

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

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