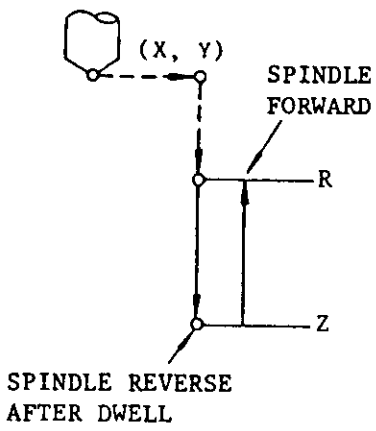
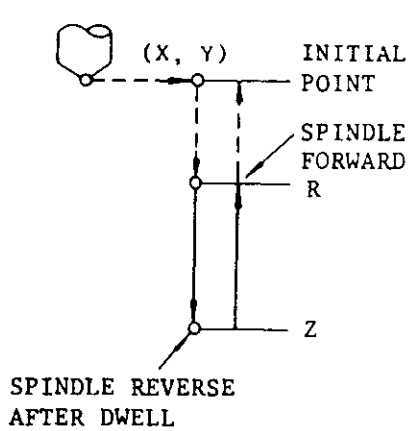
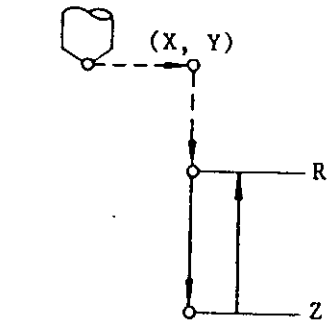
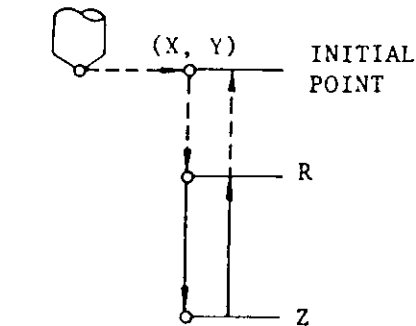
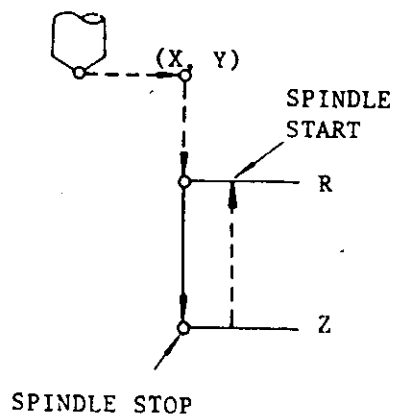
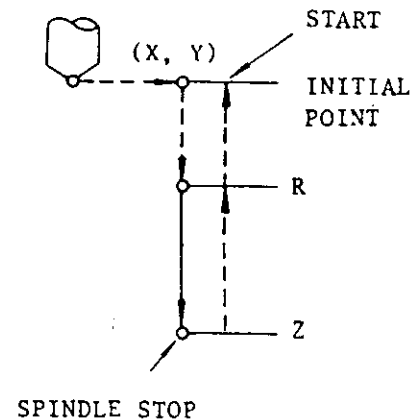


Table 2.25 Canned Cycle (continued)

	With G99 (return to R)	With G98 (return to initial point)
<p>G84</p> <p>Tapping</p>	<p>G84 X... Y... Z... (R)... (P)... L... F... ;</p>  <p>SPINDLE FORWARD</p> <p>SPINDLE REVERSE AFTER DWELL</p>	<p>G84 X... Y... Z... (R)... (P)... L... F... ;</p>  <p>INITIAL POINT</p> <p>SPINDLE FORWARD</p> <p>SPINDLE REVERSE AFTER DWELL</p>
<p>G85</p> <p>Boring</p>	<p>G85 X... Y... Z... R... L... F... ;</p> 	<p>G85 X... Y... Z... R... L... F... ;</p>  <p>INITIAL POINT</p>
<p>G86</p> <p>Boring</p>	<p>G86 X... Y... Z... R... L... F... ;</p>  <p>SPINDLE START</p> <p>SPINDLE STOP</p>	<p>G86 X... Y... Z... R... L... F... ;</p>  <p>SPINDLE START</p> <p>INITIAL POINT</p> <p>SPINDLE STOP</p>