```
( Metric Example - with added comments)
()
G01 X0.000 Y9.302 Z-2.000
( Last line executed before the Pause.)
G01 X-8.847 Y2.874 Z-2.000
( GENERIC PAUSE CODE STARTS HERE )
( Stop the spindle, chip blower, dust collector, etc.)
M05
( Raise cutter out of work - Safe Z is a good amount)
G00 Z2
( Optional Dwell before the next movement. This is 1 second.)
G04 P1
( UNCOMMENT AND CHANGE THE FOLLOWING BLOCKS TO CUSTOMIZE )
( Get out of the way - move to 200mm right - 8 inches)
G00 X200 Y0
( Null tool change! Machine does PAUSE. Waits for CONTINUE.)
M06 T01
( After Clicking Continue - Restart whatever was Stopped.)
M03
( Return back to the X-Y position before the Pause)
G00 X-8.847 Y2.874
( Another optional dwell - just to feel comfortable)
G04 P1
( Repeat the last line from before the Pause - Z movement)
G01 X-8.847 Y2.874 Z-2.000
( GENERIC PAUSE CODE ENDS HERE )
( Press on with the rest of the toolpath.)
G01 X-5.468 Y-7.525 Z-2.000
G01 X5.468 Y-7.525 Z-2.000
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