

2.9.29 CANNED CYCLES (73, G74, G76, G77,
G80 TO G89, G98, G99)[†] (CONT'D)

EXAMPLE

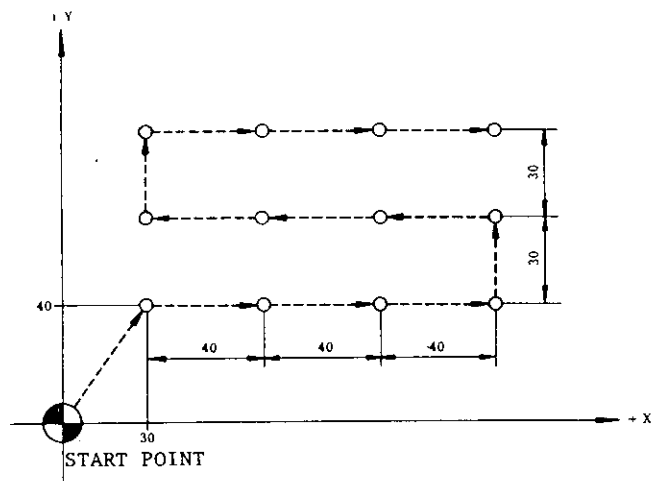


Fig. 2.84

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N10 G92 X0 Y0 Z0 ;
N11 G90 G98 ;          . . . Return to initial point, Absolute
N12 G81 X3000 Y4000 R-2000 Z-3000 F200 ; . . . Drilling cycle
N13 M98 P100 ;        . . . Jump to subprogram
N14 G00 X0 Y0 ;
N15 T05 ;             . . . Tapper selection
N16 M06 ;             . . . Tool change
N17 G84 X3000 Y4000 R-2000 Z-3000 F2000 ; . . . Tapping cycle
N18 M98 P400 ;        . . . Jump to subprogram (Note)
N19 G00 X0 Y0 ;
.
.
O400
N100 G91 X4000 L3 ;
N101 Y3000 ;
N102 X-4000 L3 ;
N103 Y3000 ;
N104 X4000 L3
N105 G90 G80 ;
N106 M99 ;

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} Subprogram for drilling position pattern.