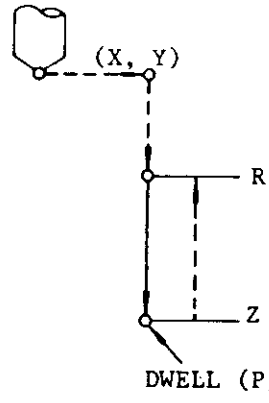
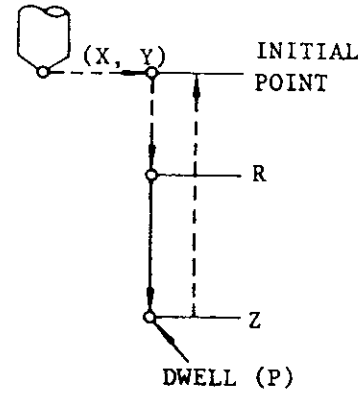
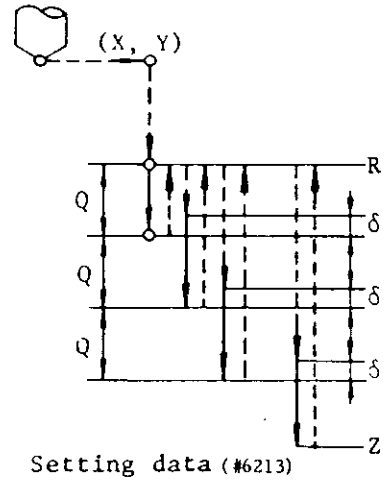
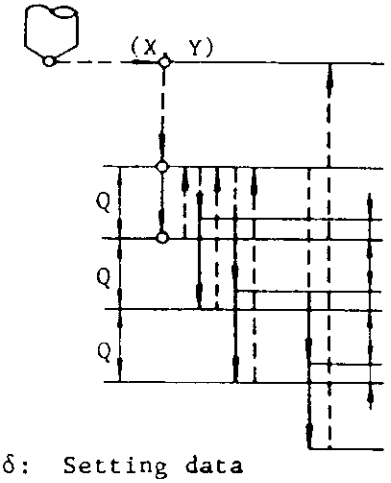
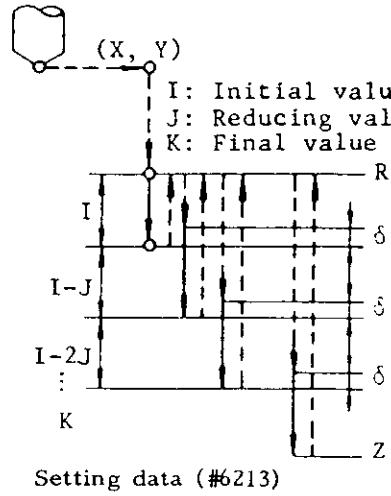
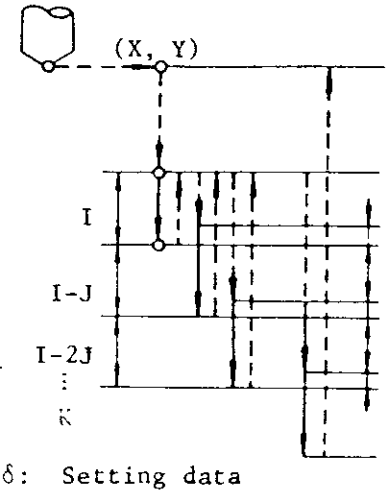
Table 2.25 Canned Cycle (continued)

	With G99 (return to R)	With G98 (return to initial point)
G82 Spot facing	G82 X... Y... Z... R... P... L... F... ; 	
G83 (Fixed pitch) Deep hole drilling	G83 X... Y... Z... R... Q... L... F... ;  δ: Setting data (#6213)	 δ: Setting data
G83 (Variable pitch) Deep hole drilling	G83 X... Y... Z... R... I... J... K... L... F... ;  δ: Setting data (#6213)	 δ: Setting data