

G96, G97(Constant travelling speed control ON, OFF)

G Code	Constant travelling speed control	Meaning	Unit
G 96	ON	To control the traveling speed constantly	m/min
G 97	OFF	Designate the rotating time of main spindle	rpm

Example) G96 S100 :

Cutting speed is 100m/min

G97 S100 :

Rotating time of main spindle is 100rpm

G98, G99(Feedrate selection)

G CODE	Meaning	Unit
G 98	Feedrate per minute	mm/min
G 97	Feedrate per rotation	mm/rev

Example) G98 G01 Z100.0 F50.0 :

Feedrate of tool is 50mm per minute.

G97 G01 Z10.0 F0.3 :

Feedrate of tool is 0.3mm per rotation of main spindle.

However, unless there is the G98 command, N.C unit is always in G99 condition.
Therefore it is not necessary to command G99 separately.

Fanuc O T User Manual

Y Pai



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CNC Programming Handbook Peter Smid,2003 Comes with a CD ROM packed with a variety of problem solving projects

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Before the introduction of automatic machines and automation industrial manufacturing of machines and their parts for the key industries were made though manually operated machines Due to this manufacturers could not make complex profiles or shapes with high accuracy As a result the production rate tended to be slow production costs were very high rejection rates were high and manufacturers often could not complete tasks on time Industry was boosted by the introduction of the semi automatic manufacturing machine known as the NC machine which was introduced in the 1950 s at the Massachusetts Institute of Technology in the USA After these NC machine started to be used typical profiles and complex shapes could get produced more readily which in turn lead to an improved production rate with higher accuracy Thereafter in the 1970 s an even larger revolutionary change was introduced to manufacturing namely the use of the CNC machine Computer Numerical Control Since then CNC has become the dominant production method in most manufacturing industries including automotive aviation defence oil and gas medical electronics industry and the optical industry Basics of CNC Programming describes how to design CNC programs and what cutting parameters are required to make a good manufacturing program The authors explain about cutting parameters in CNC machines such as cutting feed depth of cut rpm cutting speed etc and they also explain the G codes and M codes which are common to CNC The skill set of CNC program writing is covered as well as how to cut material during different operations like straight turning step turning taper turning drilling chamfering radius profile profile turning etc In so doing the authors cover the level of CNC programming from basic to industrial format Drawings and CNC programs to practice on are also included for the reader April 2024 - Surplus Record Machinery & Equipment Thomas Scanlan, SURPLUS

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