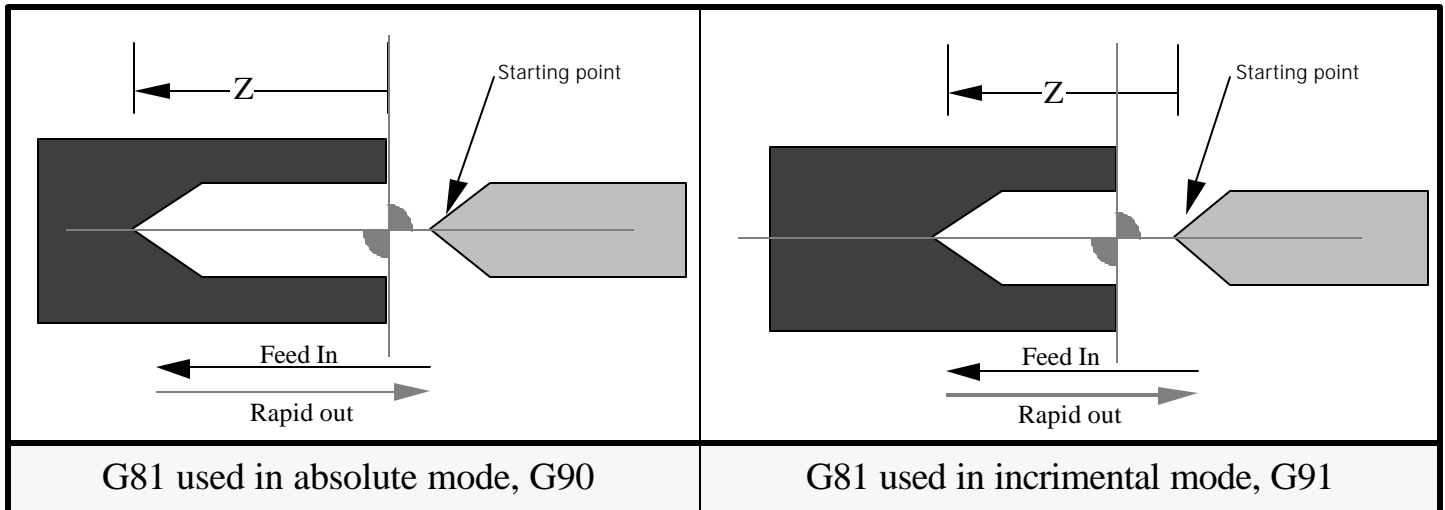


G81 Drill Cycle

G81 is a one shot command. It is used to feed to a drill a specific distance in Z and then rapid back to the starting point. The format is:

G81 Zn Fn

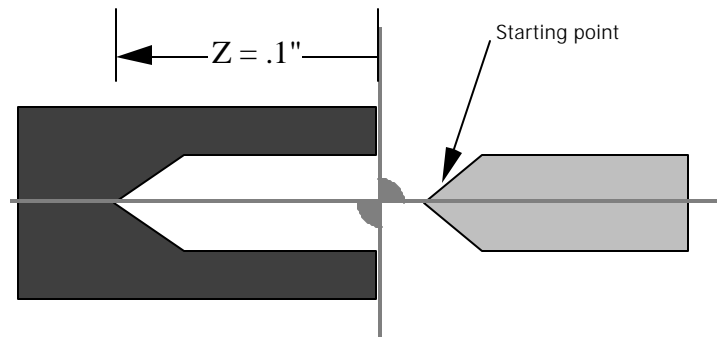


In G90, absolute mode: **Z** specifies the end of the hole from absolute Zero.

In G91, incremental mode: **Z** specifies the distance the tool will travel from the starting point .

F is the drilling feedrate in inches per rev or minute depending on if you are in G94 or G95.

G81 Example



To drill a part .1" deep at a feed of .005" per revolution. The program would be:

G90 G94F300	Puts the control into absolute mode
T1	Calls tool #1 offset
X0Z.01	positions tool at x=0, Z=.01
G95	Sets ipr mode
G81Z-.1F.005	Drills the hole .1" deep at .005 ipr.