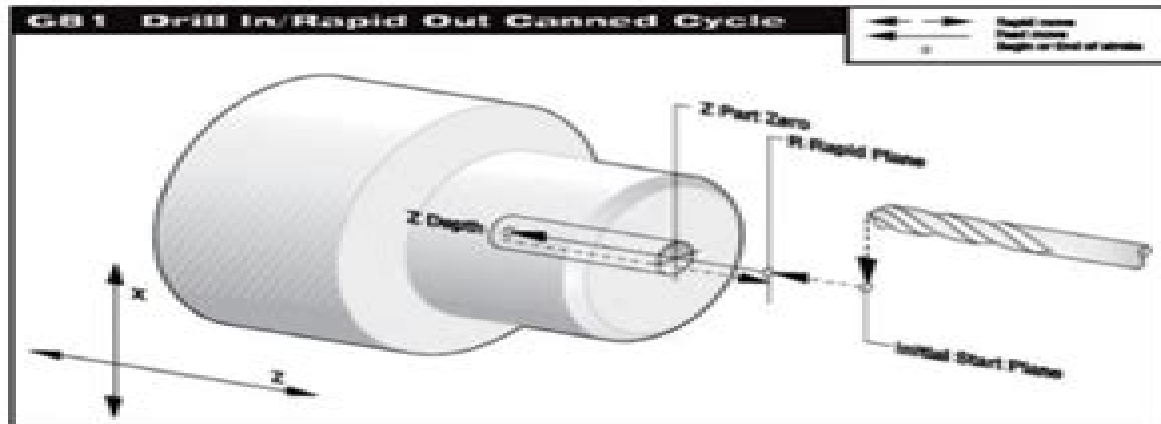


G81 DRILL CANNED CYCLE

X Optional X-axis motion command
 Z Position of bottom of hole
 R Position of the R plane
 F Feed Rate



TOOL DESCRIPTION
 1/2 DIA. DRILL

TOOL
 1

OFFSET
 01

RADIUS
 0

TIP
 0

O00119 (G81 Drilling)

N1 G28

N2 T101 (1/2 DIA. DRILL)

(Tool 1 Offset 1)

N3 G97 S1450 M03

N4 G54 G00 X0. Z1. M08

(Rapid to Initial Start Point)

N5 G81 Z-0.625 R0.1 F0.005

(G81 Drilling Cycle)

N6 G80 G00 Z1.0 M09

N7 G28

N8 M30

Haas Lathe Programming Manual

Brendan G. Carr



Haas Lathe Programming Manual:

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