

Command format:

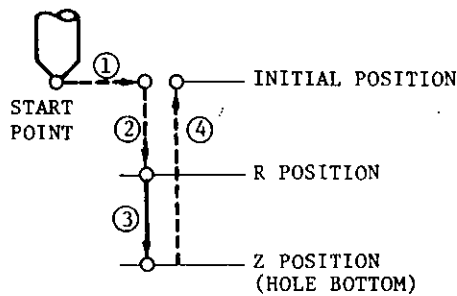
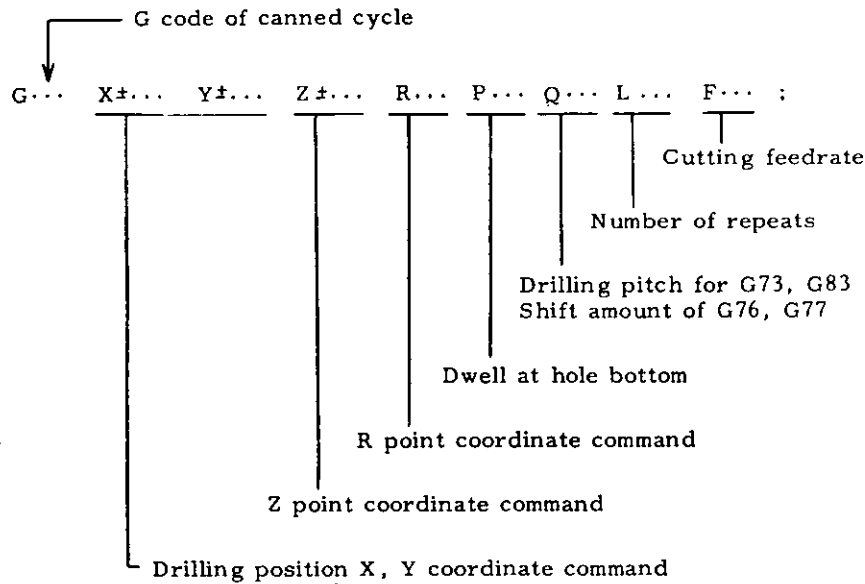


Fig. 2.81

Operations ① through ④ are executed in one cycle with the commands shown above.

- ① Positioning the drilling position (X,Y)
- ② Rapid traverse to R point
- ③ Drilling to Z point
- ④ Return to R point or to initial point

Number of repeats is specified by the address L. Where L is not given, number of repeats is regarded as "1." If 0 is given for L, only positioning to (X, Y) is made. Shift direction of shift of G76, G77 can be made at the intended angle specified by the parameter. (#6019D0) Z axis returning position at the end of canned cycle can be designated by the following G code.

G code	Meaning
G98	Initial level return
G99	R position level return

Note: When power is applied or the control is reset, the control is in the state of G code marked with .

Where parameter #6019D0 is set to 0, the shift direction is made in the specified direction. The direction is set as listed below.

Bit Direction	D2	D1
X(+)	0	0
X(-)	0	1
Y(+)	1	0
Y(-)	1	1

Where parameter #6019D0 is set to 1, the shift direction is made at the intended angle. The shifting angle is set by setting #6506 (1 = 0.001 deg).