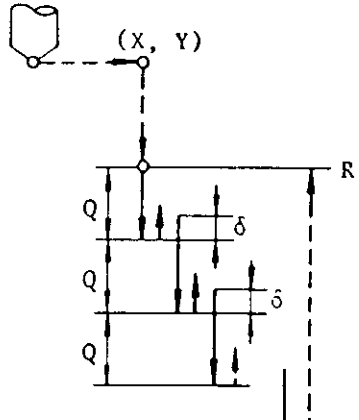
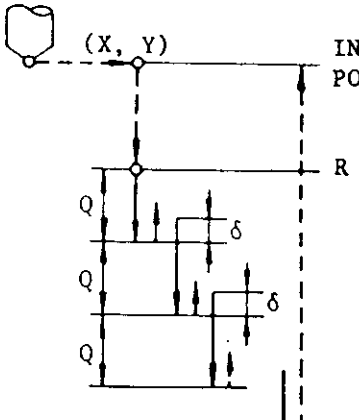
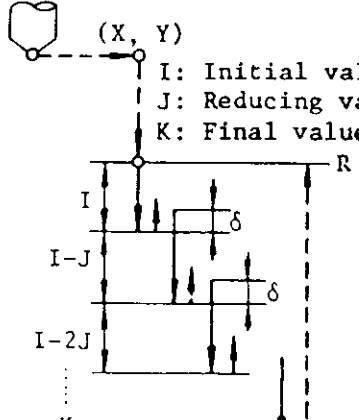
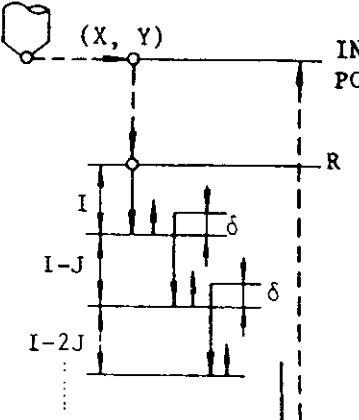
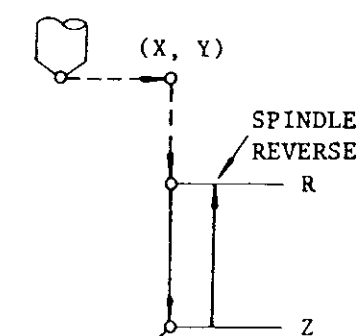
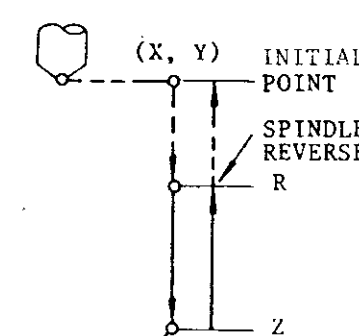


2.9.29 CANNED CYCLES (G73, G74, G76, G77  
G80 TO G89, G98, G99)<sup>†</sup> (CONT'D)

Table 2.25 Canned Cycle

	With G99 (return to R)	With G98 (return to initial point)
<p>G73 (Fixed pitch)</p> <p>High speed deep hole drilling</p>	<p>G73 X... Y... Z... R... Q... L... F... ;</p>  <p><math>\delta</math>: Setting data (#211)</p>	 <p><math>\delta</math>: Setting data</p>
<p>G73 (Variable)</p> <p>High speed deep hole drilling</p>	<p>G73 X... Y... Z... R... I... J... K... L... F... ;</p> <p>I: Initial value J: Reducing value K: Final value</p>  <p><math>\delta</math>: Setting data (#211)</p>	 <p><math>\delta</math>: Setting data</p>
<p>G74</p> <p>Reverse tapping</p>	<p>G74 X... Y... Z... R... P... L... F... ;</p>  <p>SPINDLE FORWARD AFTER DWELL</p>	 <p>SPINDLE FORWARD AFTER DWELL</p>