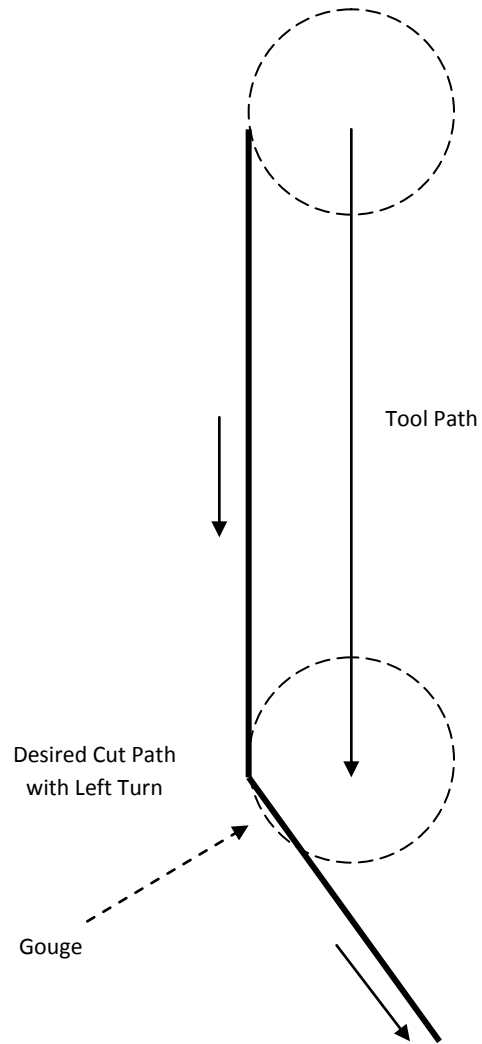
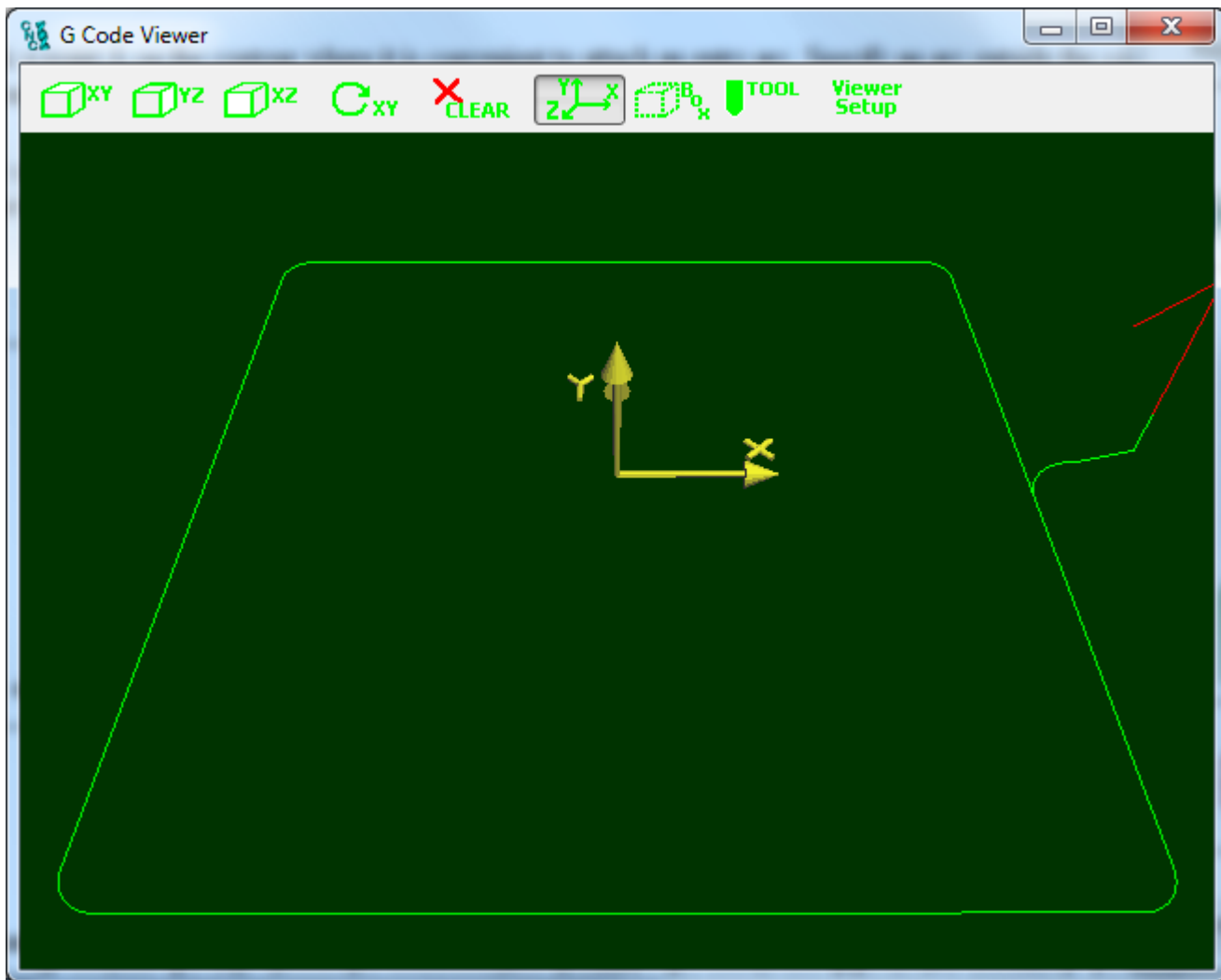


G41 (radius compensation with tool on left) cannot make angled left turns without a gouge into the specified path.

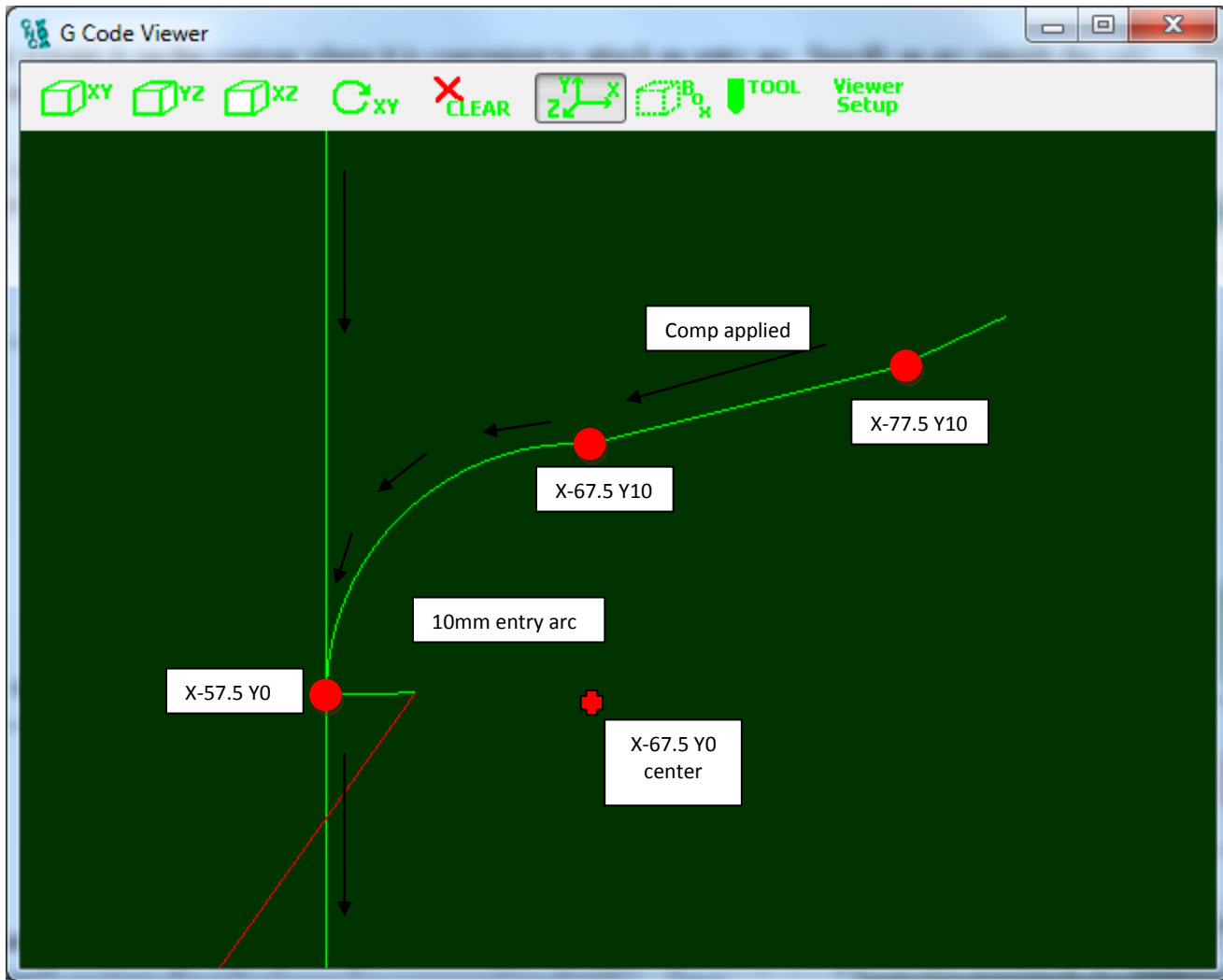


Outside Milling G41 showing 10mm Radius entry arc (Tool Diam=5mm)

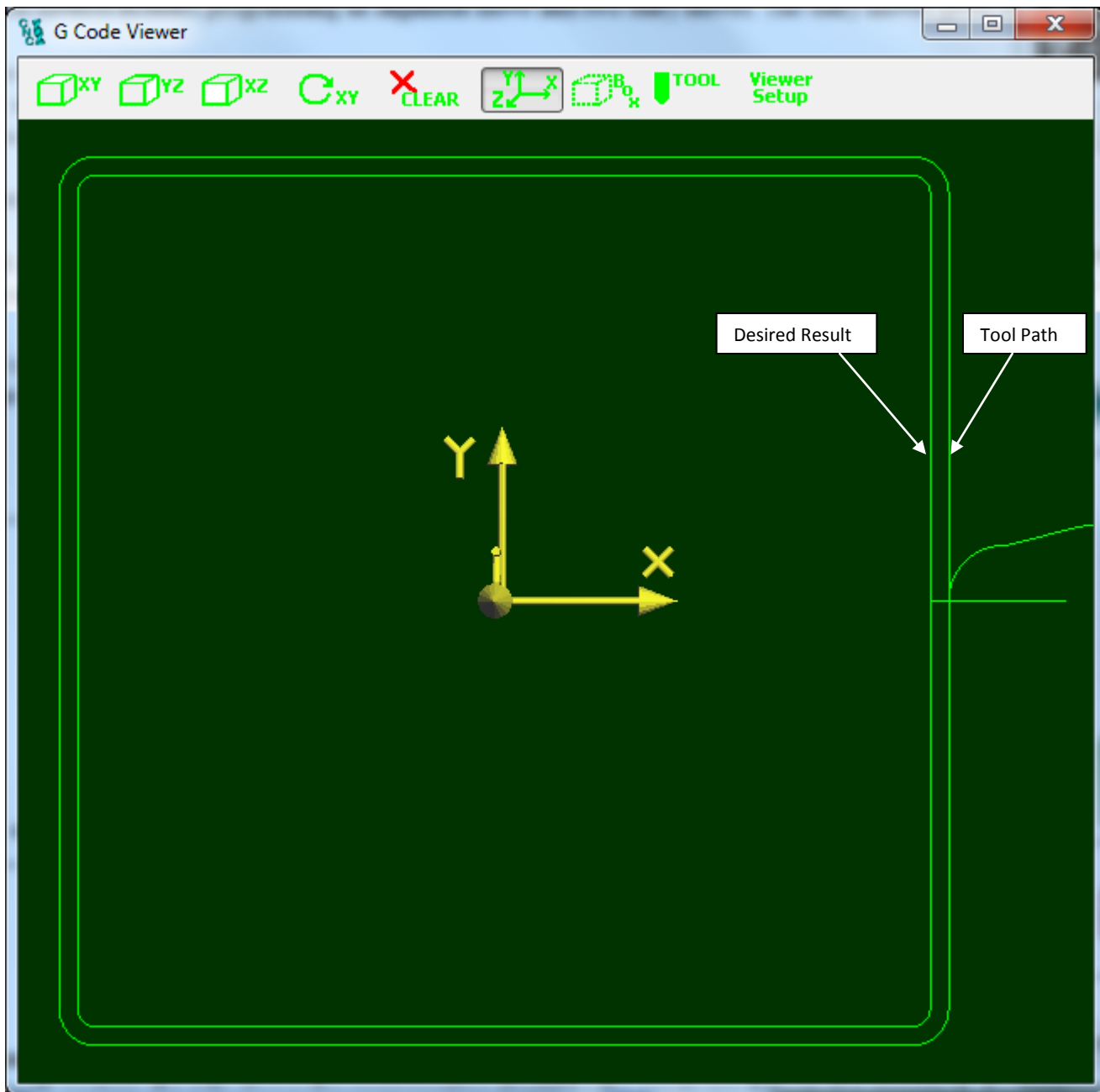


Zoom in on entry moves

```
G00 X77.5 Y10  
Z25.000  
Z2.000  
G01 Z-5.000 (Plunge far to the right of entry point)  
G01 G41D1 X67.5 Y10 (This move applies compensation)  
G03 X57.5 Y0 I0 J-10 (10mm 90 degree arc into path)
```



Plot showing original both tool path without compensation and with compensation



Example Code:

```
N1 G17G90
N2 (000001)
N3 g0G53G40G49
N4 M6T1
N5 G0G90
N10 (EXPORTING TO EDITOR)

G00 X77.5 Y10
Z25.000
Z2.000
G01 Z-5.000 (Plunge far to the right of entry point)
G01 G41D1 X67.5 Y10 (This move applies compensation)
G03 X57.5 Y0 I0 J-10 (10mm 90 degree arc into path)
G01 X57.500

N40 Y-55.000
N45 G02 X55.000 Y-57.500 I-2.500 J0.000
N50 G01 X-55.000
N55 G02 X-57.500 Y-55.000 I0.000 J2.500
N60 G01 Y55.000
N65 G02 X-55.000 Y57.500 I2.500 J0.000
N70 G01 X55.000
N75 G02 X57.500 Y55.000 I0.000 J-2.500
N80 G01 Y0.000
N85 G40 X62.595
N90 G00 Z25.000

(Show original path without compensation)
G01 X57.500 Z-5
N40 Y-55.000
N45 G02 X55.000 Y-57.500 I-2.500 J0.000
N50 G01 X-55.000
N55 G02 X-57.500 Y-55.000 I0.000 J2.500
N60 G01 Y55.000
N65 G02 X-55.000 Y57.500 I2.500 J0.000
N70 G01 X55.000
N75 G02 X57.500 Y55.000 I0.000 J-2.500
N80 G01 Y0.000
N85 G40 X62.595
N90 G00 Z25.000

N95 M30
```