EXAMPLE

A. G98 G90 G81 X⋯ Y⋯ Z-7000 R-4000 F⋯ ;

⋯ Return to initial point, absolute

B. G99 G91 G81 X⋯ Y⋯ Z-7000 R-4000 F⋯ ;

⋯ Return to R point, incremental

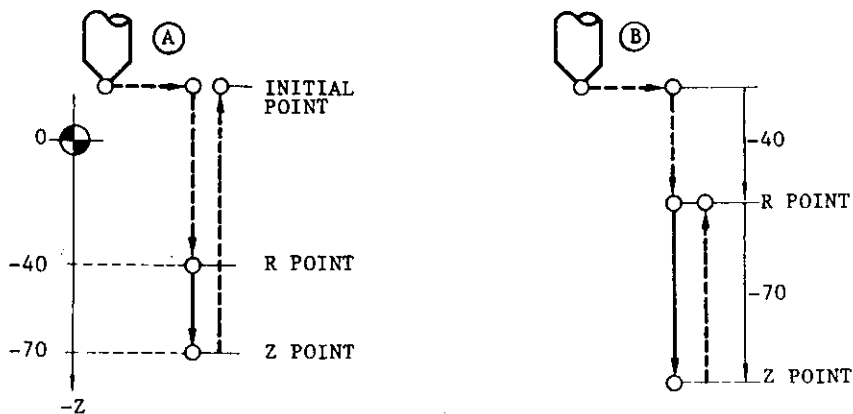
Fig. 2.82

C. N1 G92 X0 Y0 Z0 ;

N2 G98 G90 G81 X1000 Y1000
Z-5000 R-2000 F100 ;

N3 G91 X2000 R-3000 ;

N4   Z-5000 ;

N5 G99 Z-4000 R-5000 ;

N6 G80 G00 Z5000 ;

Absolute position		Remarks
Z =	R =	
-5000	-2000	Canned cycle start
-5000	-3000	Change in X, R
-8000	-3000	Change in Z
-9000	-5000	Change in R, Z
Tool moves to Z = 0		Canned cycle cancel

Newly programmed addresses only are changed including the case where switching is made from G90 to G91 such as N2 → N3 indicated in the above case. As for the non-programmed addresses, the positions programmed in the earlier blocks are maintained.

Note: Since address P, Q, I, J and K are modal in canned cycle mode, if once commanded, they are effective until the canned cycle is cancelled.