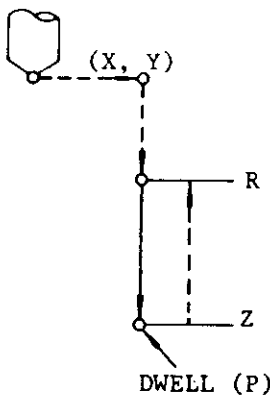
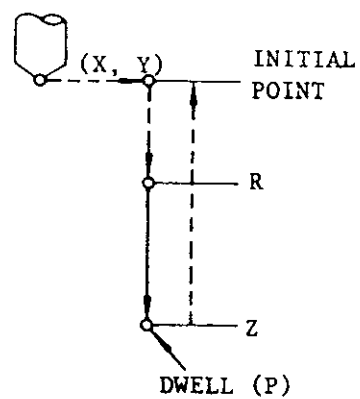
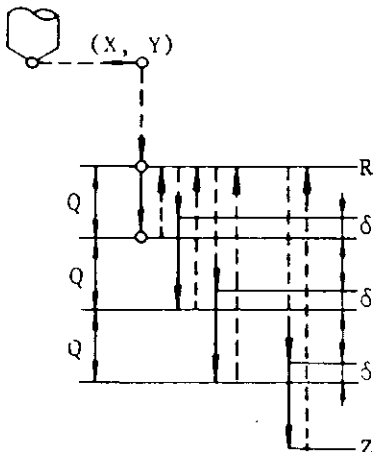
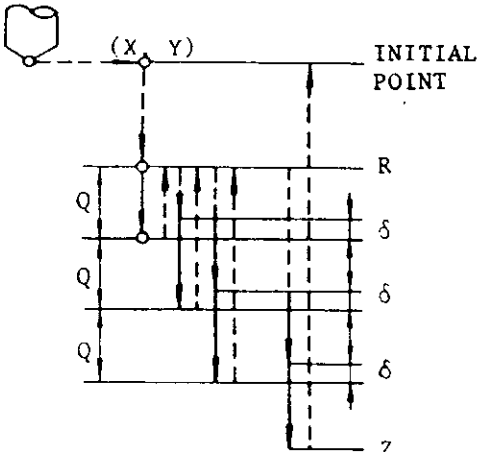
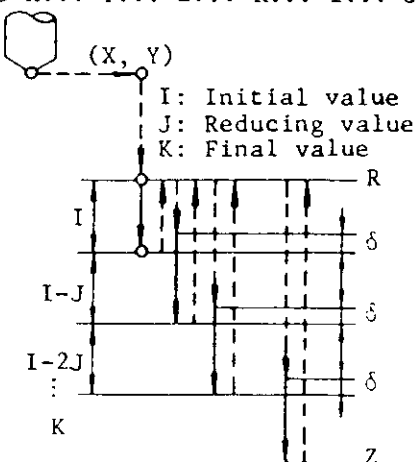
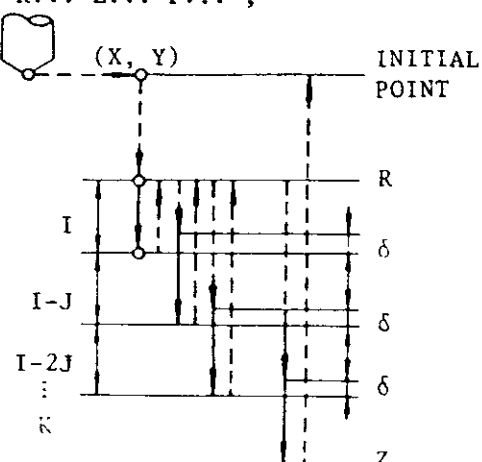


2.9.29 CANNED CYCLES (73, G74, G76, G77  
G80 TO G89, G98, G99)<sup>†</sup> (CONT'D)

Table 2.25 Canned Cycle (continued)

|   | With G99 (return to R)  | With G98 (return to initial point)   |
|---|---|--|
| <p>G82</p> <p>Spot facing</p>                         | <p>G82 X... Y... Z... R... P... L... F... ;</p>  <p>DWELL (P)</p>  | <p>G82 X... Y... Z... R... P... L... F... ;</p>  <p>INITIAL POINT</p> <p>DWELL (P)</p>  |
| <p>G83 (Fixed pitch)</p> <p>Deep hole drilling</p>    | <p>G83 X... Y... Z... R... Q... L... F... ;</p>  <p><math>\delta</math>: Setting data (#6213)</p>   | <p>G83 X... Y... Z... R... Q... L... F... ;</p>  <p><math>\delta</math>: Setting data</p>   |
| <p>G83 (Variable pitch)</p> <p>Deep hole drilling</p> | <p>G83 X... Y... Z... R... I... J... K... L... F... ;</p> <p>I: Initial value<br/>J: Reducing value<br/>K: Final value</p>  <p><math>\delta</math>: Setting data (#6213)</p> | <p>G83 X... Y... Z... R... I... J... K... L... F... ;</p> <p>I: Initial value<br/>J: Reducing value<br/>K: Final value</p>  <p><math>\delta</math>: Setting data</p> |