Table 2.25 Canned Cycle (continued)

	With G99 (return to R)	With G98 (return to initial point)
G76	G76 X Y Z R Q L. (X, Y) SPINDLE START R #6210 DWELL #6223 DWELL Z	SPINDLE START INITIAL POINT #6210 DWELL SPINDLE START INITIAL POINT SPEED #6223 #6223 Z
	SPINDLE INDEXING STOP U	SPINDLE Q INDEXING Q STOP
G77	G77 X Y Z R Q L.	
Back boring	NOT USED	SHIFT POINT DWELL Z SPINDLE Q ORIENTATION SPINDLE START
G80 Cancel	G80 ;	
G81	C81 X Y Z R L F. (X, Y)	(X, Y) INITIAL POINT
Drilling	R	R Z