

2.9.29 CANNED CYCLES (G73, G74, G76, G77, G80 TO G89, G98, G99)[†] (CONT'D)

Table 2.25 Canned Cycle (continued)

	With G99 (return to R)	With G98 (return to initial point)
G87	G87 X... Y... Z... R... Q... L... F... ;	
Boring	<p>(X, Y)</p> <p>SPINDLE START</p> <p>R</p> <p>MANUAL RETRACTION</p> <p>Z</p> <p>SPINDLE STOP</p>	<p>(X, Y)</p> <p>SPINDLE START</p> <p>INITIAL POINT</p> <p>R</p> <p>MANUAL RETRACTION</p> <p>Z</p> <p>SPINDLE STOP</p>
G88	G88 X... Y... Z... R... P... L... F... ;	
Boring	<p>(X, Y)</p> <p>SPINDLE START</p> <p>R</p> <p>MANUAL RETRACTION</p> <p>Z</p> <p>SPINDLE STOP AFTER DWELL (P)</p>	<p>(X, Y)</p> <p>SPINDLE START</p> <p>INITIAL POINT</p> <p>R</p> <p>MANUAL RETRACTION</p> <p>Z</p> <p>SPINDLE STOP AFTER DWELL (P)</p>
G89	G89 X... Y... Z... R... P... L... F... ;	
Boring	<p>(X, Y)</p> <p>R</p> <p>Z</p> <p>DWELL (P)</p>	<p>(X, Y)</p> <p>INITIAL POINT</p> <p>R</p> <p>Z</p> <p>DWELL (P)</p>