 L X+92.065 Y+67.493	864 L X+96.507 Y+66.065 FQ4
461 L X+95.	562 L Z+15.	663 L Y+66.	764 L X+92.346 Y+66.875	865 L X+97.125 Y+66.346
462 L X+99.	563 L X+92. FMAX	664 L X+95.	765 L X+92.533 Y+66.641	866 L X+97.359 Y+66.533
463 L Y+74.	564 L Z-7.1 FQ3	665 L X+96.	766 L X+92.894 Y+66.334	867 L X+97.666 Y+66.894
464 L X+91.	565 L X+92.065 Y+67.493	666 L X+96.507 Y+66.065 FQ4	767 L X+93.422 Y+66.085	868 L X+97.915 Y+67.422
465 L Y+66.	566 L X+92.346 Y+66.875	667 L X+97.125 Y+66.346	768 L X+94. Y+66.	869 L X+98. Y+68.
466 L X+95.	567 L X+92.533 Y+66.641	668 L X+97.359 Y+66.533	769 L X+95.	870 L Z+15.
467 L X+96.	568 L X+92.894 Y+66.334	669 L X+97.666 Y+66.894	770 L X+99.	871 L X+92. FMAX
468 L X+96.507 Y+66.065 FQ4	569 L X+93.422 Y+66.085	670 L X+97.915 Y+67.422	771 L Y+74.	872 L Z-8.5 FQ3
469 L X+97.125 Y+66.346	570 L X+94. Y+66.	671 L X+98. Y+68.	772 L X+91.	873 L X+92.065 Y+67.493
470 L X+97.359 Y+66.533	571 L X+95.	672 L Z+15.	773 L Y+66.	874 L X+92.346 Y+66.875
471 L X+97.666 Y+66.894	572 L X+99.	673 L X+92. FMAX	774 L X+95.	875 L X+92.533 Y+66.641
472 L X+97.915 Y+67.422	573 L Y+74.	674 L Z-7.6 FQ3	775 L X+96.	876 L X+92.894 Y+66.334
473 L X+98. Y+68.	574 L X+91.	675 L X+92.065 Y+67.493	776 L X+96.507 Y+66.065 FQ4	877 L X+93.422 Y+66.085
474 L Z+15.	575 L Y+66.	676 L X+92.346 Y+66.875	777 L X+97.125 Y+66.346	878 L X+94. Y+66.
475 L X+92. FMAX	576 L X+95.	677 L X+92.533 Y+66.641	778 L X+97.359 Y+66.533	879 L X+95.
476 L Z-6.7 FQ3	577 L X+96.	678 L X+92.894 Y+66.334	779 L X+97.666 Y+66.894	880 L X+99.
477 L X+92.065 Y+67.493	578 L X+96.507 Y+66.065 FQ4	679 L X+93.422 Y+66.085	780 L X+97.915 Y+67.422	881 L Y+74.
478 L X+92.346 Y+66.875	579 L X+97.125 Y+66.346	680 L X+94. Y+66.	781 L X+98. Y+68.	882 L X+91.
479 L X+92.533 Y+66.641	580 L X+97.359 Y+66.533	681 L X+95.	782 L Z+15.	883 L Y+66.
480 L X+92.894 Y+66.334	581 L X+97.666 Y+66.894	682 L X+99.	783 L X+92. FMAX	884 L X+95.
481 L X+93.422 Y+66.085	582 L X+97.915 Y+67.422	683 L Y+74.	784 L Z-8.1 FQ3	885 L X+96.
482 L X+94. Y+66.	583 L X+98. Y+68.	684 L X+91.	785 L X+92.065 Y+67.493	886 L X+96.507 Y+66.065 FQ4
483 L X+95.	584 L Z+15.	685 L Y+66.	786 L X+92.346 Y+66.875	887 L X+97.125 Y+66.346
484 L X+99.	585 L X+92. FMAX	686 L X+95.	787 L X+92.533 Y+66.641	888 L X+97.359 Y+66.533
485 L Y+74.	586 L Z-7.2 FQ3	687 L X+96.	788 L X+92.894 Y+66.334	889 L X+97.666 Y+66.894
486 L X+91.	587 L X+92.065 Y+67.493	688 L X+96.507 Y+66.065 FQ4	789 L X+93.422 Y+66.085	890 L X+97.915 Y+67.422
487 L Y+66.	588 L X+92.346 Y+66.875	689 L X+97.125 Y+66.346	790 L X+94. Y+66.	891 L X+98. Y+68.
488 L X+95.	589 L X+92.533 Y+66.641	690 L X+97.359 Y+66.533	791 L X+95.	892 L Z+15.
489 L X+96.	590 L X+92.894 Y+66.334	691 L X+97.666 Y+66.894	792 L X+99.	893 L X+92. FMAX
490 L X+96.507 Y+66.065 FQ4	591 L X+93.422 Y+66.085	692 L X+97.915 Y+67.422	793 L Y+74.	894 L Z-8.6 FQ3
491 L X+97.125 Y+66.346	592 L X+94. Y+66.	693 L X+98. Y+68.	794 L X+91.	895 L X+92.065 Y+67.493
492 L X+97.359 Y+66.533	593 L X+95.	694 L Z+15.	795 L Y+66.	896 L X+92.346 Y+66.875
493 L X+97.666 Y+66.894	594 L X+99.	695 L X+92. FMAX	796 L X+95.	897 L X+92.533 Y+66.641
494 L X+97.915 Y+67.422	595 L Y+74.	696 L Z-7.7 FQ3	797 L X+96.	898 L X+92.894 Y+66.334
495 L X+98. Y+68.	596 L X+91.	697 L X+92.065 Y+67.493	798 L X+96.507 Y+66.065 FQ4	899 L X+93.422 Y+66.085
496 L Z+15.	597 L Y+66.	698 L X+92.346 Y+66.875	799 L X+97.125 Y+66.346	900 L X+94. Y+66.
497 L X+92. FMAX	598 L X+95.	699 L X+92.533 Y+66.641	800 L X+97.359 Y+66.533	901 L X+95.
498 L Z-6.8 FQ3	599 L X+96.	700 L X+92.894 Y+66.334	801 L X+97.666 Y+66.894	902 L X+99.
499 L X+92.065 Y+67.493	600 L X+96.507 Y+66.065 FQ4	701 L X+93.422 Y+66.085	802 L X+97.915 Y+67.422	903 L Y+74.
500 L X+92.346 Y+66.875	601 L X+97.125 Y+66.346	702 L X+94. Y+66.	803 L X+98. Y+68.	904 L X+91.
501 L X+92.533 Y+66.641	602 L X+97.359 Y+66.533	703 L X+95.	804 L Z+15.	905 L Y+66.
502 L X+92.894 Y+66.334	603 L X+97.666 Y+66.894	704 L X+99.	805 L X+92. FMAX	906 L X+95.
503 L X+93.422 Y+66.085	604 L X+97.915 Y+67.422	705 L Y+74.	806 L Z-8.2 FQ3	907 L X+96.
504 L X+94. Y+66.	605 L X+98. Y+68.	706 L X+91.	807 L X+92.065 Y+67.493	908 L X+96.507 Y+66.065 FQ4
505 L X+95.	606 L Z+15.	707 L Y+66.	808 L X+92.346 Y+66.875	909 L X+97.125 Y+66.346
506 L X+99.	607 L X+92. FMAX	708 L X+95.	809 L X+92.533 Y+66.641	910 L X+97.359 Y+66.533
507 L Y+74.	608 L Z-7.3 FQ3	709 L X+96.	810 L X+92.894 Y+66.334	911 L X+97.666 Y+66.894
508 L X+91.	609 L X+92.065 Y+67.493	710 L X+96.507 Y+66.065 FQ4	811 L X+93.422 Y+66.085	912 L X+97.915 Y+67.422
509 L Y+66.	610 L X+92.346 Y+66.875	711 L X+97.125 Y+66.346	812 L X+94. Y+66.	913 L X+98. Y+68.
510 L X+95.	611 L X+92.533 Y+66.641	712 L X+97.359 Y+66.533	813 L X+95.	914 L Z+15.
511 L X+96.	612 L X+92.894 Y+66.334	713 L X+97.666 Y+66.894	814 L X+99.	915 L X+92. FMAX
512 L X+96.507 Y+66.065 FQ4	613 L X+93.422 Y+66.085	714 L X+97.915 Y+67.422	815 L Y+74.	916 L Z-8.7 FQ3

917 L X+92.065 Y+67.493
 918 L X+92.346 Y+66.875
 919 L X+92.533 Y+66.641
 920 L X+92.894 Y+66.334
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 2207 L Y+69.
 2208 L X+126.065 Y+68.493 FQ4
 2209 L X+126.346 Y+67.875
 2210 L X+126.533 Y+67.641
 2211 L X+126.894 Y+67.334
 2212 L X+127.422 Y+67.085
 2213 L X+128. Y+67.
 2214 L Z+15.
 2215 L Y+73. FMAX
 2216 L Z-7.8 FQ3
 2217 L X+127.493 Y+72.935
 2218 L X+126.875 Y+72.654
 2219 L X+126.641 Y+72.467
 2220 L X+126.334 Y+72.106
 2221 L X+126.085 Y+71.578
 2222 L X+126. Y+71.
 2223 L Y+70.
 2224 L Y+66.
 2225 L X+134.
 2226 L Y+74.
 2227 L X+126.
 2228 L Y+70.
 2229 L Y+69.
 2230 L X+126.065 Y+68.493 FQ4
 2231 L X+126.346 Y+67.875
 2232 L X+126.533 Y+67.641
 2233 L X+126.894 Y+67.334
 2234 L X+127.422 Y+67.085
 2235 L X+128. Y+67.
 2236 L Z+15.
 2237 L Y+73. FMAX
 2238 L Z-8.1 FQ3
 2239 L X+127.493 Y+72.935
 2240 L X+126.875 Y+72.654
 2241 L X+126.641 Y+72.467
 2242 L X+126.334 Y+72.106
 2243 L X+126.085 Y+71.578
 2244 L X+126. Y+71.
 2245 L Y+70.
 2246 L Y+66.
 2247 L X+134.
 2248 L Y+74.
 2249 L X+126.
 2250 L Y+70.
 2251 L Y+69.
 2252 L X+126.065 Y+68.493 FQ4
 2253 L X+126.346 Y+67.875
 2254 L X+126.533 Y+67.641
 2255 L X+126.894 Y+67.334
 2256 L X+127.422 Y+67.085
 2257 L X+128. Y+67.
 2258 L Z+15.
 2259 L Y+73. FMAX
 2260 L Z-8.4 FQ3
 2261 L X+127.493 Y+72.935
 2262 L X+126.875 Y+72.654
 2263 L X+126.641 Y+72.467
 2264 L X+126.334 Y+72.106
 2265 L X+126.085 Y+71.578
 2266 L X+126. Y+71.
 2267 L Y+70.
 2268 L Y+66.
 2269 L X+134.
 2270 L Y+74.
 2271 L X+126.
 2272 L Y+70.
 2273 L Y+69.
 2274 L X+126.065 Y+68.493 FQ4
 2275 L X+126.346 Y+67.875
 2276 L X+126.533 Y+67.641
 2277 L X+126.894 Y+67.334
 2278 L X+127.422 Y+67.085
 2279 L X+128. Y+67.
 2280 L Z+15.
 2281 L Y+73. FMAX
 2282 L Z-8.7 FQ3
 2283 L X+127.493 Y+72.935
 2284 L X+126.875 Y+72.654
 2285 L X+126.641 Y+72.467
 2286 L X+126.334 Y+72.106
 2287 L X+126.085 Y+71.578
 2288 L X+126. Y+71.
 2289 L Y+70.
 2290 L Y+66.
 2291 L X+134.
 2292 L Y+74.
 2293 L X+126.
 2294 L Y+70.
 2295 L Y+69.
 2296 L X+126.065 Y+68.493 FQ4
 2297 L X+126.346 Y+67.875
 2298 L X+126.533 Y+67.641
 2299 L X+126.894 Y+67.334
 2300 L X+127.422 Y+67.085
 2301 L X+128. Y+67.
 2302 L Z+15.
 2303 L Y+73. FMAX
 2304 L Z-9. FQ3
 2305 L X+127.493 Y+72.935
 2306 L X+126.875 Y+72.654
 2307 L X+126.641 Y+72.467
 2308 L X+126.334 Y+72.106
 2309 L X+126.085 Y+71.578
 2310 L X+126. Y+71.
 2311 L Y+70.
 2312 L Y+66.
 2313 L X+134.
 2314 L Y+74.
 2315 L X+126.
 2316 L Y+70.
 2317 L Y+69.
 2318 L X+126.065 Y+68.493 FQ4
 2319 L X+126.346 Y+67.875
 2320 L X+126.533 Y+67.641
 2321 L X+126.894 Y+67.334
 2322 L X+127.422 Y+67.085
 2323 L X+128. Y+67.
 2324 L Z+15.
 2325 L Y+73. FMAX
 2326 L Z-9.3 FQ3
 2327 L X+127.493 Y+72.935
 2328 L X+126.875 Y+72.654
 2329 L X+126.641 Y+72.467
 2330 L X+126.334 Y+72.106
 2331 L X+126.085 Y+71.578
 2332 L X+126. Y+71.
 2333 L Y+70.
 2334 L Y+66.
 2335 L X+134.
 2336 L Y+74.
 2337 L X+126.
 2338 L Y+70.
 2339 L Y+69.
 2340 L X+126.065 Y+68.493 FQ4
 2341 L X+126.346 Y+67.875
 2342 L X+126.533 Y+67.641
 2343 L X+126.894 Y+67.334
 2344 L X+127.422 Y+67.085
 2345 L X+128. Y+67.
 2346 L Z+15.
 2347 L Y+73. FMAX
 2348 L Z-9.6 FQ3
 2349 L X+127.493 Y+72.935
 2350 L X+126.875 Y+72.654
 2351 L X+126.641 Y+72.467
 2352 L X+126.334 Y+72.106
 2353 L X+126.085 Y+71.578
 2354 L X+126. Y+71.
 2355 L Y+70.
 2356 L Y+66.
 2357 L X+134.
 2358 L Y+74.
 2359 L X+126.
 2360 L Y+70.
 2361 L Y+69.
 2362 L X+126.065 Y+68.493 FQ4
 2363 L X+126.346 Y+67.875
 2364 L X+126.533 Y+67.641
 2365 L X+126.894 Y+67.334
 2366 L X+127.422 Y+67.085
 2367 L X+128. Y+67.
 2368 L Z+15.
 2369 L Y+73. FMAX
 2370 L Z-9.9 FQ3
 2371 L X+127.493 Y+72.935
 2372 L X+126.875 Y+72.654
 2373 L X+126.641 Y+72.467
 2374 L X+126.334 Y+72.106
 2375 L X+126.085 Y+71.578
 2376 L X+126. Y+71.
 2377 L Y+70.
 2378 L Y+66.
 2379 L X+134.
 2380 L Y+74.
 2381 L X+126.
 2382 L Y+70.
 2383 L Y+69.
 2384 L X+126.065 Y+68.493 FQ4
 2385 L X+126.346 Y+67.875
 2386 L X+126.533 Y+67.641
 2387 L X+126.894 Y+67.334
 2388 L X+127.422 Y+67.085
 2389 L X+128. Y+67.
 2390 L Z+15.
 2391 L Y+73. FMAX
 2392 L Z-10.2 FQ3
 2393 L X+127.493 Y+72.935
 2394 L X+126.875 Y+72.654
 2395 L X+126.641 Y+72.467
 2396 L X+126.334 Y+72.106
 2397 L X+126.085 Y+71.578

2398 L X+126. Y+71.	2494 L X+126.065 Y+68.493 FQ4	2590 L Z-12.9 FQ3	2687 L X+134.	2783 L X+126.894 Y+67.334
2399 L Y+70.	2495 L X+126.346 Y+67.875	2591 L X+127.493 Y+72.935	2688 L Y+74.	2784 L X+127.422 Y+67.085
2400 L Y+66.	2496 L X+126.533 Y+67.641	2592 L X+126.875 Y+72.654	2689 L X+126.	2785 L X+128. Y+67.
2401 L X+134.	2497 L X+126.894 Y+67.334	2593 L X+126.641 Y+72.467	2690 L Y+70.	2786 L Z+15.
2402 L Y+74.	2498 L X+127.422 Y+67.085	2594 L X+126.334 Y+72.106	2691 L Y+69.	2787 L Y+73. FMAX
2403 L X+126.	2499 L X+128. Y+67.	2595 L X+126.085 Y+71.578	2692 L X+126.065 Y+68.493	2788 L Z-15.6 FQ3
2404 L Y+70.	2500 L Z+15.	2596 L X+126. Y+71.	2693 L X+126.346 Y+67.875	2789 L X+127.493 Y+72.935
2405 L Y+69.	2501 L Y+73. FMAX	2597 L Y+70.	2694 L X+126.533 Y+67.641	2790 L X+126.875 Y+72.654
2406 L X+126.065 Y+68.493 FQ4	2502 L Z-11.7 FQ3	2598 L Y+66.	2695 L X+126.894 Y+67.334	2791 L X+126.641 Y+72.467
2407 L X+126.346 Y+67.875	2503 L X+127.493 Y+72.935	2599 L X+134.	2696 L X+127.422 Y+67.085	2792 L X+126.334 Y+72.106
2408 L X+126.533 Y+67.641	2504 L X+126.875 Y+72.654	2600 L Y+74.	2697 L X+128. Y+67.	2793 L X+126.085 Y+71.578
2409 L X+126.894 Y+67.334	2505 L X+126.641 Y+72.467	2601 L X+126.	2698 L Z+15.	2794 L X+126. Y+71.
2410 L X+127.422 Y+67.085	2506 L X+126.334 Y+72.106	2602 L Y+70.	2699 L Y+73. FMAX	2795 L Y+70.
2411 L X+128. Y+67.	2507 L X+126.085 Y+71.578	2603 L Y+69.	2700 L Z-14.4 FQ3	2796 L Y+66.
2412 L Z+15.	2508 L X+126. Y+71.	2604 L X+126.065 Y+68.493 FQ4	2701 L X+127.493 Y+72.935	2797 L X+134.
2413 L Y+73. FMAX	2509 L Y+70.	2605 L X+126.346 Y+67.875	2702 L X+126.875 Y+72.654	2798 L Y+74.
2414 L Z-10.5 FQ3	2510 L Y+66.	2606 L X+126.533 Y+67.641	2703 L X+126.641 Y+72.467	2799 L X+126.
2415 L X+127.493 Y+72.935	2511 L X+134.	2607 L X+126.894 Y+67.334	2704 L X+126.334 Y+72.106	2800 L Y+70.
2416 L X+126.875 Y+72.654	2512 L Y+74.	2608 L X+127.422 Y+67.085	2705 L X+126.085 Y+71.578	2801 L Y+69.
2417 L X+126.641 Y+72.467	2513 L X+126.	2609 L X+128. Y+67.	2706 L X+126. Y+71.	2802 L X+126.065 Y+68.493
2418 L X+126.334 Y+72.106	2514 L Y+70.	2610 L Z+15.	2707 L Y+70.	2803 L X+126.346 Y+67.875
2419 L X+126.085 Y+71.578	2515 L Y+69.	2611 L Y+73. FMAX	2708 L Y+66.	2804 L X+126.533 Y+67.641
2420 L X+126. Y+71.	2516 L X+126.065 Y+68.493 FQ4	2612 L Z-13.2 FQ3	2709 L X+134.	2805 L X+126.894 Y+67.334
2421 L Y+70.	2517 L X+126.346 Y+67.875	2613 L X+127.493 Y+72.935	2710 L Y+74.	2806 L X+127.422 Y+67.085
2422 L Y+66.	2518 L X+126.533 Y+67.641	2614 L X+126.875 Y+72.654	2711 L X+126.	2807 L X+128. Y+67.
2423 L X+134.	2519 L X+126.894 Y+67.334	2615 L X+126.641 Y+72.467	2712 L Y+70.	2808 L Z+15.
2424 L Y+74.	2520 L X+127.422 Y+67.085	2616 L X+126.334 Y+72.106	2713 L Y+69.	2809 L Y+73. FMAX
2425 L X+126.	2521 L X+128. Y+67.	2617 L X+126.085 Y+71.578	2714 L X+126.065 Y+68.493 FQ4	2810 L Z-15.9 FQ3
2426 L Y+70.	2522 L Z+15.	2618 L X+126. Y+71.	2715 L X+126.346 Y+67.875	2811 L X+127.493 Y+72.935
2427 L Y+69.	2523 L Y+73. FMAX	2619 L Y+70.	2716 L X+126.533 Y+67.641	2812 L X+126.875 Y+72.654
2428 L X+126.065 Y+68.493 FQ4	2524 L Z-12. FQ3	2620 L Y+66.	2717 L X+126.894 Y+67.334	2813 L X+126.641 Y+72.467
2429 L X+126.346 Y+67.875	2525 L X+127.493 Y+72.935	2621 L X+134.	2718 L X+127.422 Y+67.085	2814 L X+126.334 Y+72.106
2430 L X+126.533 Y+67.641	2526 L X+126.875 Y+72.654	2622 L Y+74.	2719 L X+128. Y+67.	2815 L X+126.085 Y+71.578
2431 L X+126.894 Y+67.334	2527 L X+126.641 Y+72.467	2623 L X+126.	2720 L Z+15.	2816 L X+126. Y+71.
2432 L X+127.422 Y+67.085	2528 L X+126.334 Y+72.106	2624 L Y+70.	2721 L Y+73. FMAX	2817 L Y+70.
2433 L X+128. Y+67.	2529 L X+126.085 Y+71.578	2625 L Y+69.	2722 L Z-14.7 FQ3	2818 L Y+66.
2434 L Z+15.	2530 L X+126. Y+71.	2626 L X+126.065 Y+68.493 FQ4	2723 L X+127.493 Y+72.935	2819 L X+134.
2435 L Y+73. FMAX	2531 L Y+70.	2627 L X+126.346 Y+67.875	2724 L X+126.875 Y+72.654	2820 L Y+74.
2436 L Z-10.8 FQ3	2532 L Y+66.	2628 L X+126.533 Y+67.641	2725 L X+126.641 Y+72.467	2821 L X+126.
2437 L X+127.493 Y+72.935	2533 L X+134.	2629 L X+126.894 Y+67.334	2726 L X+126.334 Y+72.106	2822 L Y+70.
2438 L X+126.875 Y+72.654	2534 L Y+74.	2630 L X+127.422 Y+67.085	2727 L X+126.085 Y+71.578	2823 L Y+69.
2439 L X+126.641 Y+72.467	2535 L X+126.	2631 L X+128. Y+67.	2728 L X+126. Y+71.	2824 L X+126.065 Y+68.493
2440 L X+126.334 Y+72.106	2536 L Y+70.	2632 L Z+15.	2729 L Y+70.	2825 L X+126.346 Y+67.875
2441 L X+126.085 Y+71.578	2537 L Y+69.	2633 L Y+73. FMAX	2730 L Y+66.	2826 L X+126.533 Y+67.641
2442 L X+126. Y+71.	2538 L X+126.065 Y+68.493 FQ4	2634 L Z-13.5 FQ3	2731 L X+134.	2827 L X+126.894 Y+67.334
2443 L Y+70.	2539 L X+126.346 Y+67.875	2635 L X+127.493 Y+72.935	2732 L Y+74.	2828 L X+127.422 Y+67.085
2444 L Y+66.	2540 L X+126.533 Y+67.641	2636 L X+126.875 Y+72.654	2733 L X+126.	2829 L X+128. Y+67.
2445 L X+134.	2541 L X+126.894 Y+67.334	2637 L X+126.641 Y+72.467	2734 L Y+70.	2830 L Z+15.
2446 L Y+74.	2542 L X+127.422 Y+67.085	2638 L X+126.334 Y+72.106	2735 L Y+69.	2831 L Y+73. FMAX
2447 L X+126.	2543 L X+128. Y+67.	2639 L X+126.085 Y+71.578	2736 L X+126.065 Y+68.493 FQ4	2832 L Z-16.2 FQ3
2448 L Y+70.	2544 L Z+15.	2640 L X+126. Y+71.	2737 L X+126.346 Y+67.875	2833 L X+127.493 Y+72.935
2449 L Y+69.	2545 L Y+73. FMAX	2641 L Y+70.	2738 L X+126.533 Y+67.641	2834 L X+126.875 Y+72.654
2450 L X+126.065 Y+68.493 FQ4	2546 L Z-12.3 FQ3	2642 L Y+66.	2739 L X+126.894 Y+67.334	2835 L X+126.641 Y+72.467
2451 L X+126.346 Y+67.875	2547 L X+127.493 Y+72.935	2643 L X+134.	2740 L X+127.422 Y+67.085	2836 L X+126.334 Y+72.106
2452 L X+126.533 Y+67.641	2548 L X+126.875 Y+72.654	2644 L Y+74.	2741 L X+128. Y+67.	2837 L X+126.085 Y+71.578
2453 L X+126.894 Y+67.334	2549 L X+126.641 Y+72.467	2645 L X+126.	2742 L Z+15.	2838 L X+126. Y+71.
2454 L X+127.422 Y+67.085	2550 L X+126.334 Y+72.106	2646 L Y+70.	2743 L Y+73. FMAX	2839 L Y+70.
2455 L X+128. Y+67.	2551 L X+126.085 Y+71.578	2647 L Y+69.	2744 L Z-15. FQ3	2840 L Y+66.
2456 L Z+15.	2552 L X+126. Y+71.	2648 L X+126.065 Y+68.493 FQ4	2745 L X+127.493 Y+72.935	2841 L X+134.
2457 L Y+73. FMAX	2553 L Y+70.	2649 L X+126.346 Y+67.875	2746 L X+126.875 Y+72.654	2842 L Y+74.
2458 L Z-11.1 FQ3	2554 L Y+66.	2650 L X+126.533 Y+67.641	2747 L X+126.641 Y+72.467	2843 L X+126.
2459 L X+127.493 Y+72.935	2555 L X+134.	2651 L X+126.894 Y+67.334	2748 L X+126.334 Y+72.106	2844 L Y+70.
2460 L X+126.875 Y+72.654	2556 L Y+74.	2652 L X+127.422 Y+67.085	2749 L X+126.085 Y+71.578	2845 L Y+69.
2461 L X+126.641 Y+72.467	2557 L X+126.	2653 L X+128. Y+67.	2750 L X+126. Y+71.	2846 L X+126.065 Y+68.493
2462 L X+126.334 Y+72.106	2558 L Y+70.	2654 L Z+15.	2751 L Y+70.	2847 L X+126.346 Y+67.875
2463 L X+126.085 Y+71.578	2559 L Y+69.	2655 L Y+73. FMAX	2752 L Y+66.	2848 L X+126.533 Y+67.641
2464 L X+126. Y+71.	2560 L X+126.065 Y+68.493 FQ4	2656 L Z-13.8 FQ3	2753 L X+134.	2849 L X+126.894 Y+67.334
2465 L Y+70.	2561 L X+126.346 Y+67.875	2657 L X+127.493 Y+72.935	2754 L Y+74.	2850 L X+127.422 Y+67.085
2466 L Y+66.	2562 L X+126.533 Y+67.641	2658 L X+126.875 Y+72.654	2755 L X+126.	2851 L X+128. Y+67.
2467 L X+134.	2563 L X+126.894 Y+67.334	2659 L X+126.641 Y+72.467	2756 L Y+70.	2852 L Z+15.
2468 L Y+74.	2564 L X+127.422 Y+67.085	2660 L X+126.334 Y+72.106	2757 L Y+69.	2853 L Y+73. FMAX
2469 L X+126.	2565 L X+128. Y+67.	2661 L X+126.085 Y+71.578	2758 L X+126.065 Y+68.493 FQ4	2854 L Z-16.5 FQ3
2470 L Y+70.	2566 L Z+15.	2662 L X+126. Y+71.	2759 L X+126.346 Y+67.875	2855 L X+127.493 Y+72.935
2471 L Y+69.	2567 L Y+73. FMAX	2663 L Y+70.	2760 L X+126.533 Y+67.641	2856 L X+126.875 Y+72.654
2472 L X+126.065 Y+68.493 FQ4	2568 L Z-12.6 FQ3	2664 L Y+66.	2761 L X+126.894 Y+67.334	2857 L X+126.641 Y+72.467
2473 L X+126.346 Y+67.875	2569 L X+127.493 Y+72.935	2665 L X+134.	2762 L X+127.422 Y+67.085	2858 L X+126.334 Y+72.106
2474 L X+126.533 Y+67.641	2570 L X+126.875 Y+72.654	2666 L Y+74.	2763 L X+128. Y+67.	2859 L X+126.085 Y+71.578
2475 L X+126.894 Y+67.334	2571 L X+126.641 Y+72.467	2667 L X+126.	2764 L Z+15.	2860 L X+126. Y+71.
2476 L X+127.422 Y+67.085	2572 L X+126.334 Y+72.106	2668 L Y+70.	2765 L Y+73. FMAX	2861 L Y+70.
2477 L X+128. Y+67.	2573 L X+126.085 Y+71.578	2669 L Y+69.	2766 L Z-15.3 FQ3	2862 L Y+66.
2478 L Z+15.	2574 L X+126. Y+71.	2670 L X+126.065 Y+68.493 FQ4	2767 L X+127.493 Y+72.935	2863 L X+134.
2479 L Y+73. FMAX	2575 L Y+70.	2671 L X+126.346 Y+67.875	2768 L X+126.875 Y+72.654	2864 L Y+74.
2480 L Z-11.4 FQ3	2576 L Y+66.	2672 L X+126.533 Y+67.641	2769 L X+126.641 Y+72.467	2865 L X+126.
2481 L X+127.493 Y+72.935	2577 L X+134.	2673 L X+126.894 Y+67.334	2770 L X+126.334 Y+72.106	2866 L Y+70.
2482 L X+126.875 Y+72.654	2578 L Y+74.	2674 L X+127.422 Y+67.085	2771 L X+126.085 Y+71.578	2867 L Y+69.
2483 L X+126.641 Y+72.467	2579 L X+126.	2675 L X+128. Y+67.	2772 L X+126. Y+71.	2868 L X+126.065 Y+68.493
2484 L X+126.334 Y+72.106	2580 L Y+70.	2676 L Z+15.	2773 L Y+70.	2869 L X+126.346 Y+67.875
2485 L X+126.085 Y+71.578	2581 L Y+69.	2677 L Y+73. FMAX	2774 L Y+66.	2870 L X+126.533 Y+67.641
2486 L X+126. Y+71.	2582 L X+126.065 Y+68.493 FQ4	2678 L Z-14.1 FQ3	2775 L X+134.	2871 L X+126.894 Y+67.334
2487 L Y+70.	2583 L X+126.346 Y+67.875	2679 L X+127.493 Y+72.935	2776 L Y+74.	2872 L X+127.422 Y+67.085
2488 L Y+66.	2584 L X+126.533 Y+67.641	2680 L X+126.875 Y+72.654	2777 L X+126.	2873 L X+128. Y+67.
2489 L X+134.	2585 L X+126.894 Y+67.334	2681 L X+126.641 Y+72.467	2778 L Y+70.	2874 L Z+15.
2490 L Y+74.	2586 L X+127.422 Y+67.085	2682 L X+126.334 Y+72.106	2779 L Y+69.	2875 L Y+73. FMAX
2491 L X+126.	2587 L X+128. Y+67.	2683 L X+126.085 Y+71.578	2780 L X+126.065 Y+68.493 FQ4	2876 L Z-16.8 FQ3
2492 L Y+70.	2588 L Z+15.	2684 L X+126. Y+71.	2781 L X+126.346 Y+67.875	2877 L X+127.493 Y+72.935
2493 L Y+69.	2589 L Y+73. FMAX	2685 L Y+70.	2782 L X+126.533 Y+67.641	2878 L X+126.875 Y+72.654
		2686 L Y+66.		2879 L X+126.641 Y+72.467

2880 L X+126.334 Y+72.106
2881 L X+126.085 Y+71.578
2882 L X+126. Y+71.
2883 L Y+70.
2884 L Y+66.
2885 L X+134.
2886 L Y+74.
2887 L X+126.
2888 L Y+70.
2889 L Y+69.
2890 L X+126.065 Y+68.493
FQ4
2891 L X+126.346 Y+67.875
2892 L X+126.533 Y+67.641
2893 L X+126.894 Y+67.334
2894 L X+127.422 Y+67.085
2895 L X+128. Y+67.
2896 L Z+15.
2897 L Y+73. FMAX
2898 L Z-17.1 FQ3
2899 L X+127.493 Y+72.935
2900 L X+126.875 Y+72.654
2901 L X+126.641 Y+72.467
2902 L X+126.334 Y+72.106
2903 L X+126.085 Y+71.578
2904 L X+126. Y+71.
2905 L Y+70.
2906 L Y+66.
2907 L X+134.
2908 L X+126.
2909 L X+126.
2910 L Y+70.
2911 L Y+69.
2912 L X+126.065 Y+68.493
FQ4
2913 L X+126.346 Y+67.875
2914 L X+126.533 Y+67.641
2915 L X+126.894 Y+67.334
2916 L X+127.422 Y+67.085
2917 L X+128. Y+67.
2918 L Z+15.
2919 L Y+73. FMAX
2920 L Z-17.4 FQ3
2921 L X+127.493 Y+72.935
2922 L X+126.875 Y+72.654
2923 L X+126.641 Y+72.467
2924 L X+126.334 Y+72.106
2925 L X+126.085 Y+71.578
2926 L X+126. Y+71.
2927 L Y+70.
2928 L Y+66.
2929 L X+134.
2930 L Y+74.
2931 L X+126.
2932 L Y+70.
2933 L Y+69.
2934 L X+126.065 Y+68.493
FQ4
2935 L X+126.346 Y+67.875
2936 L X+126.533 Y+67.641
2937 L X+126.894 Y+67.334
2938 L X+127.422 Y+67.085
2939 L X+128. Y+67.
2940 L Z+15.
2941 L Y+73. FMAX
2942 L Z-17.7 FQ3
2943 L X+127.493 Y+72.935
2944 L X+126.875 Y+72.654
2945 L X+126.641 Y+72.467
2946 L X+126.334 Y+72.106
2947 L X+126.085 Y+71.578
2948 L X+126. Y+71.
2949 L Y+70.
2950 L Y+66.
2951 L X+134.
2952 L Y+74.
2953 L X+126.
2954 L Y+70.
2955 L Y+69.
2956 L X+126.065 Y+68.493
FQ4
2957 L X+126.346 Y+67.875
2958 L X+126.533 Y+67.641
2959 L X+126.894 Y+67.334
2960 L X+127.422 Y+67.085
2961 L X+128. Y+67.
2962 L Z+15.
2963 L Y+73. FMAX
2964 L Z-18. FQ3
2965 L X+127.493 Y+72.935
2966 L X+126.875 Y+72.654
2967 L X+126.641 Y+72.467
2968 L X+126.334 Y+72.106
2969 L X+126.085 Y+71.578
2970 L X+126. Y+71.
2971 L Y+70.
2972 L Y+66.
2973 L X+134.
2974 L Y+74.
2975 L X+126.
2976 L Y+70.
2977 L Y+69.
2978 L X+126.065 Y+68.493
FQ4
2979 L X+126.346 Y+67.875
2980 L X+126.533 Y+67.641
2981 L X+126.894 Y+67.334
2982 L X+127.422 Y+67.085
2983 L X+128. Y+67.
2984 L Z+15.
2985 M129
2986 L B+0 C+0 R0 FMAX
2987 TOOL CALL 5 Z S10000
2988 CALL LBL 1
2989 L M126 ; DREHACHSEN
WEGOPTIMIERE EIN
2990 L A0. R0 FMAX
2991 L M128 ; TCPM ON
2992 L X+35. Y+82. Z+5.
FMAX M13
2993 L Z+1. FMAX
2994 L Z-8. FQ3
2995 L X+38.381 Y+79.072
2996 L X+38.982 Y+79.013
2997 L X+39.644 Y+79.164
2998 L X+39.868 Y+79.274
2999 L X+40.312 Y+79.618
3000 L X+40.621 Y+80.034
3001 L X+40.813 Y+80.515
3002 L X+40.984 Y+81.559
3003 L X+40.917 Y+82.992
3004 L X+40.611 Y+84.125
3005 L X+40.09 Y+85.176
3006 L X+39.375 Y+86.106
3007 L X+38.492 Y+86.879
3008 L X+37.475 Y+87.466
3009 L X+36.364 Y+87.843
3010 L X+35.2 Y+87.997
3011 L X+34.029 Y+87.921
3012 L X+32.895 Y+87.619
3013 L X+31.842 Y+87.102
3014 L X+30.909 Y+86.389
3015 L X+30.133 Y+85.509
3016 L X+29.543 Y+84.495
3017 L X+29.162 Y+83.385
3018 L X+29.004 Y+82.222
3019 L X+29.076 Y+81.05
3020 L X+29.362 Y+79.948
3021 L X+29.851 Y+78.919
3022 L X+30.527 Y+78.001
3023 L X+31.363 Y+77.228
3024 L X+32.331 Y+76.627
3025 L X+33.394 Y+76.219
3026 L X+34.516 Y+76.02
3027 L X+35.655 Y+76.036
3028 L X+36.771 Y+76.267
3029 L X+37.822 Y+76.705
3030 L X+38.772 Y+77.334
3031 L X+39.586 Y+78.131
3032 L X+40.235 Y+79.068
3033 L X+40.695 Y+80.11
3034 L X+40.949 Y+81.221
3035 L X+40.989 Y+82.359
3036 L X+40.813 Y+83.485
3037 L X+40.577 Y+84.041
3038 L X+40.127 Y+84.55
3039 L X+39.924 Y+84.693
3040 L X+39.409 Y+84.917
3041 L X+38.895 Y+84.99
3042 L X+38.381 Y+84.928
3043 L X+35. Y+82.
3044 L Z+1.
3045 L Z+5. FMAX
3046 L Z+8. FMAX
3047 L Z-7. FMAX
3048 L Z-12.
3049 L X+35.142 Y+79.768
3050 L X+35.728 Y+79.62
3051 L X+36.405 Y+79.67
3052 L X+36.642 Y+79.745
3053 L X+37.133 Y+80.019
3054 L X+37.501 Y+80.384
3055 L X+37.763 Y+80.832
3056 L X+37.978 Y+81.64
3057 L X+37.962 Y+82.476
3058 L X+37.715 Y+83.275
3059 L X+37.258 Y+83.975
3060 L X+36.625 Y+84.522
3061 L X+35.865 Y+84.873
3062 L X+35.039 Y+85.
3063 L X+34.209 Y+84.894
3064 L X+33.441 Y+84.563
3065 L X+32.794 Y+84.033
3066 L X+32.318 Y+83.345
3067 L X+32.051 Y+82.552
3068 L X+32.01 Y+81.757
3069 L X+32.179 Y+80.979
3070 L X+32.547 Y+80.273
3071 L X+33.088 Y+79.688
3072 L X+33.763 Y+79.267
3073 L X+34.526 Y+79.038
3074 L X+35.322 Y+79.017
3075 L X+36.095 Y+79.207
3076 L X+36.791 Y+79.594
3077 L X+37.361 Y+80.15
3078 L X+37.765 Y+80.836
3079 L X+37.974 Y+81.604
3080 L X+37.973 Y+82.4
3081 L X+37.763 Y+83.168
3082 L X+37.446 Y+83.683
3083 L X+36.925 Y+84.119
3084 L X+36.703 Y+84.23
3085 L X+36.16 Y+84.375
3086 L X+35.642 Y+84.37
3087 L X+35.142 Y+84.232
3088 L X+35. Y+82.
3089 L Z-7.
3090 L A0. R0 FMAX
3091 L X+0. Y+0. Z+100.
FMAX
3092 L X+130.2 Y+30.2 FMAX
3093 L Z+15. FMAX
3094 L Z+1.595
3095 L X+129.8 Z+1.56
3096 L Y+29.8 Z+1.525
3097 L X+130.2 Z+1.49
3098 L Y+30.2 Z+1.455
3099 L X+129.8 Z+1.42
3100 L Y+29.8 Z+1.385
3101 L X+130.2 Z+1.35
3102 L Y+30.2 Z+1.315
3103 L X+129.8 Z+1.28
3104 L Y+29.8 Z+1.245
3105 L X+130.2 Z+1.21
3106 L Y+30.2 Z+1.175
3107 L X+129.8 Z+1.14
3108 L Y+29.8 Z+1.105
3109 L X+130.2 Z+1.07
3110 L Y+30.2 Z+1.035
3111 L X+129.8 Z+1.
3112 L Y+29.8 Z+965
3113 L X+130.2 Z+93
3114 L Y+30.2 Z+895
3115 L X+129.8 Z+86
3116 L Y+29.8 Z+825
3117 L X+130.2 Z+79
3118 L Y+30.2 Z+755
3119 L X+129.8 Z+72
3120 L Y+29.8 Z+685
3121 L X+130.2 Z+665
3122 L Y+30.2 Z+615
3123 L X+129.8 Z+58
3124 L Y+29.8 Z+545
3125 L X+130.2 Z+51
3126 L Y+30.2 Z+475
3127 L X+129.8 Z+44
3128 L Y+29.8 Z+405
3129 L X+130.2 Z+37
3130 L Y+30.2 Z+335
3131 L X+129.8 Z+3
3132 L Y+29.8 Z+265
3133 L X+130.2 Z+23
3134 L Y+30.2 Z+195
3135 L X+129.8 Z+16
3136 L Y+29.8 Z+125
3137 L X+130.2 Z+09
3138 L Y+30.2 Z+055
3139 L X+129.8 Z+02
3140 L Y+29.8 Z-015
3141 L X+130.2 Z-05
3142 L Y+30.2 Z-085
3143 L X+129.8 Z-12
3144 L Y+29.8 Z-155
3145 L X+130.2 Z-19
3146 L Y+30.2 Z-225
3147 L X+129.8 Z-26
3148 L Y+29.8 Z-295
3149 L X+130.2 Z-33
3150 L Y+30.2 Z-365
3151 L X+129.8 Z-4
3152 L Y+29.8
3153 L X+130.2
3154 L Y+30.2
3155 L X+129.8
3156 L X+128.4
3157 L X+127.
3158 L Y+27.
3159 L X+133.
3160 L Y+33.
3161 L X+127.
3162 L Y+30.2
3163 L Z+9.6 FQ4
3164 L X+129.8 FMAX
3165 L Z+9.2 FMAX
3166 L Z-8 FQ3
3167 L Y+29.8
3168 L X+130.2
3169 L Y+30.2
3170 L X+129.8
3171 L X+128.4
3172 L X+127.
3173 L Y+27.
3174 L X+133.
3175 L Y+33.
3176 L X+127.
3177 L Y+30.2
3178 L Z+9.2 FQ4
3179 L X+129.8 FMAX
3180 L Z+8.8 FMAX
3181 L Z-1.2 FQ3
3182 L Y+29.8
3183 L X+130.2
3184 L Y+30.2
3185 L X+129.8
3186 L X+128.4
3187 L X+127.
3188 L Y+27.
3189 L X+133.
3190 L Y+33.
3191 L X+127.
3192 L Y+30.2
3193 L Z+8.8 FQ4
3194 L X+129.8 FMAX
3195 L Z+8.4 FMAX
3196 L Z-1.6 FQ3
3197 L Y+29.8
3198 L X+130.2
3199 L Y+30.2
3200 L X+129.8
3201 L X+128.4
3202 L X+127.
3203 L Y+27.
3204 L X+133.
3205 L Y+33.
3206 L X+127.
3207 L Y+30.2
3208 L Z+8.4 FQ4
3209 L X+129.8 FMAX
3210 L Z+8. FMAX
3211 L Z-2. FQ3
3212 L Y+29.8
3213 L X+130.2
3214 L Y+30.2
3215 L X+129.8
3216 L X+128.4
3217 L X+127.
3218 L Y+27.
3219 L X+133.
3220 L Y+33.
3221 L X+127.
3222 L Y+30.2
3223 L Z+8. FQ4
3224 L X+129.8 FMAX
3225 L Z+7.6 FMAX
3226 L Z-2.4 FQ3
3227 L Y+29.8
3228 L X+130.2
3229 L Y+30.2
3230 L X+129.8
3231 L X+128.4
3232 L X+127.
3233 L Y+27.
3234 L X+133.
3235 L Y+33.
3236 L X+127.
3237 L Y+30.2
3238 L Z+7.6 FQ4
3239 L X+129.8 FMAX
3240 L Z+7.2 FMAX
3241 L Z-2.8 FQ3
3242 L Y+29.8
3243 L X+130.2
3244 L Y+30.2
3245 L X+129.8
3246 L X+128.4
3247 L X+127.
3248 L Y+27.
3249 L X+133.
3250 L Y+33.
3251 L X+127.
3252 L Y+30.2
3253 L Z+7.2 FQ4
3254 L X+129.8 FMAX
3255 L Z+6.8 FMAX
3256 L Z-3.2 FQ3
3257 L Y+29.8
3258 L X+130.2
3259 L Y+30.2
3260 L X+129.8
3261 L X+128.4
3262 L X+127.
3263 L Y+27.
3264 L X+133.
3265 L Y+33.
3266 L X+127.
3267 L Y+30.2
3268 L Z+6.8 FQ4
3269 L X+129.8 FMAX
3270 L Z+6.4 FMAX
3271 L Z-3.6 FQ3
3272 L Y+29.8
3273 L X+130.2
3274 L Y+30.2
3275 L X+129.8
3276 L X+128.4
3277 L X+127.
3278 L Y+27.
3279 L X+133.
3280 L Y+33.
3281 L X+127.
3282 L Y+30.2
3283 L Z+6.4 FQ4
3284 L X+129.8 FMAX
3285 L Z+6. FMAX
3286 L Z-4. FQ3
3287 L Y+29.8
3288 L X+130.2
3289 L Y+27.
3290 L X+129.8
3291 L X+128.4
3292 L X+127.
3293 L Y+27.
3294 L X+133.
3295 L Y+33.
3296 L X+127.
3297 L Y+30.2
3298 L Z+6. FQ4
3299 L X+129.8 FMAX
3300 L Z+5.6 FMAX
3301 L Z-4.4 FQ3
3302 L Y+29.8
3303 L X+130.2
3304 L Y+30.2
3305 L X+129.8
3306 L X+128.4
3307 L X+127.
3308 L Y+27.
3309 L X+133.
3310 L Y+33.
3311 L X+127.
3312 L Y+30.2
3313 L Z+5.6 FQ4
3314 L X+129.8 FMAX
3315 L Z+5.2 FMAX
3316 L Z-4.8 FQ3
3317 L Y+29.8
3318 L X+130.2
3319 L Y+30.2
3320 L X+129.8
3321 L X+128.4
3322 L X+127.
3323 L Y+27.
3324 L X+133.
3325 L Y+33.
3326 L X+127.
3327 L Y+30.2
3328 L Z+5.2 FQ4
3329 L X+129.8 FMAX
3330 L Z+4.8 FMAX
3331 L Z-5.2 FQ3
3332 L Y+29.8
3333 L X+130.2
3334 L Y+30.2
3335 L X+129.8
3336 L X+128.4
3337 L X+127.
3338 L Y+27.
3339 L X+133.
3340 L Y+33.
3341 L X+127.
3342 L Y+30.2
3343 L Z+4.8 FQ4
3344 L X+129.8 FMAX
3345 L Z+4.4 FMAX
3346 L Z-5.6 FQ3
3347 L Y+29.8
3348 L X+130.2
3349 L Y+30.2
3350 L X+129.8
3351 L X+128.4
3352 L X+127.
3353 L Y+27.
3354 L X+133.
3355 L Y+33.
3356 L X+127.
3357 L Y+30.2
3358 L Z+4.4 FQ4
3359 L X+129.8 FMAX
3360 L Z+4. FMAX
3361 L Z-6. FQ3
3362 L Y+29.8
3363 L X+130.2
3364 L Y+30.2
3365 L X+129.8
3366 L X+128.4
3367 L X+127.
3368 L Y+27.
3369 L X+133.
3370 L Y+33.
3371 L X+127.
3372 L Y+30.2
3373 L Z+4. FQ4
3374 L X+129.8 FMAX
3375 L Z+3.6 FMAX
3376 L Z-6.4 FQ3

3377 L Y+29.8
3378 L X+130.2
3379 L Y+30.2
3380 L X+129.8
3381 L X+128.4
3382 L X+127.
3383 L Y+27.
3384 L X+133.
3385 L Y+33.
3386 L X+127.
3387 L Y+30.2
3388 L Z+3.6 FQ4
3389 L X+129.8 FMAX
3390 L Z+3.2 FMAX
3391 L Z-6.8 FQ3
3392 L Y+29.8
3393 L X+130.2
3394 L Y+30.2
3395 L X+129.8
3396 L X+128.4
3397 L X+127.
3398 L Y+27.
3399 L X+133.
3400 L Y+33.
3401 L X+127.
3402 L Y+30.2
3403 L Z+3.2 FQ4
3404 L X+129.8 FMAX
3405 L Z+2.8 FMAX
3406 L Z-7.2 FQ3
3407 L Y+29.8
3408 L X+130.2
3409 L Y+30.2
3410 L X+129.8
3411 L X+128.4
3412 L X+127.
3413 L Y+27.
3414 L X+133.
3415 L Y+33.
3416 L X+127.
3417 L Y+30.2
3418 L Z+2.8 FQ4
3419 L X+129.8 FMAX
3420 L Z+2.4 FMAX
3421 L Z-7.6 FQ3
3422 L Y+29.8
3423 L X+130.2
3424 L Y+30.2
3425 L X+129.8
3426 L X+128.4
3427 L X+127.
3428 L Y+27.
3429 L X+133.
3430 L Y+33.
3431 L X+127.
3432 L Y+30.2
3433 L Z+2.4 FQ4
3434 L X+129.8 FMAX
3435 L Z+2. FMAX
3436 L Z-8. FQ3
3437 L Y+29.8
3438 L X+130.2
3439 L Y+30.2
3440 L X+129.8
3441 L X+128.4
3442 L X+127.
3443 L Y+27.
3444 L X+133.
3445 L Y+33.
3446 L X+127.
3447 L Y+30.2
3448 L Z+15. FQ4
3449 L X+0.0 Y+0.0 Z+100. FMAX
3450 L X+94. Y+29. FMAX
3451 L Z+15. FMAX
3452 L Z-5.238 FQ3
3453 L X+96. Z-5.413
3454 L Y+31. Z-5.588
3455 L X+94. Z-5.763
3456 L Y+30. Z-5.85
3457 L Y+29. Z-5.938
3458 L X+96. Z-6.113
3459 L Y+31. Z-6.288
3460 L X+94. Z-6.463
3461 L Y+30. Z-6.55
3462 L Y+29. Z-6.638
3463 L X+96. Z-6.813
3464 L Y+31. Z-6.988
3465 L X+94. Z-7.163
3466 L Y+30. Z-7.25
3467 L Y+29.
3468 L X+96.
3469 L Y+31.
3470 L X+94.
3471 L Y+30.
3472 L Z+2.75 FQ4
3473 L Z+2.5 FMAX
3474 L Z-7.5 FQ3
3475 L Y+29.
3476 L X+96.
3477 L Y+31.
3478 L X+94.
3479 L Y+30.
3480 L Z+2.5 FQ4
3481 L Z+2.25 FMAX
3482 L Z-7.75 FQ3
3483 L Y+29.
3484 L X+96.
3485 L Y+31.
3486 L X+94.
3487 L Y+30.
3488 L Z+2.25 FQ4
3489 L Z+2. FMAX
3490 L Z-8. FQ3
3491 L Y+29.
3492 L X+96.
3493 L Y+31.
3494 L X+94.
3495 L Y+30.
3496 L Z+2. FQ4
3497 L Z+1.75 FMAX
3498 L Z-8.25 FQ3
3499 L Y+29.
3500 L X+96.
3501 L Y+31.
3502 L X+94.
3503 L Y+30.
3504 L Z+1.75 FQ4
3505 L Z+1.5 FMAX
3506 L Z-8.5 FQ3
3507 L Y+29.
3508 L X+96.
3509 L Y+31.
3510 L X+94.
3511 L Y+30.
3512 L Z+1.5 FQ4
3513 L Z+1.25 FMAX
3514 L Z-8.75 FQ3
3515 L Y+29.
3516 L X+96.
3517 L Y+31.
3518 L X+94.
3519 L Y+30.
3520 L Z+1.25 FQ4
3521 L Z+1. FMAX
3522 L Z-9. FQ3
3523 L Y+29.
3524 L X+96.
3525 L Y+31.
3526 L X+94.
3527 L Y+30.
3528 L Z+1. FQ4
3529 L Z+7.5 FMAX
3530 L Z-9.25 FQ3
3531 L Y+29.
3532 L X+96.
3533 L Y+31.
3534 L X+94.
3535 L Y+30.
3536 L Z+7.5 FQ4
3537 L Z+5 FMAX
3538 L Z-9.5 FQ3
3539 L Y+29.
3540 L X+96.
3541 L Y+31.
3542 L X+94.
3543 L Y+30.
3544 L Z+5 FQ4
3545 L Z+25 FMAX
3546 L Z-9.75 FQ3
3547 L Y+29.
3548 L X+96.
3549 L Y+31.
3550 L X+94.
3551 L Y+30.
3552 L Z+25 FQ4
3553 L Z+0.0 FMAX
3554 L Z-10. FQ3
3555 L Y+29.
3556 L X+96.
3557 L Y+31.
3558 L X+94.
3559 L Y+30.
3560 L Z+0.0 FQ4
3561 L Z-25 FMAX
3562 L Z-10.25 FQ3
3563 L Y+29.
3564 L X+96.
3565 L Y+31.
3566 L X+94.
3567 L Y+30.
3568 L Z-25 FQ4
3569 L Z-5 FMAX
3570 L Z-10.5 FQ3
3571 L Y+29.
3572 L X+96.
3573 L Y+31.
3574 L X+94.
3575 L Y+30.
3576 L Z-5 FQ4
3577 L Z-7.5 FMAX
3578 L Z-10.75 FQ3
3579 L Y+29.
3580 L X+96.
3581 L Y+31.
3582 L X+94.
3583 L Y+30.
3584 L Z-7.5 FQ4
3585 L Z-1. FMAX
3586 L Z-11. FQ3
3587 L Y+29.
3588 L X+96.
3589 L Y+31.
3590 L X+94.
3591 L Y+30.
3592 L Z-1. FQ4
3593 L Z-1.25 FMAX
3594 L Z-11.25 FQ3
3595 L Y+29.
3596 L X+96.
3597 L Y+31.
3598 L X+94.
3599 L Y+30.
3600 L Z-1.25 FQ4
3601 L Z-1.5 FMAX
3602 L Z-11.5 FQ3
3603 L Y+29.
3604 L X+96.
3605 L Y+31.
3606 L X+94.
3607 L Y+30.
3608 L Z-1.5 FQ4
3609 L Z-1.75 FMAX
3610 L Z-11.75 FQ3
3611 L Y+29.
3612 L X+96.
3613 L Y+31.
3614 L X+94.
3615 L Y+30.
3616 L Z-1.75 FQ4
3617 L Z-2. FMAX
3618 L Z-12. FQ3
3619 L Y+29.
3620 L X+96.
3621 L Y+31.
3622 L X+94.
3623 L Y+30.
3624 L Z+15. FQ4
3625 M129
3626 L B=0 C=0 R0 FMAX
3627 TOOL CALL 11 Z S16000
3628 CALL LBL 1
3629 L M126 ; DREHACHSEN WEGOPTIMIERTE EIN
3630 L A0. R0 FMAX
3631 L M128 ; TCPM ON
3632 L X+0.0 Y+0.0 Z+100. FMAX M13
3633 L X+130.2 Y+30.2 FMAX
3634 L Z+15. FMAX
3635 L Z+1.495 FQ3
3636 L X+129.8 Z+1.46
3637 L Y+29.8 Z+1.425
3638 L X+130.2 Z+1.39
3639 L Y+30.2 Z+1.355
3640 L X+129.8 Z+1.32
3641 L Y+29.8 Z+1.285
3642 L X+130.2 Z+1.25
3643 L Y+30.2 Z+1.215
3644 L X+129.8 Z+1.18
3645 L Y+29.8 Z+1.145
3646 L X+130.2 Z+1.11
3647 L Y+30.2 Z+1.075
3648 L X+129.8 Z+1.04
3649 L Y+29.8 Z+1.005
3650 L X+130.2 Z+97
3651 L Y+30.2 Z+935
3652 L X+129.8 Z+9
3653 L Y+29.8 Z+865
3654 L X+130.2 Z+83
3655 L Y+30.2 Z+795
3656 L X+129.8 Z+76
3657 L Y+29.8 Z+725
3658 L X+130.2 Z+69
3659 L Y+30.2 Z+655
3660 L X+129.8 Z+62
3661 L Y+29.8 Z+585
3662 L X+130.2 Z+55
3663 L Y+30.2 Z+515
3664 L X+129.8 Z+48
3665 L Y+29.8 Z+445
3666 L X+130.2 Z+41
3667 L Y+30.2 Z+375
3668 L X+129.8 Z+34
3669 L Y+29.8 Z+305
3670 L X+130.2 Z+27
3671 L Y+30.2 Z+235
3672 L X+129.8 Z+2
3673 L Y+29.8 Z+165
3674 L X+130.2 Z+13
3675 L Y+30.2 Z+95
3676 L X+129.8 Z+96
3677 L Y+29.8 Z+.025
3678 L X+130.2 Z-.01
3679 L Y+30.2 Z-.045
3680 L X+129.8 Z-.08
3681 L Y+29.8 Z-.115
3682 L X+130.2 Z-.15
3683 L Y+30.2 Z-.185
3684 L X+129.8 Z-.22
3685 L Y+29.8 Z-.255
3686 L X+130.2 Z-.29
3687 L Y+30.2 Z-.325
3688 L X+129.8 Z-.36
3689 L Y+29.8 Z-.395
3690 L X+130.2 Z-.43
3691 L Y+30.2 Z-.465
3692 L X+129.8 Z-.5
3693 L Y+29.8
3694 L X+130.2
3695 L Y+30.2
3696 L X+129.8
3697 L X+128.4
3698 L X+127.
3699 L Y+27.
3700 L X+133.
3701 L Y+33.
3702 L X+127.
3703 L Y+30.2
3704 L Z+9.5 FQ4
3705 L X+129.8 FMAX
3706 L Z+9. FMAX
3707 L Z-1. FQ3
3708 L Y+29.8
3709 L X+130.2
3710 L Y+30.2
3711 L X+129.8
3712 L X+128.4
3713 L X+127.
3714 L Y+27.
3715 L X+133.
3716 L Y+33.
3717 L X+127.
3718 L Y+30.2
3719 L Z+9. FQ4
3720 L X+129.8 FMAX
3721 L Z+8.5 FMAX
3722 L Z-1.5 FQ3
3723 L Y+29.8
3724 L X+130.2
3725 L Y+30.2
3726 L X+129.8
3727 L X+128.4
3728 L X+127.
3729 L Y+27.
3730 L X+133.
3731 L Y+33.
3732 L X+127.
3733 L Y+30.2
3734 L Z+8.5 FQ4
3735 L X+129.8 FMAX
3736 L Z+8. FMAX
3737 L Z-2. FQ3
3738 L Y+29.8
3739 L X+130.2
3740 L Y+30.2
3741 L X+129.8
3742 L X+128.4
3743 L X+127.
3744 L Y+27.
3745 L X+133.
3746 L Y+33.
3747 L X+127.
3748 L Y+30.2
3749 L Z+8. FQ4
3750 L X+129.8 FMAX
3751 L Z+7.5 FMAX
3752 L Z-2.5 FQ3
3753 L Y+29.8
3754 L X+130.2
3755 L Y+30.2
3756 L X+129.8
3757 L X+128.4
3758 L X+127.
3759 L Y+27.
3760 L X+133.
3761 L Y+33.
3762 L X+127.
3763 L Y+30.2
3764 L Z+7.5 FQ4
3765 L X+129.8 FMAX
3766 L Z+7. FMAX
3767 L Z-3. FQ3
3768 L Y+29.8
3769 L X+130.2
3770 L Y+30.2
3771 L X+129.8
3772 L X+128.4
3773 L X+127.
3774 L Y+27.
3775 L X+133.
3776 L Y+33.
3777 L X+127.
3778 L Y+30.2
3779 L Z+7. FQ4
3780 L X+129.8 FMAX
3781 L Z+6.5 FMAX
3782 L Z-3.5 FQ3
3783 L Y+29.8
3784 L X+130.2
3785 L Y+30.2
3786 L X+129.8
3787 L X+128.4
3788 L X+127.
3789 L Y+27.
3790 L X+133.
3791 L Y+33.
3792 L X+127.
3793 L Y+30.2
3794 L Z+6.5 FQ4
3795 L X+129.8 FMAX
3796 L Z+6. FMAX
3797 L Z-4. FQ3
3798 L Y+29.8
3799 L X+130.2
3800 L Y+30.2
3801 L X+129.8
3802 L X+128.4
3803 L X+127.
3804 L Y+27.
3805 L X+133.
3806 L Y+33.
3807 L X+127.
3808 L Y+30.2
3809 L Z+6. FQ4
3810 L X+129.8 FMAX
3811 L Z+5.5 FMAX
3812 L Z-4.5 FQ3
3813 L Y+29.8
3814 L X+130.2
3815 L Y+30.2
3816 L X+129.8
3817 L X+128.4
3818 L X+127.
3819 L Y+30.2
3820 L X+133.
3821 L Y+33.
3822 L X+127.
3823 L Y+30.2
3824 L Z+5.5 FQ4
3825 L X+129.8 FMAX
3826 L Z+5. FMAX
3827 L Z-5. FQ3
3828 L Y+29.8
3829 L X+130.2
3830 L Y+30.2
3831 L X+129.8
3832 L X+128.4
3833 L X+127.
3834 L Y+27.
3835 L X+133.
3836 L Y+33.
3837 L X+127.
3838 L Y+30.2
3839 L Z+5. FQ4
3840 L X+129.8 FMAX
3841 L Z+4.5 FMAX
3842 L Z-5.5 FQ3
3843 L Y+29.8
3844 L X+130.2
3845 L Y+30.2
3846 L X+129.8
3847 L X+128.4
3848 L X+127.
3849 L Y+27.
3850 L X+133.
3851 L Y+33.
3852 L X+127.
3853 L Y+30.2
3854 L Z+4.5 FQ4
3855 L X+129.8 FMAX
3856 L Z+4. FMAX
3857 L Z-6. FQ3
3858 L Y+29.8
3859 L X+130.2
3860 L Y+30.2
3861 L X+129.8
3862 L X+128.4
3863 L X+127.
3864 L Y+27.
3865 L X+133.
3866 L Y+33.
3867 L X+127.
3868 L Y+30.2
3869 L Z+4. FQ4
3870 L X+129.8 FMAX
3871 L Z+3.5 FMAX
3872 L Z-6.5 FQ3
3873 L Y+29.8
3874 L X+130.2
3875 L Y+30.2
3876 L X+129.8
3877 L X+128.4
3878 L X+127.

3879 L Y+27.	3980 L Y+30.2	4079 L Y+30.5	4180 L X+134.104 Y+28.305	4281 L X+133.695 Y+32.104
3880 L X+129.8	3981 L X+129.8	4080 L X+134.429 Y+31.03 FQ4	4181 L X+134.403 Y+28.884	4282 L X+133.116 Y+32.403
3881 L Y+33.	3982 L X+128.4	4081 L X+134.227 Y+31.508	4182 L X+134.5 Y+29.5	4283 L X+132.5 Y+32.5
3882 L X+127.	3983 L X+127.	4082 L X+134.032 Y+31.785	4183 L Y+30.	4284 L Z+15.
3883 L Y+30.2	3984 L Y+27.	4083 L X+133.695 Y+32.104	4184 L Y+34.5	4285 L Y+27.5 FMAX
3884 L Z+3.5 FQ4	3985 L X+133.	4084 L X+133.116 Y+32.403	4185 L X+125.5	4286 L Z-5.6 FQ3
3885 L X+129.8 FMAX	3986 L Y+33.	4085 L X+132.5 Y+32.5	4186 L Y+25.5	4287 L X+133.03 Y+27.571
3886 L Z+3. FMAX	3987 L X+127.	4086 L Z+15.	4187 L X+134.5	4288 L X+133.508 Y+27.773
3887 L Z-7. FQ3	3988 L Y+30.2	4087 L Y+27.5 FMAX	4188 L Y+30.	4289 L X+133.785 Y+27.968
3888 L Y+29.8	3989 L Z+15. FQ4	4088 L Z-2. FQ3	4189 L Y+30.5	4290 L X+134.104 Y+28.305
3889 L X+130.2	3990 M129	4089 L X+133.03 Y+27.571	4190 L X+134.429 Y+31.03 FQ4	4291 L X+134.403 Y+28.884
3890 L Y+30.2	3991 L B+0 C+0 R0 FMAX	4090 L X+133.508 Y+27.773	4191 L X+134.227 Y+31.508	4292 L X+134.5 Y+29.5
3891 L X+129.8	3992 TOOL CALL 10 Z S16000	4091 L X+133.785 Y+27.968	4192 L X+134.032 Y+31.785	4293 L Y+30.
3892 L X+128.4	3993 CALL LBL 1	4092 L X+134.104 Y+28.305	4193 L X+133.695 Y+32.104	4294 L Y+34.5
3893 L X+127.	3994 L M126 ; DREHACHSEN	4093 L X+134.403 Y+28.884	4194 L X+133.116 Y+32.403	4295 L X+125.5
3894 L Y+27.	WEGOPTIMIERT EIN	4094 L X+134.5 Y+29.5	4195 L X+132.5 Y+32.5	4296 L Y+25.5
3895 L X+133.	3995 L A0. R0 FMAX	4095 L Y+30.	4196 L Z+15.	4297 L X+134.5
3896 L Y+33.	3996 L M128 ; TCPM ON	4096 L Y+34.5	4197 L Y+27.5 FMAX	4298 L Y+30.
3897 L X+127.	3997 L X+0.0 Y+0.0 Z+100.	4097 L X+125.5	4198 L Z-4. FQ3	4299 L Y+30.5
3898 L Y+30.2	FMAX M13	4098 L Y+25.5	4199 L X+133.03 Y+27.571	4300 L X+134.429 Y+31.03 FQ4
3899 L Z+3. FQ4	3998 L X+132.5 Y+27.5 FMAX	4099 L X+134.5	4200 L X+133.508 Y+27.773	4301 L X+134.227 Y+31.508
3900 L X+129.8 FMAX	3999 L Z+15. FMAX	4100 L Y+30.	4201 L X+133.785 Y+27.968	4302 L X+134.032 Y+31.785
3901 L Z+2.5 FMAX	4000 L Z-.4 FQ3	4101 L Y+30.5	4202 L X+134.104 Y+28.305	4303 L X+133.695 Y+32.104
3902 L Z-7.5 FQ3	4001 L X+133.03 Y+27.571	4102 L X+134.429 Y+31.03 FQ4	4203 L X+134.403 Y+28.884	4304 L X+133.116 Y+32.403
3903 L Y+29.8	4002 L X+133.508 Y+27.773	4103 L X+134.227 Y+31.508	4204 L X+134.5 Y+29.5	4305 L X+132.5 Y+32.5
3904 L X+130.2	4003 L X+133.785 Y+27.968	4104 L X+134.032 Y+31.785	4205 L Y+30.	4306 L Z+15.
3905 L Y+30.2	4004 L X+134.104 Y+28.305	4105 L X+133.695 Y+32.104	4206 L Y+34.5	4307 L Y+27.5 FMAX
3906 L X+129.8	4005 L X+134.403 Y+28.884	4106 L X+133.116 Y+32.403	4207 L X+125.5	4308 L Z-6. FQ3
3907 L X+128.4	4006 L X+134.5 Y+29.5	4107 L X+132.5 Y+32.5	4208 L Y+25.5	4309 L X+133.03 Y+27.571
3908 L X+127.	4007 L Y+30.	4108 L Z+15.	4209 L X+134.5	4310 L X+133.508 Y+27.773
3909 L Y+27.	4008 L Y+34.5	4109 L Y+27.5 FMAX	4210 L Y+30.	4311 L X+133.785 Y+27.968
3910 L X+133.	4009 L X+125.5	4110 L Z-2.4 FQ3	4211 L Y+30.5	4312 L X+134.104 Y+28.305
3911 L Y+33.	4010 L Y+25.5	4111 L X+133.03 Y+27.571	4212 L X+134.429 Y+31.03 FQ4	4313 L X+134.403 Y+28.884
3912 L X+127.	4011 L X+134.5	4112 L X+133.508 Y+27.773	4213 L X+134.227 Y+31.508	4314 L X+134.5 Y+29.5
3913 L Y+30.2	4012 L Y+30.	4113 L X+133.785 Y+27.968	4214 L X+134.032 Y+31.785	4315 L Y+30.
3914 L Z+2.5 FQ4	4013 L Y+30.5	4114 L X+134.104 Y+28.305	4215 L X+133.695 Y+32.104	4316 L Y+34.5
3915 L X+129.8 FMAX	4014 L X+134.429 Y+31.03 FQ4	4115 L X+134.403 Y+28.884	4216 L X+133.116 Y+32.403	4317 L X+125.5
3916 L Z-2. FMAX	4015 L X+134.227 Y+31.508	4116 L X+134.5 Y+29.5	4217 L X+132.5 Y+32.5	4318 L Y+25.5
3917 L X+2.8. FQ3	4016 L X+134.032 Y+31.785	4117 L Y+30.	4218 L Z+15.	4319 L X+134.5
3918 L Y+29.8	4017 L X+133.695 Y+32.104	4118 L Y+34.5	4219 L Y+27.5 FMAX	4320 L Y+30.
3919 L X+130.2	4018 L X+133.116 Y+32.403	4119 L X+125.5	4220 L Z-4.4 FQ3	4321 L Y+30.5
3920 L Y+30.2	4019 L X+132.5 Y+32.5	4120 L Y+25.5	4221 L X+133.03 Y+27.571	4322 L X+134.429 Y+31.03 FQ4
3921 L X+129.8	4020 L Z+15.	4121 L X+134.5	4222 L X+133.508 Y+27.773	4323 L X+134.227 Y+31.508
3922 L X+128.4	4021 L Y+27.5 FMAX	4122 L Y+30.	4223 L X+133.785 Y+27.968	4324 L X+134.032 Y+31.785
3923 L X+127.	4022 L Z-.8 FQ3	4123 L Y+30.5	4224 L X+134.104 Y+28.305	4325 L X+133.695 Y+32.104
3924 L Y+27.	4023 L X+133.03 Y+27.571	4124 L X+134.429 Y+31.03 FQ4	4225 L X+134.403 Y+28.884	4326 L X+133.116 Y+32.403
3925 L X+133.	4024 L X+133.508 Y+27.773	4125 L X+134.227 Y+31.508	4226 L X+134.5 Y+29.5	4327 L X+132.5 Y+32.5
3926 L Y+33.	4025 L X+133.785 Y+27.968	4126 L X+134.032 Y+31.785	4227 L Y+30.	4328 L Z+15.
3927 L X+127.	4026 L X+134.104 Y+28.305	4127 L X+133.695 Y+32.104	4228 L Y+34.5	4329 L Y+27.5 FMAX
3928 L Y+30.2	4027 L X+134.403 Y+28.884	4128 L X+133.116 Y+32.403	4229 L X+125.5	4330 L Z-6.4 FQ3
3929 L Z+2. FQ4	4028 L X+134.5 Y+29.5	4129 L X+132.5 Y+32.5	4230 L Y+25.5	4331 L X+133.03 Y+27.571
3930 L X+129.8 FMAX	4029 L Y+30.	4130 L Z+15.	4231 L X+134.5	4332 L X+133.508 Y+27.773
3931 L Z+1.5 FMAX	4030 L Y+34.5	4131 L Y+27.5 FMAX	4232 L Y+30.	4333 L X+133.785 Y+27.968
3932 L Z-8.5 FQ3	4031 L X+125.5	4132 L Z-2.8 FQ3	4233 L Y+30.5	4334 L X+134.104 Y+28.305
3933 L Y+29.8	4032 L Y+25.5	4133 L X+133.03 Y+27.571	4234 L X+134.429 Y+31.03 FQ4	4335 L X+134.403 Y+28.884
3934 L X+130.2	4033 L X+134.5	4134 L X+133.508 Y+27.773	4235 L X+134.227 Y+31.508	4336 L X+134.5 Y+29.5
3935 L Y+30.2	4034 L Y+30.	4135 L X+133.785 Y+27.968	4236 L X+134.032 Y+31.785	4337 L Y+30.
3936 L X+129.8	4035 L Y+30.5	4136 L X+134.104 Y+28.305	4237 L X+133.695 Y+32.104	4338 L Y+34.5
3937 L X+128.4	4036 L X+134.429 Y+31.03 FQ4	4137 L X+134.403 Y+28.884	4238 L X+133.116 Y+32.403	4339 L X+125.5
3938 L X+127.	4037 L X+134.227 Y+31.508	4138 L X+134.5 Y+29.5	4239 L X+132.5 Y+32.5	4340 L Y+25.5
3939 L Y+27.	4038 L X+134.032 Y+31.785	4139 L Y+30.	4240 L Z+15.	4341 L X+134.5
3940 L X+133.	4039 L X+133.695 Y+32.104	4140 L Y+34.5	4241 L Y+27.5 FMAX	4342 L Y+30.
3941 L Y+33.	4040 L X+133.116 Y+32.403	4141 L X+125.5	4242 L Z-4.8 FQ3	4343 L Y+30.5
3942 L X+127.	4041 L X+132.5 Y+32.5	4142 L Y+25.5	4243 L X+133.03 Y+27.571	4344 L X+134.429 Y+31.03 FQ4
3943 L Y+30.2	4042 L Z+15.	4143 L X+134.5	4244 L X+133.508 Y+27.773	4345 L X+134.227 Y+31.508
3944 L Z+1.5 FQ4	4043 L Y+27.5 FMAX	4144 L Y+30.	4245 L X+133.785 Y+27.968	4346 L X+134.032 Y+31.785
3945 L X+129.8 FMAX	4044 L Z-1.2 FQ3	4145 L Y+30.5	4246 L X+134.104 Y+28.305	4347 L X+133.695 Y+32.104
3946 L Z+1. FMAX	4045 L X+133.03 Y+27.571	4146 L X+134.429 Y+31.03 FQ4	4247 L X+134.403 Y+28.884	4348 L X+133.116 Y+32.403
3947 L Z-9. FQ3	4046 L X+133.508 Y+27.773	4147 L X+134.227 Y+31.508	4248 L X+134.5 Y+29.5	4349 L X+132.5 Y+32.5
3948 L Y+29.8	4047 L X+133.785 Y+27.968	4148 L X+134.032 Y+31.785	4249 L Y+30.	4350 L Z+15.
3949 L X+130.2	4048 L X+134.104 Y+28.305	4149 L X+133.695 Y+32.104	4250 L Y+34.5	4351 L Y+27.5 FMAX
3950 L Y+30.2	4049 L X+134.403 Y+28.884	4150 L X+133.116 Y+32.403	4251 L X+125.5	4352 L Z-6.8 FQ3
3951 L X+129.8	4050 L X+134.5 Y+29.5	4151 L X+132.5 Y+32.5	4252 L Y+25.5	4353 L X+133.03 Y+27.571
3952 L X+128.4	4051 L Y+30.	4152 L Z+15.	4253 L X+134.5	4354 L X+133.508 Y+27.773
3953 L X+127.	4052 L Y+34.5	4153 L Y+27.5 FMAX	4254 L Y+30.	4355 L X+133.785 Y+27.968
3954 L Y+27.	4053 L X+125.5	4154 L Z-3.2 FQ3	4255 L Y+30.5	4356 L X+134.104 Y+28.305
3955 L X+133.	4054 L Y+25.5	4155 L X+133.03 Y+27.571	4256 L X+134.429 Y+31.03 FQ4	4357 L X+134.403 Y+28.884
3956 L Y+33.	4055 L X+134.5	4156 L X+133.508 Y+27.773	4257 L X+134.227 Y+31.508	4358 L X+134.5 Y+29.5
3957 L X+127.	4056 L Y+30.	4157 L X+133.785 Y+27.968	4258 L X+134.032 Y+31.785	4359 L Y+30.
3958 L Y+30.2	4057 L Y+30.5	4158 L X+134.104 Y+28.305	4259 L X+133.695 Y+32.104	4360 L Y+34.5
3959 L Z+1. FQ4	4058 L X+134.429 Y+31.03 FQ4	4159 L X+134.403 Y+28.884	4260 L X+133.116 Y+32.403	4361 L X+125.5
3960 L X+129.8 FMAX	4059 L X+134.227 Y+31.508	4160 L X+134.5 Y+29.5	4261 L X+132.5 Y+32.5	4362 L Y+25.5
3961 L Z+5. FMAX	4060 L X+134.032 Y+31.785	4161 L Y+30.	4262 L Z+15.	4363 L X+134.5
3962 L Z-9.5 FQ3	4061 L X+133.695 Y+32.104	4162 L Y+34.5	4263 L Y+27.5 FMAX	4364 L Y+30.
3963 L Y+29.8	4062 L X+133.116 Y+32.403	4163 L X+125.5	4264 L Z-5.2 FQ3	4365 L Y+30.5
3964 L X+130.2	4063 L X+132.5 Y+32.5	4164 L Y+25.5	4265 L X+133.03 Y+27.571	4366 L X+134.429 Y+31.03 FQ4
3965 L Y+30.2	4064 L Z+15.	4165 L X+134.5	4266 L X+133.508 Y+27.773	4367 L X+134.227 Y+31.508
3966 L X+129.8	4065 L Y+27.5 FMAX	4166 L Y+30.	4267 L X+133.785 Y+27.968	4368 L X+134.032 Y+31.785
3967 L X+128.4	4066 L Z-1.6 FQ3	4167 L Y+30.5	4268 L X+134.104 Y+28.305	4369 L X+133.695 Y+32.104
3968 L X+127.	4067 L X+133.03 Y+27.571	4168 L X+134.429 Y+31.03 FQ4	4269 L X+134.403 Y+28.884	4370 L X+133.116 Y+32.403
3969 L Y+27.	4068 L X+133.508 Y+27.773	4169 L X+134.227 Y+31.508	4270 L X+134.5 Y+29.5	4371 L X+132.5 Y+32.5
3970 L X+133.	4069 L X+133.785 Y+27.968	4170 L X+134.032 Y+31.785	4271 L Y+30.	4372 L Z+15.
3971 L Y+33.	4070 L X+134.104 Y+28.305	4171 L X+133.695 Y+32.104	4272 L Y+34.5	4373 L Y+27.5 FMAX
3972 L X+127.	4071 L X+134.403 Y+28.884	4172 L X+133.116 Y+32.403	4273 L X+125.5	4374 L Z-7.2 FQ3
3973 L Y+30.2	4072 L X+134.5 Y+29.5	4173 L X+132.5 Y+32.5	4274 L Y+25.5	4375 L X+133.03 Y+27.571
3974 L Z+5. FQ4	4073 L Y+30.	4174 L Z+15.	4275 L X+134.5	4376 L X+133.508 Y+27.773
3975 L X+129.8 FMAX	4074 L Y+34.5	4175 L Y+27.5 FMAX	4276 L Y+30.	4377 L X+133.785 Y+27.968
3976 L Z+0.0 FMAX	4075 L X+125.5	4176 L Z-3.6 FQ3	4277 L Y+30.5	4378 L X+134.104 Y+28.305
3977 L Z-10. FQ3	4076 L Y+25.5	4177 L X+133.03 Y+27.571	4278 L X+134.429 Y+31.03 FQ4	4379 L X+134.403 Y+28.884
3978 L Y+29.8	4077 L X+134.5	4178 L X+133.508 Y+27.773	4279 L X+134.227 Y+31.508	4380 L X+134.5 Y+29.5
3979 L X+130.2	4078 L Y+30.	4179 L X+133.785 Y+27.968	4280 L X+134.032 Y+31.785	4381 L Y+30.

4382 L Y+34.5
4383 L X+125.5
4384 L Y+25.5
4385 L X+134.5
4386 L Y+30.
4387 L Y+30.5
4388 L X+134.429 Y+31.03 FQ4
4389 L X+134.227 Y+31.508
4390 L X+134.032 Y+31.785
4391 L X+133.695 Y+32.104
4392 L X+133.116 Y+32.403
4393 L X+132.5 Y+32.5
4394 L Z+15.
4395 L Y+27.5 FMAX
4396 L Z-7.6 FQ3
4397 L X+133.03 Y+27.571
4398 L X+133.508 Y+27.773
4399 L X+133.785 Y+27.968
4400 L X+134.104 Y+28.305
4401 L X+134.403 Y+28.884
4402 L X+134.5 Y+29.5
4403 L Y+30.
4404 L Y+34.5
4405 L X+125.5
4406 L Y+25.5
4407 L X+134.5
4408 L Y+30.
4409 L Y+30.5
4410 L X+134.429 Y+31.03 FQ4
4411 L X+134.227 Y+31.508
4412 L X+134.032 Y+31.785
4413 L X+133.695 Y+32.104
4414 L X+133.116 Y+32.403
4415 L X+132.5 Y+32.5
4416 L Z+15.
4417 L Y+27.5 FMAX
4418 L Z-8. FQ3
4419 L X+133.03 Y+27.571
4420 L X+133.508 Y+27.773
4421 L X+133.785 Y+27.968
4422 L X+134.104 Y+28.305
4423 L X+134.403 Y+28.884
4424 L X+134.5 Y+29.5
4425 L Y+30.
4426 L Y+34.5
4427 L X+125.5
4428 L Y+25.5
4429 L X+134.5
4430 L Y+30.
4431 L Y+30.5
4432 L X+134.429 Y+31.03 FQ4
4433 L X+134.227 Y+31.508
4434 L X+134.032 Y+31.785
4435 L X+133.695 Y+32.104
4436 L X+133.116 Y+32.403
4437 L X+132.5 Y+32.5
4438 L Z+15.
4439 L X+0.0 Y+0.0 Z+100. FMAX
4440 L X+130.4 Y+30.4 FMAX
4441 L Z+15. FMAX
4442 L Z+1.351 FQ3
4443 L X+129.741 Z+1.293
4444 L X+129.6 Z+1.281
4445 L Y+29.6 Z+1.211
4446 L X+130.4 Z+1.141
4447 L Y+30.4 Z+1.071
4448 L X+129.741 Z+1.013
4449 L X+129.6 Z+1.001
4450 L Y+29.6 Z+0.931
4451 L X+130.4 Z+0.861
4452 L Y+30.4 Z+0.791
4453 L X+129.741 Z+0.733
4454 L X+129.6 Z+0.721
4455 L Y+29.6 Z+0.651
4456 L X+130.4 Z+0.581
4457 L Y+30.4 Z+0.511
4458 L X+129.741 Z+0.453
4459 L X+129.6 Z+0.441
4460 L Y+29.6 Z+0.371
4461 L X+130.4 Z+0.301
4462 L Y+30.4 Z+0.231
4463 L X+129.741 Z+0.173
4464 L X+129.6 Z+0.161
4465 L Y+29.6 Z+0.091
4466 L X+130.4 Z+0.021
4467 L Y+30.4 Z-0.049
4468 L X+129.741 Z-0.107
4469 L X+129.6 Z-0.119
4470 L Y+29.6 Z-0.189
4471 L X+130.4 Z-0.259
4472 L Y+30.4 Z-0.329
4473 L X+129.741 Z-0.387
4474 L X+129.6 Z-0.399
4475 L Y+29.6 Z-0.469
4476 L X+130.4 Z-0.539
4477 L Y+30.4 Z-0.609
4478 L X+129.741 Z-0.667
4479 L X+129.6
4480 L Y+29.6
4481 L X+130.4
4482 L X+128.2
4483 L X+131.8
4484 L X+129.741
4485 L Y+29.6
4486 L X+130.4
4487 L X+129.741
4488 L Y+29.6
4489 L X+130.4
4490 L X+129.741
4491 L Y+31.8
4492 L X+129.741
4493 L X+128.2
4494 L Y+28.2
4495 L X+131.8
4496 L Y+31.8
4497 L X+129.741
4498 L Y+32.15
4499 L Y+32.5
4500 L X+127.5
4501 L Y+27.5
4502 L X+132.5
4503 L Y+32.5
4504 L X+129.741
4505 L Z+9.333 FQ4
4506 L Y+30.4 FMAX
4507 L Z+8.667 FMAX
4508 L Z-1.333 FQ3
4509 L X+129.6
4510 L Y+29.6
4511 L X+130.4
4512 L Y+30.4
4513 L X+129.741
4514 L Y+30.75
4515 L Y+31.1
4516 L X+128.9
4517 L Y+28.9
4518 L X+131.1
4519 L Y+31.1
4520 L X+129.741
4521 L Y+31.45
4522 L Y+31.8
4523 L X+128.2
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4525 L X+131.8
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4527 L X+129.741
4528 L Y+32.15
4529 L Y+32.5
4530 L X+127.5
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4533 L Y+32.5
4534 L X+129.741
4535 L Z+8.667 FQ4
4536 L Y+30.4 FMAX
4537 L Z+8. FMAX
4538 L Z-2. FQ3
4539 L X+129.6
4540 L Y+29.6
4541 L X+130.4
4542 L Y+30.4
4543 L X+129.741
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4545 L Y+31.1
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4547 L Y+28.9
4548 L X+131.1
4549 L Y+31.1
4550 L X+129.741
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4553 L X+128.2
4554 L Y+28.2
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4557 L X+129.741
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4559 L Y+32.5
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4562 L X+132.5
4563 L Y+32.5
4564 L X+129.741
4565 L Z+8. FQ4
4566 L Y+30.4 FMAX
4567 L Z+7.333 FMAX
4568 L Z-2.667 FQ3
4569 L X+129.6
4570 L Y+29.6
4571 L X+130.4
4572 L Y+30.4
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4592 L X+132.5
4593 L Y+32.5
4594 L X+129.741
4595 L Z+7.333 FQ4
4596 L Y+30.4 FMAX
4597 L Z+6.667 FMAX
4598 L X+129.741
4599 L X+129.6
4600 L Y+29.6
4601 L X+130.4
4602 L Y+30.4
4603 L X+129.741
4604 L Y+30.75
4605 L Y+31.1
4606 L X+128.9
4607 L Y+28.9
4608 L X+131.1
4609 L Y+31.1
4610 L X+129.741
4611 L Y+31.45
4612 L Y+31.8
4613 L X+128.2
4614 L Y+28.2
4615 L X+131.8
4616 L Y+31.8
4617 L X+129.741
4618 L Y+32.15
4619 L Y+32.5
4620 L X+127.5
4621 L Y+27.5
4622 L X+132.5
4623 L Y+32.5
4624 L X+129.741
4625 L Z+6.667 FQ4
4626 L Y+30.4 FMAX
4627 L Z+6. FMAX
4628 L Z-4. FQ3
4629 L X+129.6
4630 L Y+29.6
4631 L X+130.4
4632 L Y+30.4
4633 L X+129.741
4634 L Y+30.75
4635 L Y+31.1
4636 L X+128.9
4637 L Y+28.9
4638 L X+131.1
4639 L Y+31.1
4640 L X+129.741
4641 L Y+31.45
4642 L Y+31.8
4643 L X+128.2
4644 L Y+28.2
4645 L X+131.8
4646 L Y+31.8
4647 L X+129.741
4648 L Y+32.15
4649 L Y+32.5
4650 L X+127.5
4651 L Y+27.5
4652 L X+132.5
4653 L Y+32.5
4654 L X+129.741
4655 L Z+6. FQ4
4656 L Y+30.4 FMAX
4657 L Z+5.333 FMAX
4658 L Z-4.667 FQ3
4659 L X+129.6
4660 L Y+29.6
4661 L X+130.4
4662 L Y+30.4
4663 L X+129.741
4664 L Y+30.75
4665 L Y+31.1
4666 L X+128.9
4667 L Y+28.9
4668 L X+131.1
4669 L Y+31.1
4670 L X+129.741
4671 L Y+31.45
4672 L Y+31.8
4673 L X+128.2
4674 L Y+28.2
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4681 L Y+27.5
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4683 L Y+32.5
4684 L X+129.741
4685 L Z+5.333 FQ4
4686 L Y+30.4 FMAX
4687 L Z+4.667 FMAX
4688 L Z-5.333 FQ3
4689 L X+129.6
4690 L Y+29.6
4691 L X+130.4
4692 L Y+30.4
4693 L X+129.741
4694 L Y+30.75
4695 L Y+31.1
4696 L X+128.9
4697 L Y+28.9
4698 L X+131.1
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4701 L Y+31.45
4702 L Y+31.8
4703 L X+128.2
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4707 L X+129.741
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4712 L X+132.5
4713 L Y+32.5
4714 L X+129.741
4715 L Z+4.667 FQ4
4716 L Y+30.4 FMAX
4717 L Z+4. FMAX
4718 L Z-6. FQ3
4719 L X+129.6
4720 L Y+29.6
4721 L X+130.4
4722 L Y+30.4
4723 L X+129.741
4724 L Y+30.75
4725 L Y+31.1
4726 L X+128.9
4727 L Y+28.9
4728 L X+131.1
4729 L Y+31.1
4730 L X+129.741
4731 L Y+31.45
4732 L Y+31.8
4733 L X+128.2
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4735 L X+131.8
4736 L Y+31.8
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4742 L X+132.5
4743 L Y+32.5
4744 L X+129.741
4745 L Z+4. FQ4
4746 L Y+30.4 FMAX
4747 L Z+3.333 FMAX
4748 L Z-6.667 FQ3
4749 L X+129.6
4750 L Y+29.6
4751 L X+130.4
4752 L Y+30.4
4753 L X+129.741
4754 L Y+30.75
4755 L Y+31.1
4756 L X+128.9
4757 L Y+28.9
4758 L X+131.1
4759 L Y+31.1
4760 L X+129.741
4761 L Y+31.45
4762 L Y+31.8
4763 L X+128.2
4764 L Y+28.2
4765 L X+131.8
4766 L Y+31.8
4767 L X+129.741
4768 L Y+32.15
4769 L Y+32.5
4770 L X+127.5
4771 L Y+27.5
4772 L X+132.5
4773 L Y+32.5
4774 L X+129.741
4775 L Z+3.333 FQ4
4776 L Y+30.4 FMAX
4777 L Z+2.667 FMAX
4778 L Z-7.333 FQ3
4779 L X+129.6
4780 L Y+29.6
4781 L X+130.4
4782 L Y+30.4
4783 L X+129.741
4784 L Y+30.75
4785 L Y+31.1
4786 L X+128.9
4787 L Y+28.9
4788 L X+131.1
4789 L Y+31.1
4790 L X+129.741
4791 L Y+31.45
4792 L Y+31.8
4793 L X+128.2
4794 L Y+28.2
4795 L X+131.8
4796 L Y+31.8
4797 L X+129.741
4798 L Y+32.15
4799 L Y+32.5
4800 L X+127.5
4801 L Y+27.5
4802 L X+132.5
4803 L Y+32.5
4804 L X+129.741
4805 L Z+2.667 FQ4
4806 L Y+30.4 FMAX
4807 L Z+2. FMAX
4808 L Z-8. FQ3
4809 L X+129.6
4810 L Y+29.6
4811 L X+130.4
4812 L Y+30.4
4813 L X+129.741
4814 L Y+30.75
4815 L Y+31.1
4816 L X+128.9
4817 L Y+28.9
4818 L X+131.1
4819 L Y+31.1
4820 L X+129.741
4821 L Y+31.45
4822 L Y+31.8
4823 L X+128.2
4824 L Y+28.2
4825 L X+131.8
4826 L Y+31.1
4827 L X+129.741
4828 L Y+32.15
4829 L Y+32.5
4830 L X+127.5
4831 L Y+27.5
4832 L X+132.5
4833 L Y+32.5
4834 L X+129.741
4835 L Z+2. FQ4
4836 L Y+30.4 FMAX
4837 L Z+1.333 FMAX
4838 L Z-8.667 FQ3
4839 L X+129.6
4840 L Y+29.6
4841 L X+130.4
4842 L Y+30.4
4843 L X+129.741
4844 L Y+30.75
4845 L Y+31.1
4846 L X+128.9
4847 L Y+28.9
4848 L X+131.1
4849 L Y+31.1
4850 L X+129.741
4851 L Y+31.45
4852 L Y+31.8
4853 L X+128.2
4854 L Y+28.2
4855 L X+131.8
4856 L Y+31.8
4857 L X+129.741
4858 L Y+32.15
4859 L Y+32.5
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4861 L Y+27.5
4862 L X+132.5
4863 L Y+32.5
4864 L X+129.741
4865 L Z+1.333 FQ4
4866 L Y+30.4 FMAX
4867 L Z+0.667 FMAX
4868 L Z-9.333 FQ3
4869 L X+129.6
4870 L Y+29.6
4871 L X+130.4
4872 L Y+30.4
4873 L X+129.741
4874 L Y+30.75
4875 L Y+31.1
4876 L X+128.9
4877 L Y+28.9
4878 L X+131.1
4879 L Y+31.1
4880 L X+129.741
4881 L Y+31.45
4882 L Y+31.8
4883 L X+128.2
4884 L Y+28.2
4885 L X+131.8

4886 L Y+31.8	4986 L X+95.929 Y+32.403	5087 L X+93.597 Y+31.929	5188 L Y+27.5	5289 M2
4887 L X+129.741	4987 L X+95.5 Y+32.5	5088 L X+93.5 Y+31.5	5189 L X+97.5	5290 M30
4888 L Y+32.15	4988 L X+95.5	5089 L Z+15.5	5190 L Y+32.5	5291 END PGM stud MM
4889 L Y+32.5	4989 L X+92.5	5090 L X+96.5 FMAX	5191 L X+95.5	
4890 L X+127.5	4990 L Y+27.5	5091 L Z-9.5 FQ3	5192 L X+94.5	
4891 L Y+27.5	4991 L X+97.5	5092 L X+96.436 Y+31.852	5193 L X+94.148 Y+32.436 FQ4	
4892 L X+132.5	4992 L Y+32.5	5093 L X+96.262 Y+32.148	5194 L X+93.852 Y+32.262	
4893 L Y+32.5	4993 L X+95.5	5094 L X+95.929 Y+32.403	5195 L X+93.597 Y+31.929	
4894 L X+129.741	4994 L X+94.5	5095 L X+95.5 Y+32.5	5196 L X+93.5 Y+31.5	
4895 L Z+.667 FQ4	4995 L X+94.148 Y+32.436 FQ4	5096 L X+95.5	5197 L Z+15.5	
4896 L Y+30.4 FMAX	4996 L X+93.852 Y+32.262	5097 L X+92.5	5198 L X+96.5 FMAX	
4897 L Z+0.0 FMAX	4997 L X+93.597 Y+31.929	5098 L Y+27.5	5199 L Z-11. FQ3	
4898 L Z-10. FQ3	4998 L X+93.5 Y+31.5	5099 L X+97.5	5200 L X+96.436 Y+31.852	
4899 L X+129.6	4999 L Z+15.5	5100 L Y+32.5	5201 L X+96.262 Y+32.148	
4900 L Y+29.6	5000 L X+96.5 FMAX	5101 L X+95.5	5202 L X+95.929 Y+32.403	
4901 L X+130.4	5001 L Z-8.25 FQ3	5102 L X+94.5	5203 L X+95.5 Y+32.5	
4902 L Y+30.4	5002 L X+96.436 Y+31.852	5103 L X+94.148 Y+32.436 FQ4	5204 L X+95.5	
4903 L X+129.741	5003 L X+96.262 Y+32.148	5104 L X+93.852 Y+32.262	5205 L X+92.5	
4904 L Y+30.75	5004 L X+95.929 Y+32.403	5105 L X+93.597 Y+31.929	5206 L Y+27.5	
4905 L Y+31.1	5005 L X+95.5 Y+32.5	5106 L X+93.5 Y+31.5	5207 L X+97.5	
4906 L X+128.9	5006 L X+95.5	5107 L Z+15.5	5208 L Y+32.5	
4907 L Y+28.9	5007 L X+92.5	5108 L X+96.5 FMAX	5209 L X+95.5	
4908 L X+131.1	5008 L Y+27.5	5109 L Z-9.75 FQ3	5210 L X+94.5	
4909 L Y+31.1	5009 L X+97.5	5110 L X+96.436 Y+31.852	5211 L X+94.148 Y+32.436 FQ4	
4910 L X+129.741	5010 L Y+32.5	5111 L X+96.262 Y+32.148	5212 L X+93.852 Y+32.262	
4911 L Y+31.45	5011 L X+95.5	5112 L X+95.929 Y+32.403	5213 L X+93.597 Y+31.929	
4912 L Y+31.8	5012 L X+94.5	5113 L X+95.5 Y+32.5	5214 L X+93.5 Y+31.5	
4913 L X+128.2	5013 L X+94.148 Y+32.436 FQ4	5114 L X+95.5	5215 L Z+15.5	
4914 L Y+28.2	5014 L X+93.852 Y+32.262	5115 L X+92.5	5216 L X+96.5 FMAX	
4915 L X+131.8	5015 L X+93.597 Y+31.929	5116 L Y+27.5	5217 L Z-11.25 FQ3	
4916 L Y+31.8	5016 L X+93.5 Y+31.5	5117 L X+97.5	5218 L X+96.436 Y+31.852	
4917 L X+129.741	5017 L Z+15.5	5118 L Y+32.5	5219 L X+96.262 Y+32.148	
4918 L Y+32.15	5018 L X+96.5 FMAX	5119 L X+95.5	5220 L X+95.929 Y+32.403	
4919 L Y+32.5	5019 L Z-8.5 FQ3	5120 L X+94.5	5221 L X+95.5 Y+32.5	
4920 L X+127.5	5020 L X+96.436 Y+31.852	5121 L X+94.148 Y+32.436 FQ4	5222 L X+95.5	
4921 L Y+27.5	5021 L X+96.262 Y+32.148	5122 L X+93.852 Y+32.262	5223 L X+92.5	
4922 L X+132.5	5022 L X+95.929 Y+32.403	5123 L X+93.597 Y+31.929	5224 L Y+27.5	
4923 L Y+32.5	5023 L X+95.5 Y+32.5	5124 L X+93.5 Y+31.5	5225 L X+97.5	
4924 L X+129.741	5024 L X+95.5	5125 L Z+15.5	5226 L Y+32.5	
4925 L Z+15.5 FQ4	5025 L X+92.5	5126 L X+96.5 FMAX	5227 L X+95.5	
4926 L X+0.0 Y+0.0 Z+100. FMAX	5026 L Y+27.5	5127 L Z-10. FQ3	5228 L X+94.5	
4927 L X+96.5 Y+31.5 FMAX	5027 L X+97.5	5128 L X+96.436 Y+31.852	5229 L X+94.148 Y+32.436 FQ4	
4928 L Z+15.5 FMAX	5028 L Y+32.5	5129 L X+96.262 Y+32.148	5230 L X+93.852 Y+32.262	
4929 L Z-7.25 FQ3	5029 L X+95.5	5130 L X+95.929 Y+32.403	5231 L X+93.597 Y+31.929	
4930 L X+96.436 Y+31.852	5030 L X+94.5	5131 L X+95.5 Y+32.5	5232 L X+93.5 Y+31.5	
4931 L X+96.262 Y+32.148	5031 L X+94.148 Y+32.436 FQ4	5132 L X+95.5	5233 L Z+15.5	
4932 L X+95.929 Y+32.403	5032 L X+93.852 Y+32.262	5133 L X+92.5	5234 L X+96.5 FMAX	
4933 L X+95.5 Y+32.5	5033 L X+93.597 Y+31.929	5134 L Y+27.5	5235 L Z-11.5 FQ3	
4934 L X+95.5	5034 L X+93.5 Y+31.5	5135 L X+97.5	5236 L X+96.436 Y+31.852	
4935 L X+92.5	5035 L Z+15.5	5136 L Y+32.5	5237 L X+96.262 Y+32.148	
4936 L Y+27.5	5036 L X+96.5 FMAX	5137 L X+95.5	5238 L X+95.929 Y+32.403	
4937 L X+97.5	5037 L Z-8.75 FQ3	5138 L X+94.5	5239 L X+95.5 Y+32.5	
4938 L Y+32.5	5038 L X+96.436 Y+31.852	5139 L X+94.148 Y+32.436 FQ4	5240 L X+95.5	
4939 L X+95.5	5039 L X+96.262 Y+32.148	5140 L X+93.852 Y+32.262	5241 L X+92.5	
4940 L X+94.5	5040 L X+95.929 Y+32.403	5141 L X+93.597 Y+31.929	5242 L Y+27.5	
4941 L X+94.148 Y+32.436 FQ4	5041 L X+95.5 Y+32.5	5142 L X+93.5 Y+31.5	5243 L X+97.5	
4942 L X+93.852 Y+32.262	5042 L X+95.5	5143 L Z+15.5	5244 L Y+32.5	
4943 L X+93.597 Y+31.929	5043 L X+92.5	5144 L X+96.5 FMAX	5245 L X+95.5	
4944 L X+93.5 Y+31.5	5044 L Y+27.5	5145 L Z-10.25 FQ3	5246 L X+94.5	
4945 L Z+15.5	5045 L X+97.5	5146 L X+96.436 Y+31.852	5247 L X+94.148 Y+32.436 FQ4	
4946 L X+96.5 FMAX	5046 L Y+32.5	5147 L X+96.262 Y+32.148	5248 L X+93.852 Y+32.262	
4947 L Z-7.5 FQ3	5047 L X+95.5	5148 L X+95.929 Y+32.403	5249 L X+93.597 Y+31.929	
4948 L X+96.436 Y+31.852	5048 L X+94.5	5149 L X+95.5 Y+32.5	5250 L X+93.5 Y+31.5	
4949 L X+96.262 Y+32.148	5049 L X+94.148 Y+32.436 FQ4	5150 L X+95.5	5251 L Z+15.5	
4950 L X+95.929 Y+32.403	5050 L X+93.852 Y+32.262	5151 L X+92.5	5252 L X+96.5 FMAX	
4951 L X+95.5 Y+32.5	5051 L X+93.597 Y+31.929	5152 L Y+27.5	5253 L Z-11.75 FQ3	
4952 L X+95.5	5052 L X+93.5 Y+31.5	5153 L X+97.5	5254 L X+96.436 Y+31.852	
4953 L X+92.5	5053 L Z+15.5	5154 L Y+32.5	5255 L X+96.262 Y+32.148	
4954 L Y+27.5	5054 L X+96.5 FMAX	5155 L X+95.5	5256 L X+95.929 Y+32.403	
4955 L X+97.5	5055 L Z-9. FQ3	5156 L X+94.5	5257 L X+95.5 Y+32.5	
4956 L Y+32.5	5056 L X+96.436 Y+31.852	5157 L X+94.148 Y+32.436 FQ4	5258 L X+95.5	
4957 L X+95.5	5057 L X+96.262 Y+32.148	5158 L X+93.852 Y+32.262	5259 L X+92.5	
4958 L X+94.5	5058 L X+95.929 Y+32.403	5159 L X+93.597 Y+31.929	5260 L Y+27.5	
4959 L X+94.148 Y+32.436 FQ4	5059 L X+95.5 Y+32.5	5160 L X+93.5 Y+31.5	5261 L X+97.5	
4960 L X+93.852 Y+32.262	5060 L X+95.5	5161 L Z+15.5	5262 L Y+32.5	
4961 L X+93.597 Y+31.929	5061 L X+92.5	5162 L X+96.5 FMAX	5263 L X+95.5	
4962 L X+93.5 Y+31.5	5062 L Y+27.5	5163 L Z-10.5 FQ3	5264 L X+94.5	
4963 L Z+15.5	5063 L X+97.5	5164 L X+96.436 Y+31.852	5265 L X+94.148 Y+32.436 FQ4	
4964 L X+96.5 FMAX	5064 L Y+32.5	5165 L X+96.262 Y+32.148	5266 L X+93.852 Y+32.262	
4965 L Z-7.75 FQ3	5065 L X+95.5	5166 L X+95.929 Y+32.403	5267 L X+93.597 Y+31.929	
4966 L X+96.436 Y+31.852	5066 L X+94.5	5167 L X+95.5 Y+32.5	5268 L X+93.5 Y+31.5	
4967 L X+96.262 Y+32.148	5067 L X+94.148 Y+32.436 FQ4	5168 L X+95.5	5269 L Z+15.5	
4968 L X+95.929 Y+32.403	5068 L X+93.852 Y+32.262	5169 L X+92.5	5270 L X+96.5 FMAX	
4969 L X+95.5 Y+32.5	5069 L X+93.597 Y+31.929	5170 L Y+27.5	5271 L Z-12. FQ3	
4970 L X+95.5	5070 L X+93.5 Y+31.5	5171 L X+97.5	5272 L X+96.436 Y+31.852	
4971 L X+92.5	5071 L Z+15.5	5172 L Y+32.5	5273 L X+96.262 Y+32.148	
4972 L Y+27.5	5072 L X+96.5 FMAX	5173 L X+95.5	5274 L X+95.929 Y+32.403	
4973 L X+97.5	5073 L Z-9.25 FQ3	5174 L X+94.5	5275 L X+95.5 Y+32.5	
4974 L Y+32.5	5074 L X+96.436 Y+31.852	5175 L X+94.148 Y+32.436 FQ4	5276 L X+95.5	
4975 L X+95.5	5075 L X+96.262 Y+32.148	5176 L X+93.852 Y+32.262	5277 L X+92.5	
4976 L X+94.5	5076 L X+95.929 Y+32.403	5177 L X+93.597 Y+31.929	5278 L Y+27.5	
4977 L X+94.148 Y+32.436 FQ4	5077 L X+95.5 Y+32.5	5178 L X+93.5 Y+31.5	5279 L X+97.5	
4978 L X+93.852 Y+32.262	5078 L X+95.5	5179 L Z+15.5	5280 L Y+32.5	
4979 L X+93.597 Y+31.929	5079 L X+92.5	5180 L X+96.5 FMAX	5281 L X+95.5	
4980 L X+93.5 Y+31.5	5080 L Y+27.5	5181 L Z-10.75 FQ3	5282 L X+94.5	
4981 L Z+15.5	5081 L X+97.5	5182 L X+96.436 Y+31.852	5283 L X+94.148 Y+32.436 FQ4	
4982 L X+96.5 FMAX	5082 L Y+32.5	5183 L X+96.262 Y+32.148	5284 L X+93.852 Y+32.262	
4983 L Z-8. FQ3	5083 L X+95.5	5184 L X+95.929 Y+32.403	5285 L X+93.597 Y+31.929	
4984 L X+96.436 Y+31.852	5084 L X+94.5	5185 L X+95.5 Y+32.5	5286 L X+93.5 Y+31.5	
4985 L X+96.262 Y+32.148	5085 L X+94.148 Y+32.436 FQ4	5186 L X+95.5	5287 L Z+15.5	
	5086 L X+93.852 Y+32.262	5187 L X+92.5	5288 M05	

APPENDIX 3G
MACHINING PROCESS



Figure 3G(1): Material Before Machining



Figure 3G(2): Tools Installation



Figure 3G(3): Tools

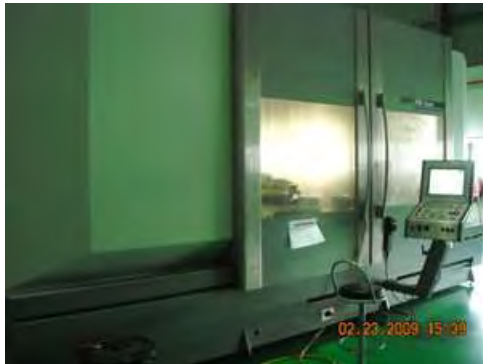


Figure 3G(4): CNC 5-Axis Face Milling



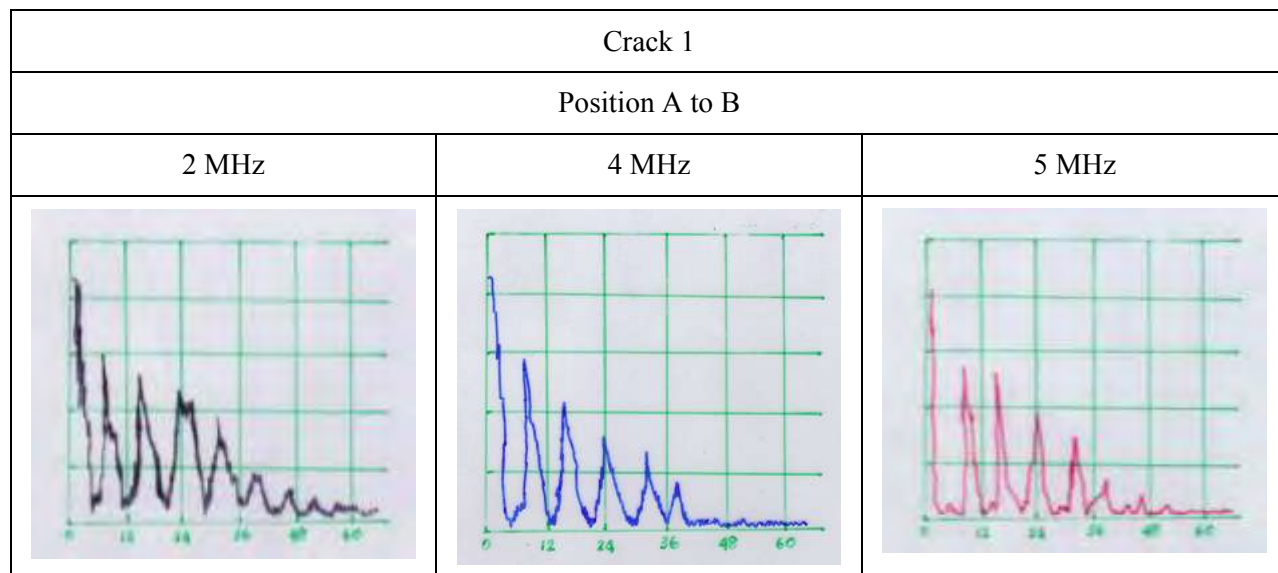
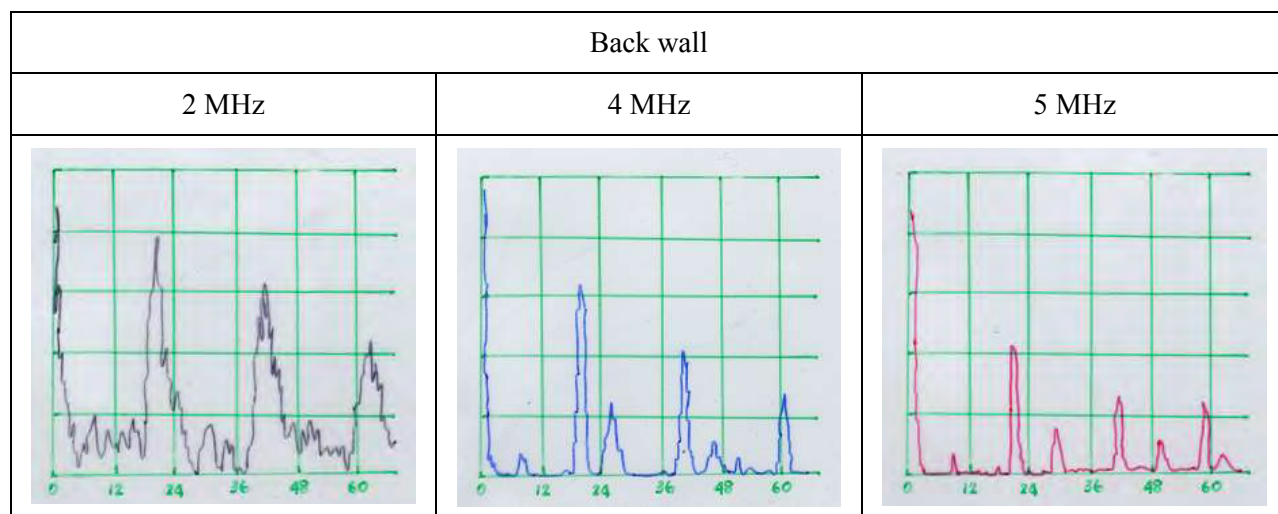
Figure 3G(5): Machining Process

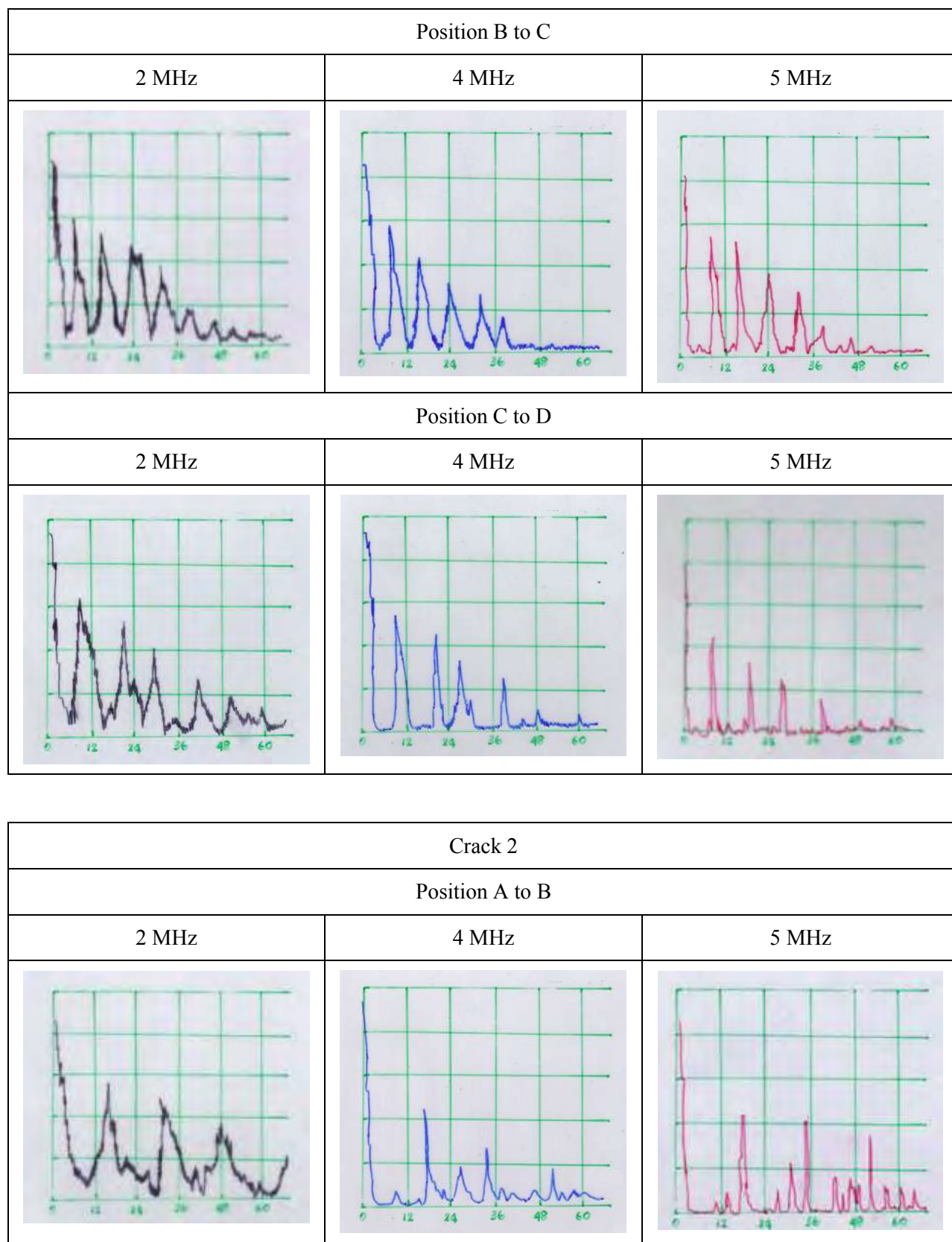


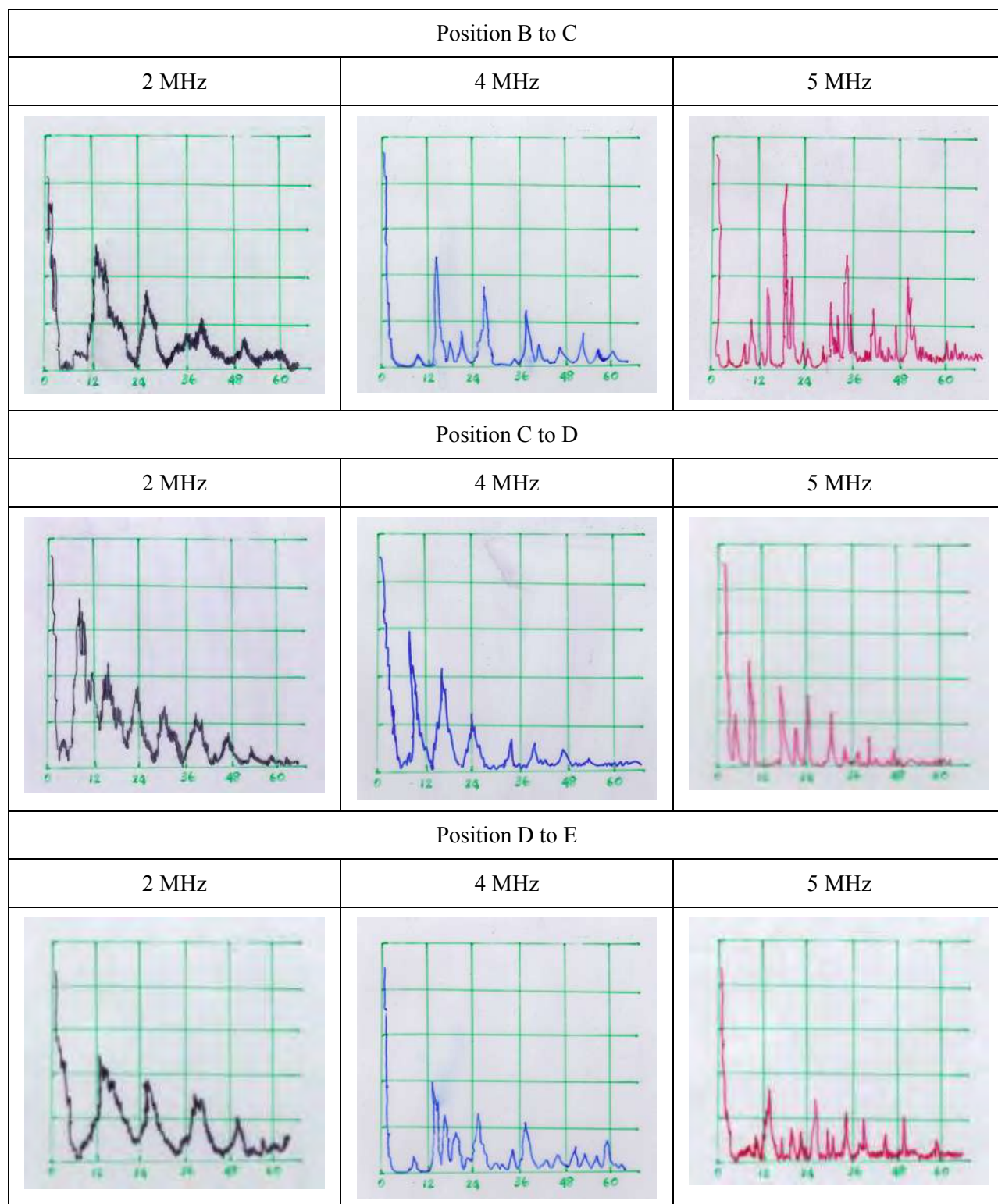
Figure 3G(6): Finished Test Sample

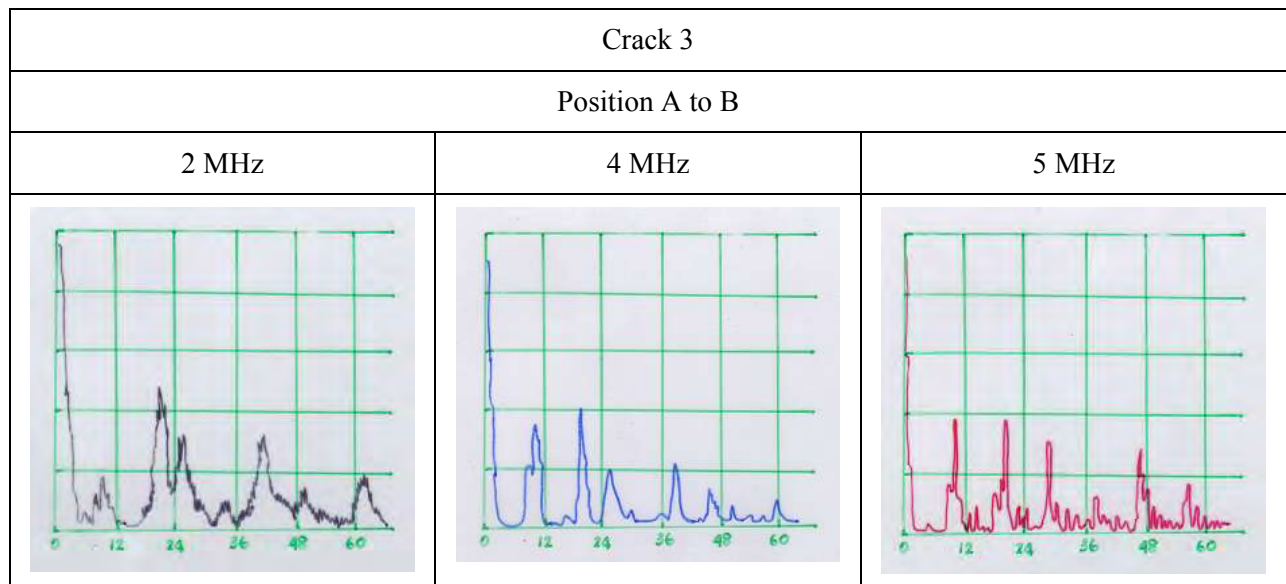
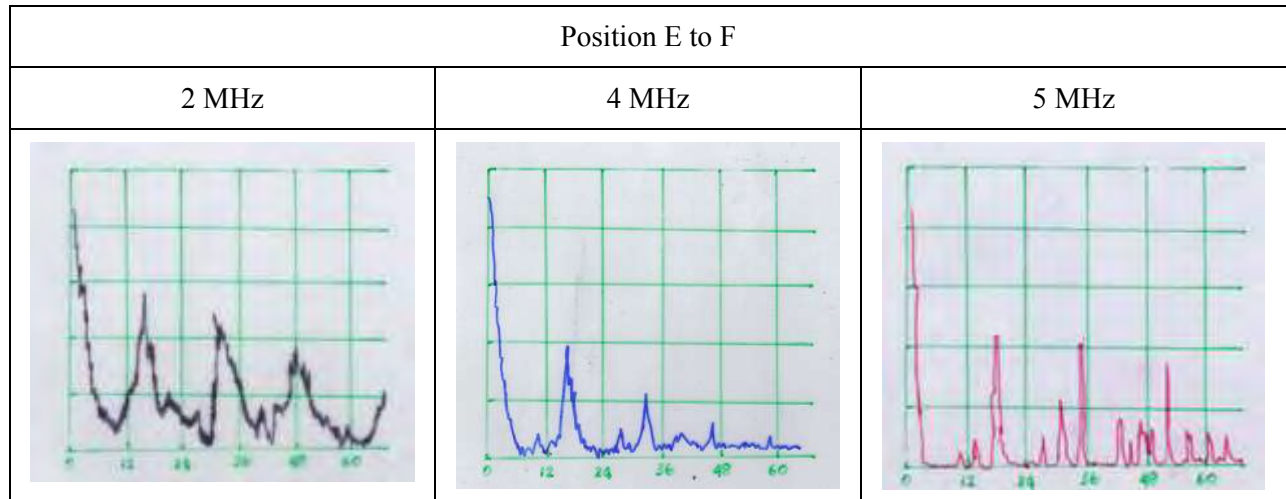
APPENDIX 4A

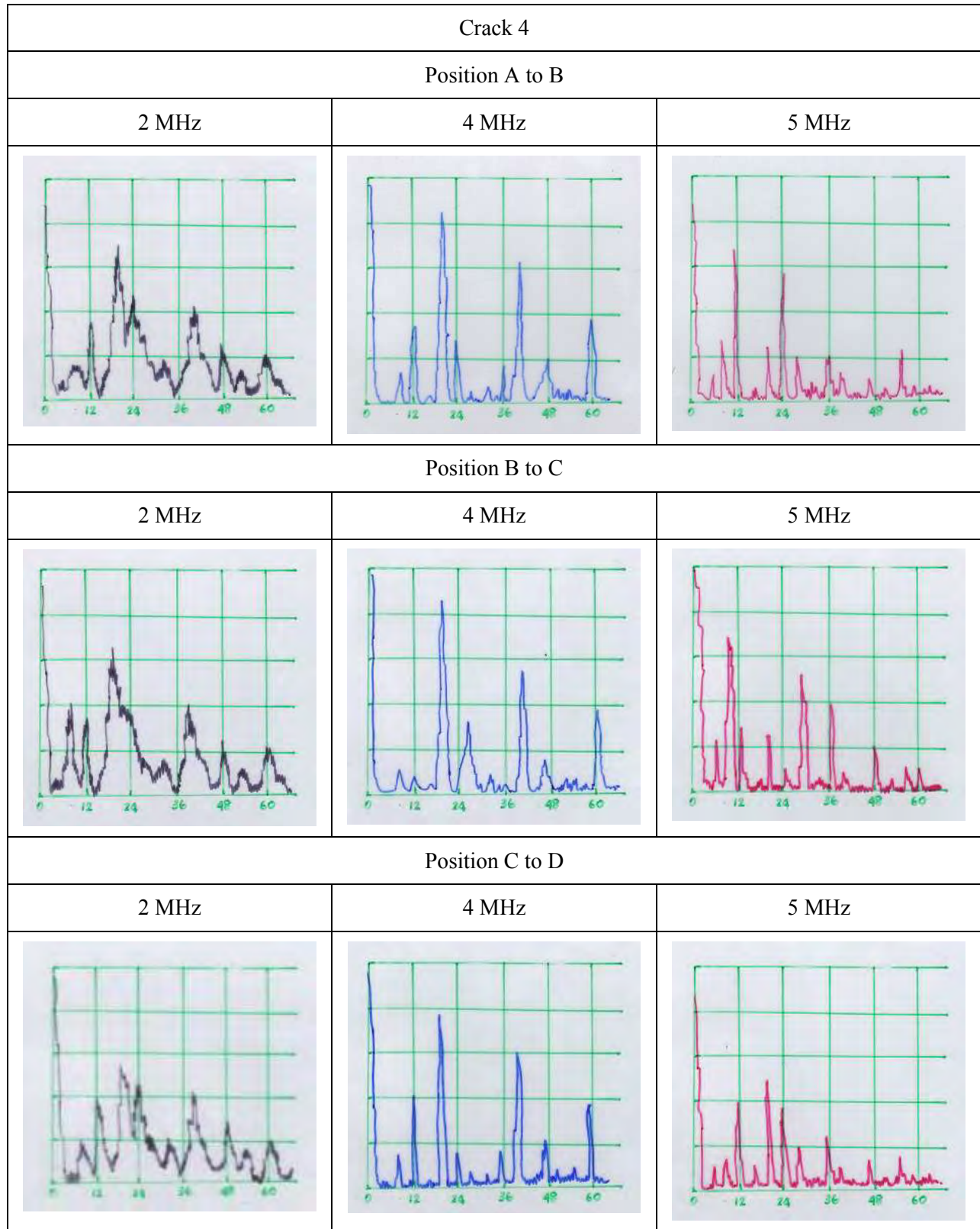
A-SCAN RESULT FOR EFFECT OF PROBE FREQUENCY EXPERIMENT

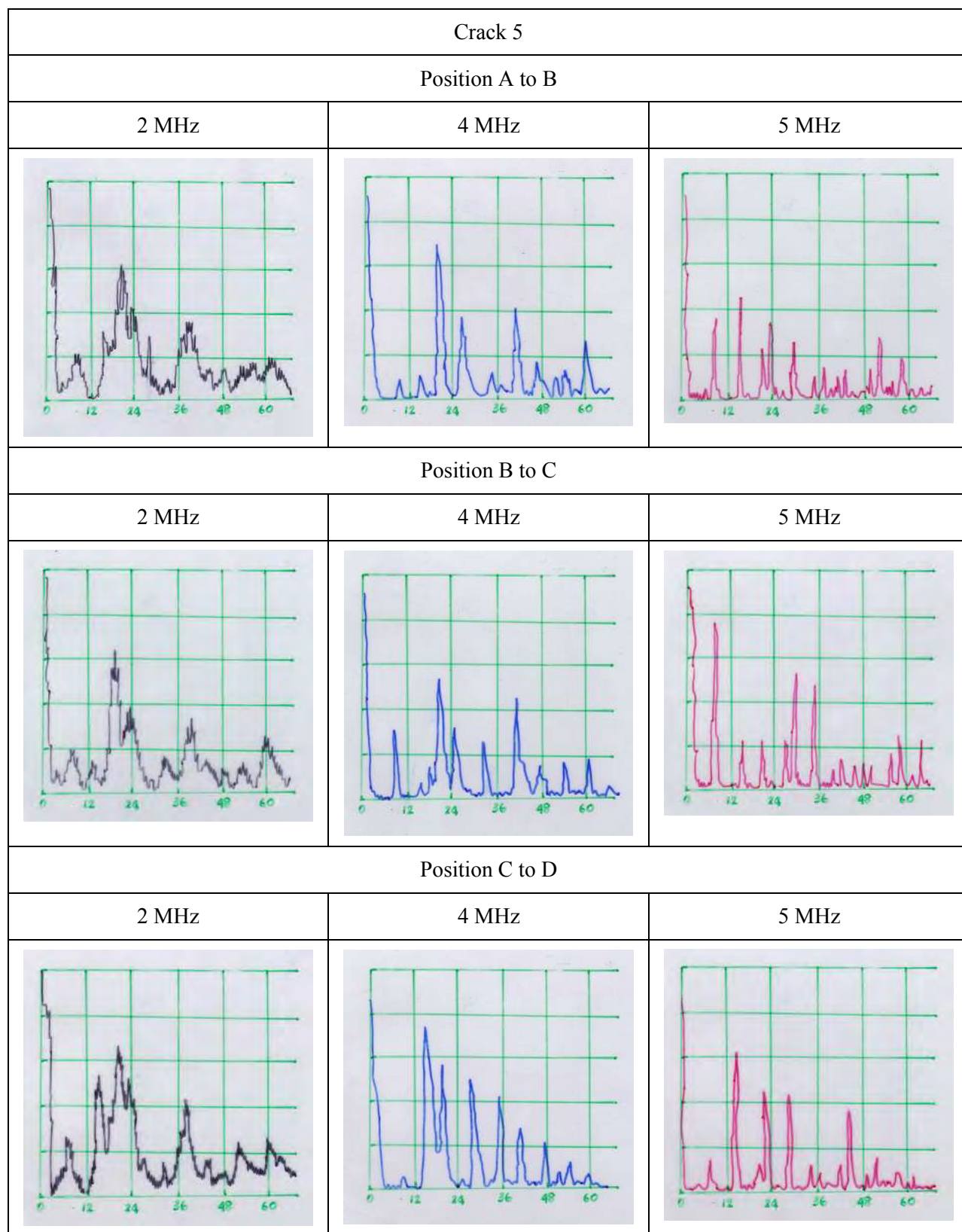


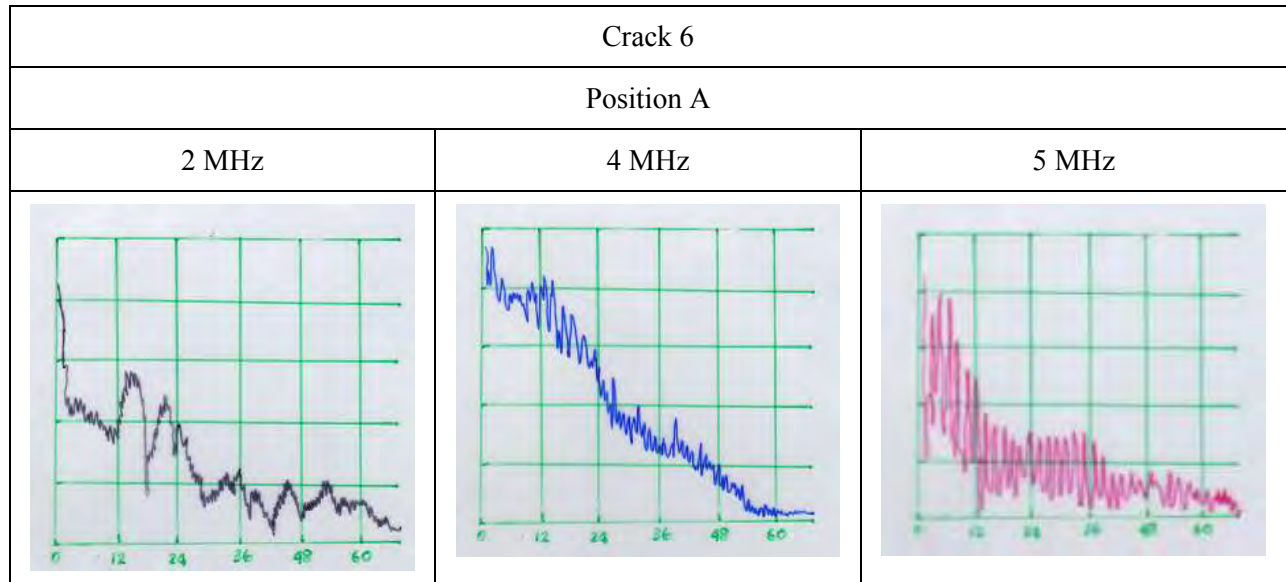






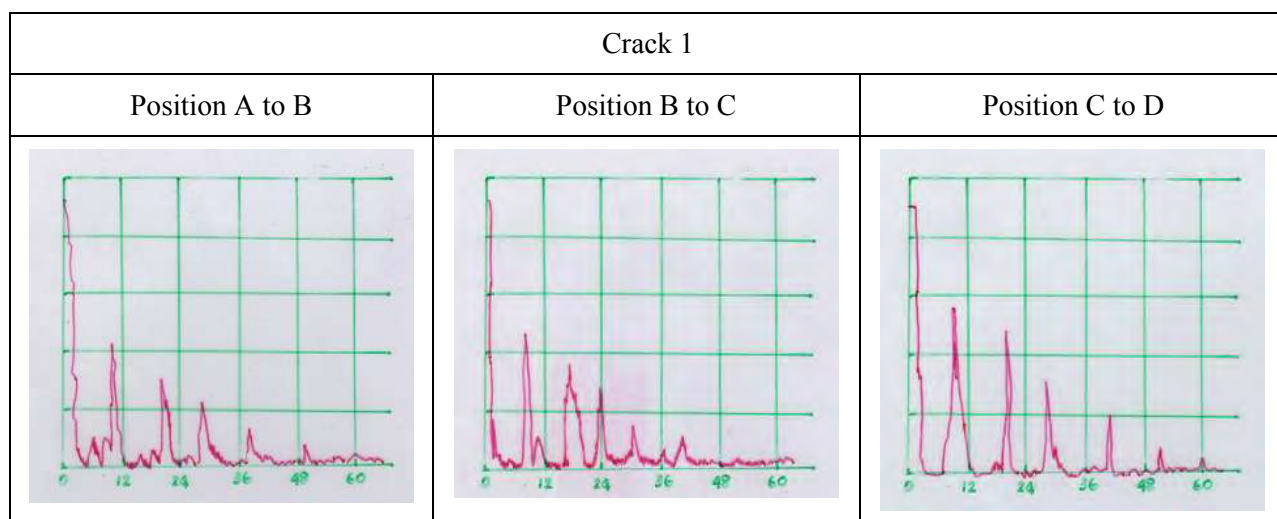
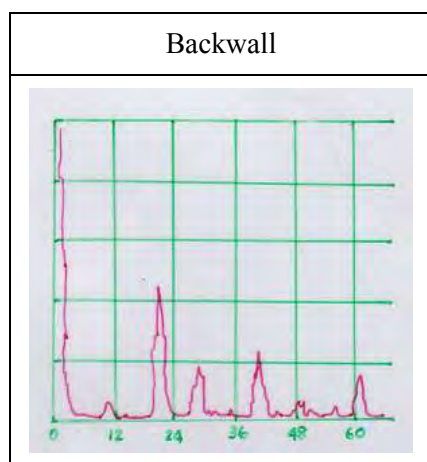


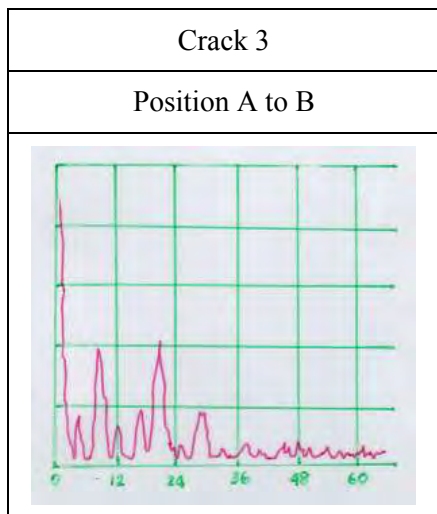
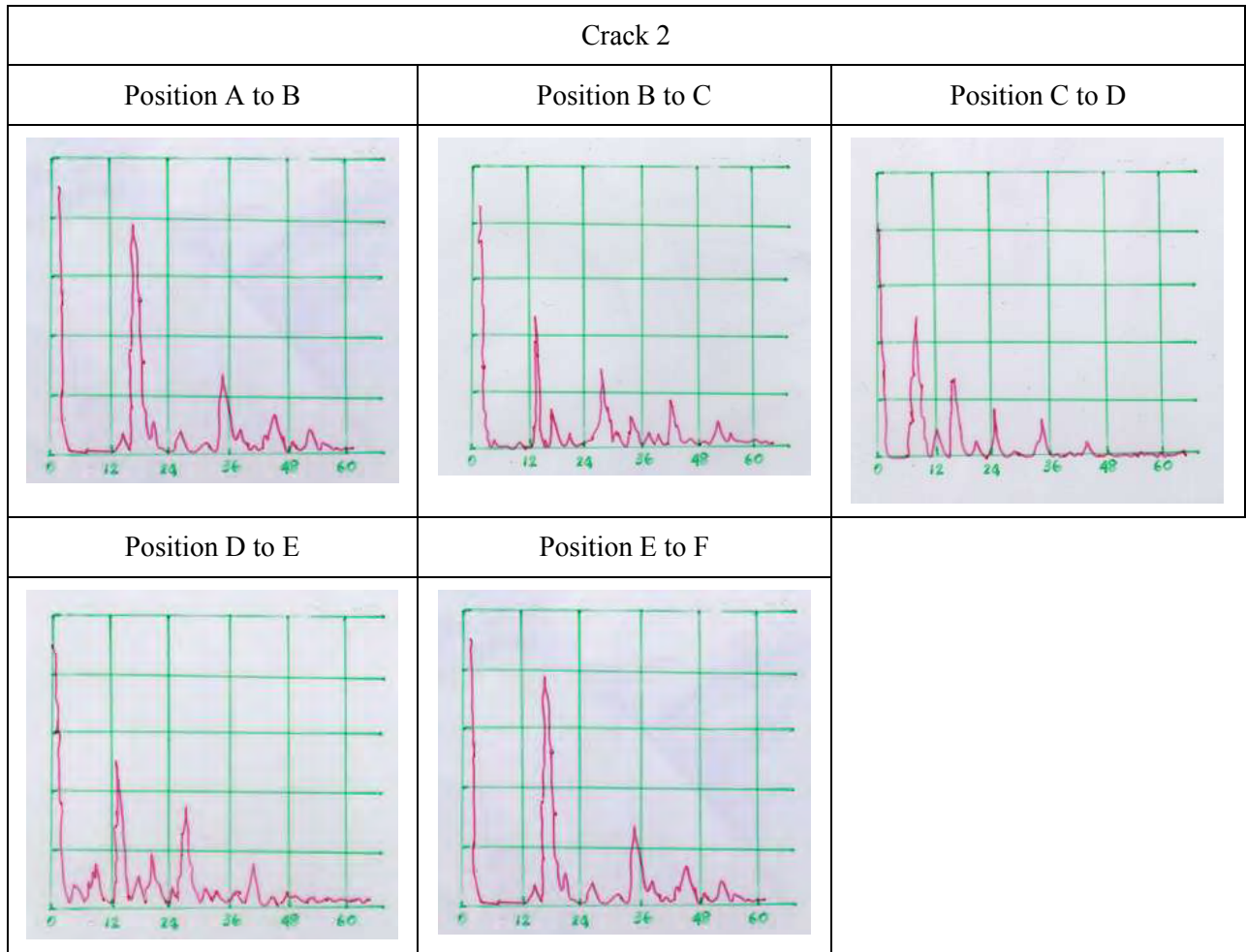


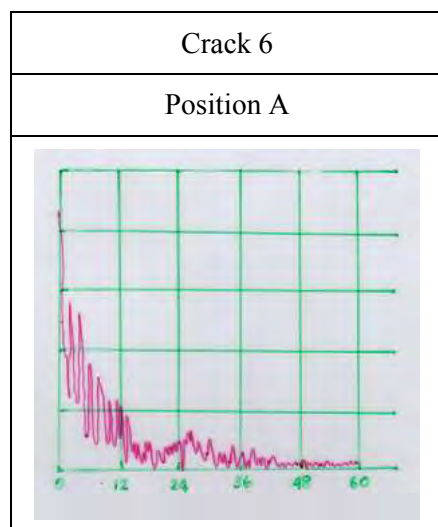
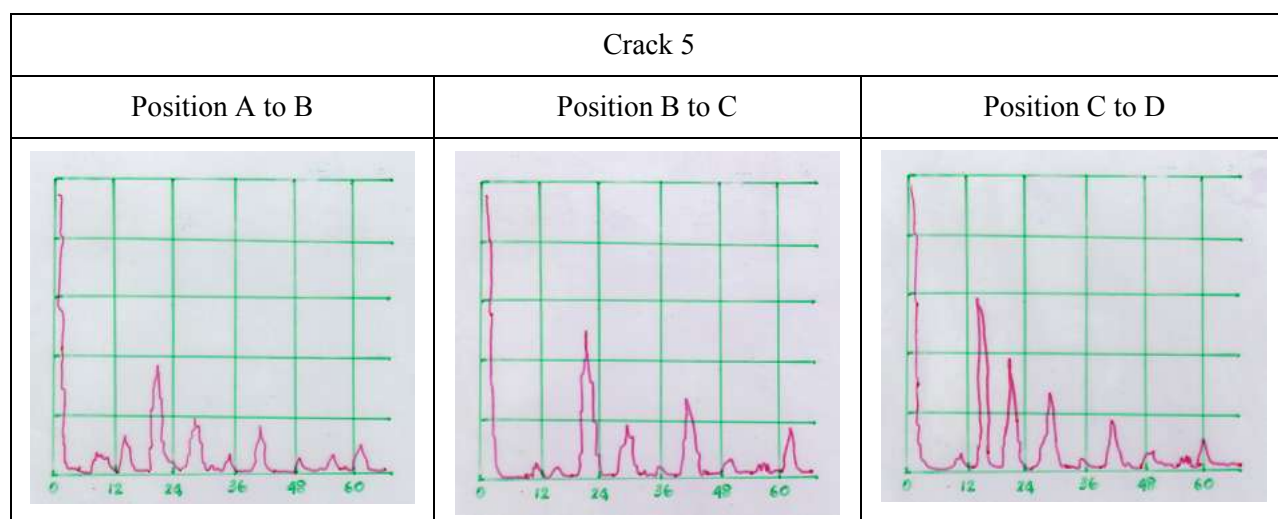
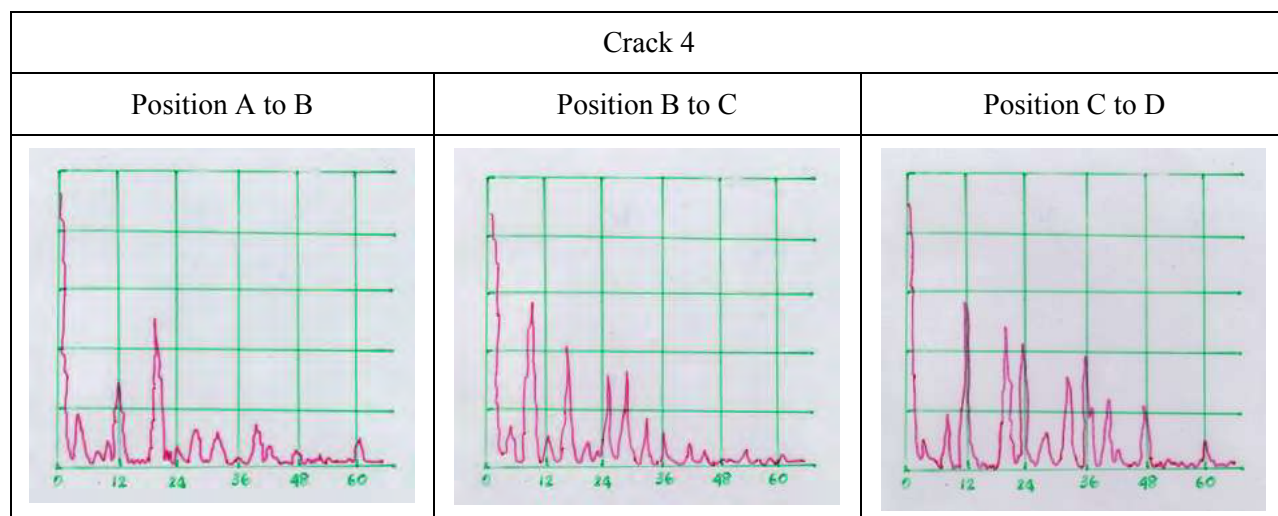


APPENDIX 4B

A-SCAN RESULT FOR 4 MHZ ALUMINUM

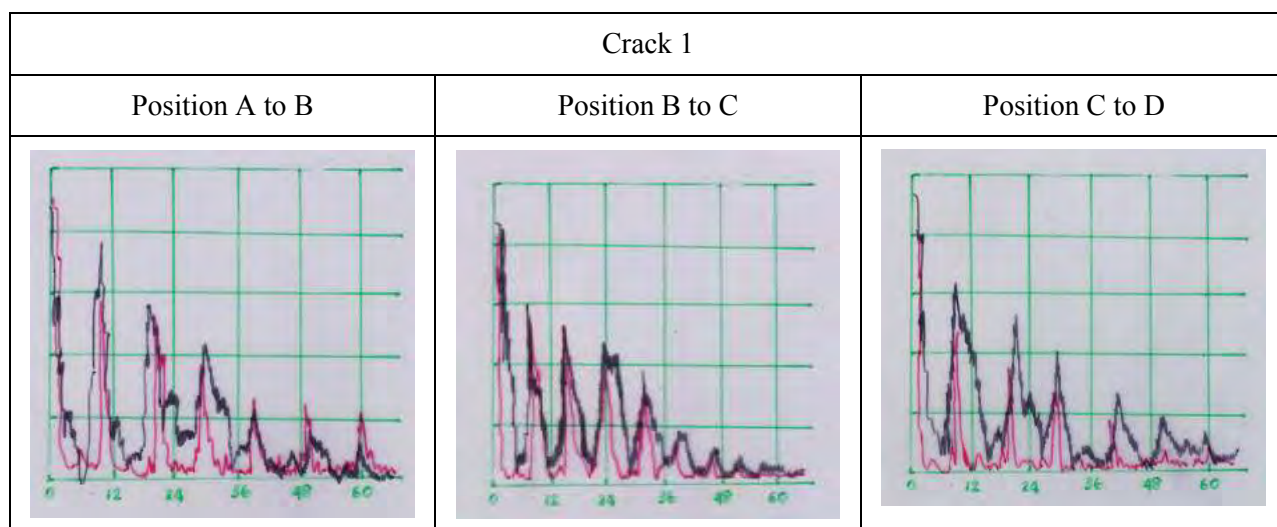
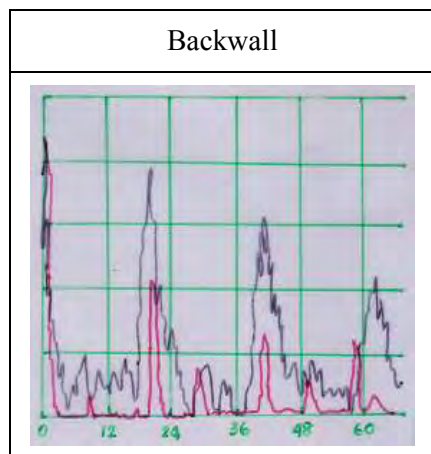


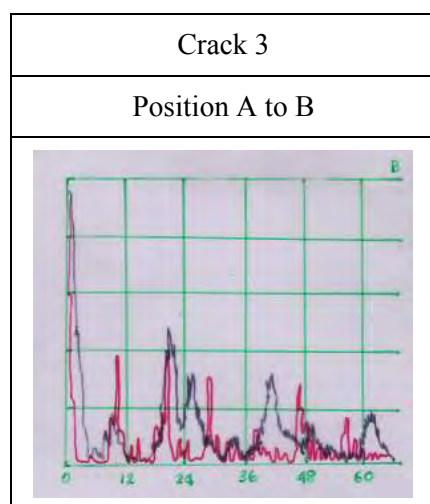
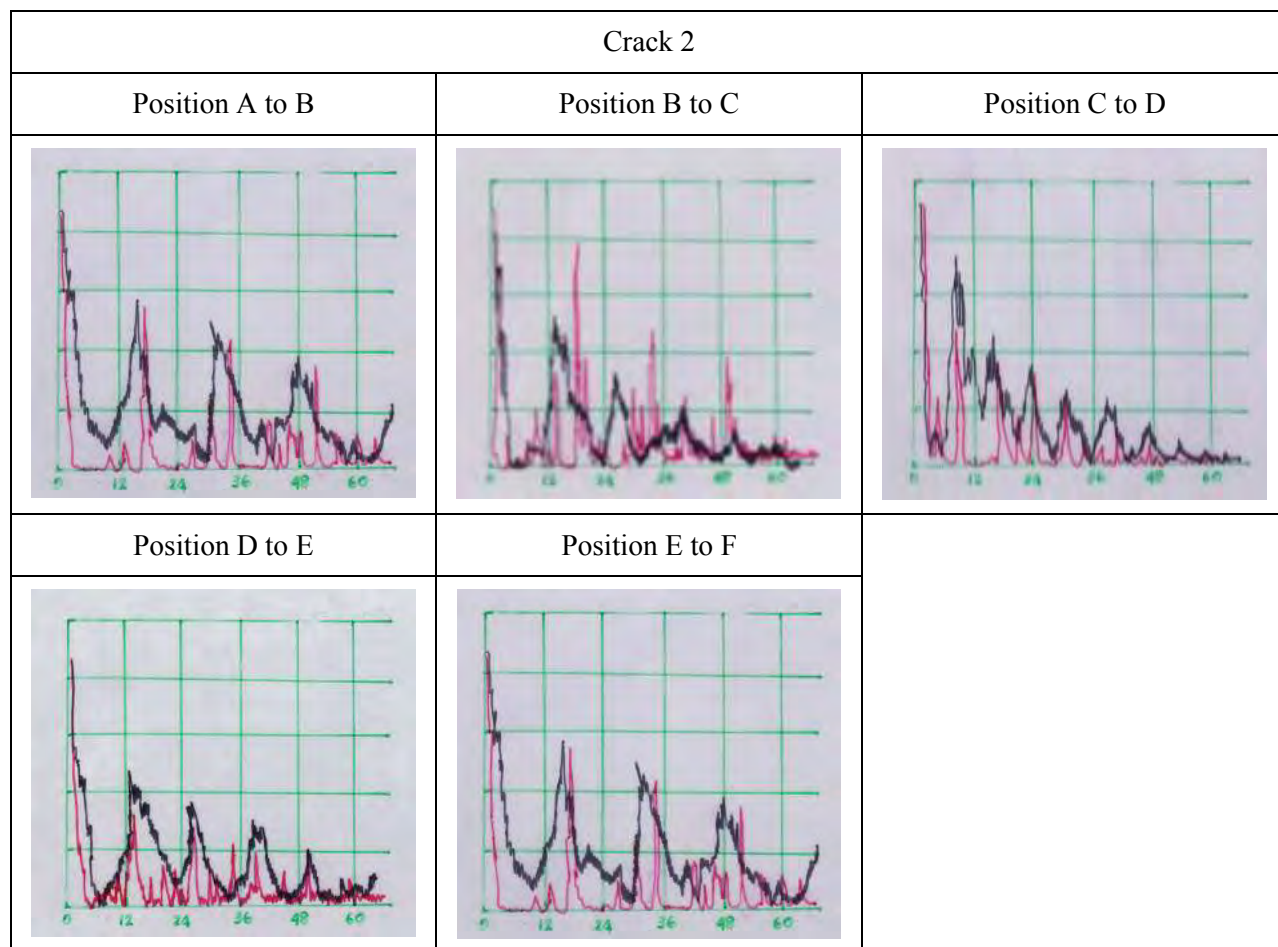


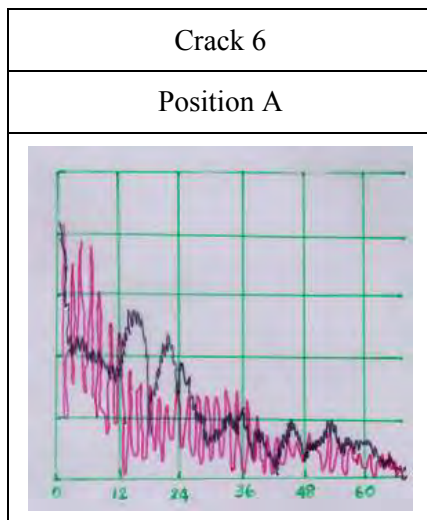
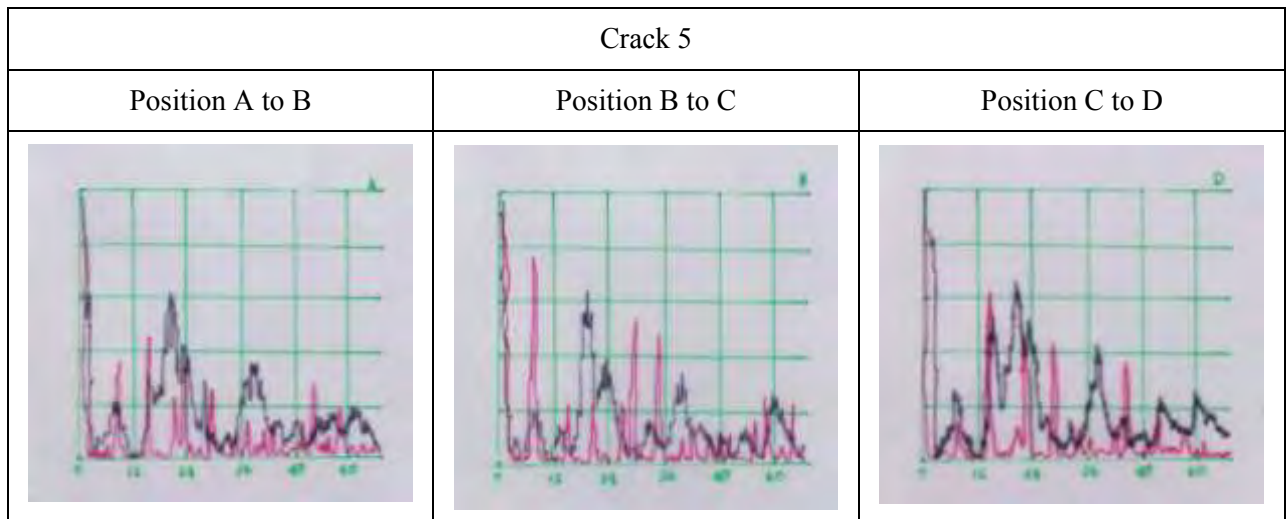
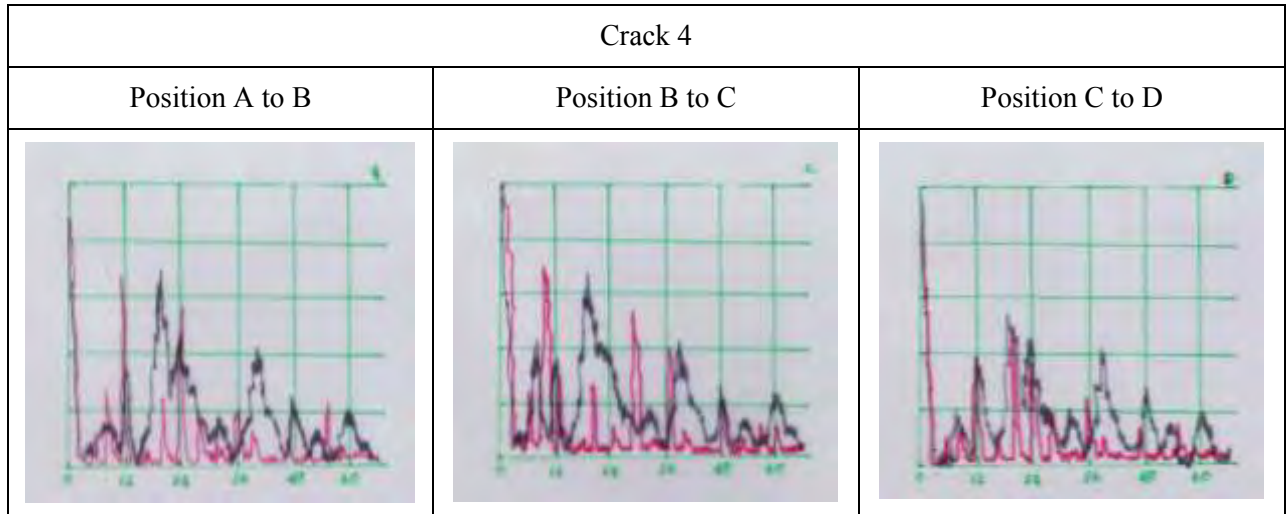


APPENDIX 5A

A-SCAN RESULT FOR 2 MHz vs 5 MHz







APPENDIX 5B

A-SCAN RESULT FOR 4 MHz vs 5 MHz

