**Absolute code for 13 that will be used in all the models.**

G21

G0 G90 x0.0 y0.0 z5

M08

M03 S1000.0;

G0 x0.0 y0.0 z1.0;

G1 z1.0 f100.0;

G1 X0.0 y-40.0;

G1 x0.0 y-40; G0;

G0 Z5

M09;

M05;

For 3

G0 x6 y0.0

GO z1

M08;

M03 S1000.0;

G1 x20.0 y0.0;

G1 x20 y-20;

G1 x6.5 y-20;

G0 Z3 x20;

G0 z1;

G1 y-40;

G1 x6.0;

G91; all the code is incremental now on