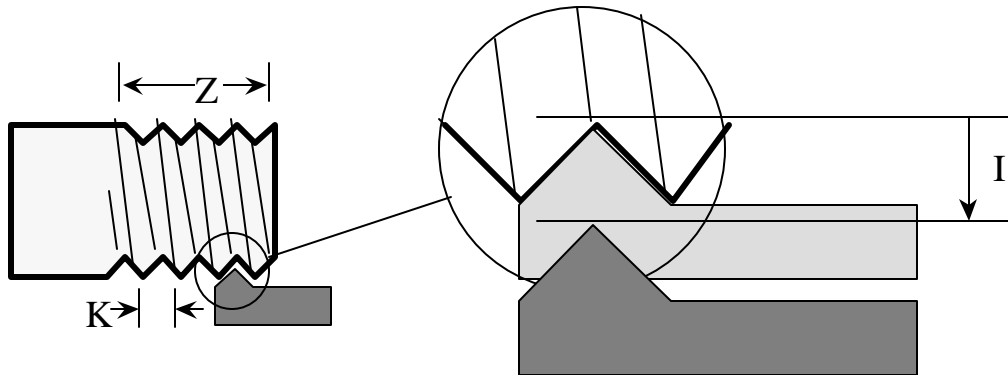


The format is: **G34ZnInKnAnP**

This cycle is used for course threading. It is single pass cycle only. G34 can thread down to .5 lead (2 pitch). The features of this cycle are the same as G33 except as noted below.



- Z** The Z axis location of the end of the thread
- I** The tool will retract in X incrementally, the sign (+/-) determines direction
- K** The lead of the thread, amount per revolution, 2 to 180 tpi
- A** used for tapered threading, it specifies the amount the X axis will move over the length of a tapered thread
- P** used when you want the tool to keep traveling forward while it pulls out of the work. This will leave no undercut

Notes:

Starting position in Z

The tool must be started at least .2" away from the start of the thread to allow the slide to get up to speed before it makes contact with the material

Starting position in X

The tool should be positioned at the depth of pass wanted

Depth of each pass:

This cycle is only a single pass. If you want to use it for multiple passes you have to position the tool each time at the depth you want.

Retraction position

The tool will back away from the starting position the amount of I. The direction of the pull out will be determined by the sign of I. When doing this single pass thread cycle be sure to have a large enough value for I to enable the tool to clear the part.

Pullout position in Z when using P option:

The tool will start to pull out at the location given in Z. It will travel beyond Z the same amount as it has to travel in X to reach the retraction position.

End of cycle position:

At the end of the threading cycle the tool will return to the starting point.

NOTE: This single pass threading cycle can not be used for a cleanup pass of a thread cut with the G33 cycle.

G34 Threading - special single pass course pitch