DATA BLK. NO.	TYPE BLOCK	TYPE OPER.	DRILLING OPTIONS	MILLING OPTIONS				DIMENSIONS					SUB-ROUTINE DATA					FEED RATE IPM MM/MIN	NO. OF PKS	TOOL NO.	SPINDLE SPEED	TOOL DESCRIPTION & REMARKS
	0 (STD) 1 LOOP 2 REP 3 STOP 4 COPY	0 POS 1 DRILL 2 BORE 3 TAP 4 MILL	0 (STD) 1 BLT CIR 2 CUT RT 3 CUT LT 4 CT RT 2P 5 CT LT 2P	0 (STD) 1 Q CIR C 2 Q CIR CC 3 ARC C 4 ARC CC	0 XY 1 XZ 2 YZ	5 CIRCLE 6 FRAME 7 CIR 2P 8 FRM 2P 9 MENU	0 INSIDE 1 OUTSIDE 2 IN/TAN 3 OUT/TAN 4 POCKET	A - ABSOLUTE I - INCREMENTAL	X	Y	Z UP	Z DN	HOLES	ANG	RADIUS	REPEAT NX	NY					