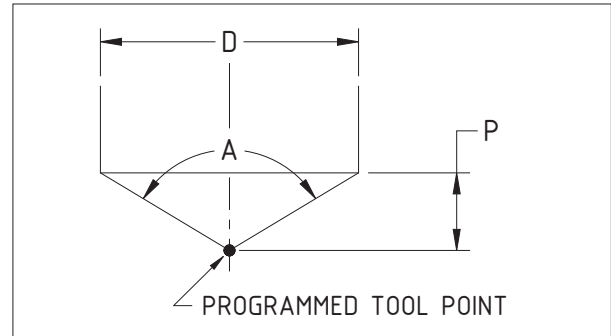
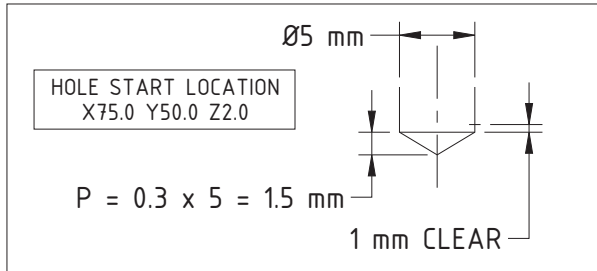


Web Drilling

To make the program more efficient, change the R-level, Z-depth and G98/G99 preparatory commands at each hole location. In the program, the following clearances have been used:



Tool (drill) point data:

- D = Drill diameter or Effective drill diameter
- A = Included drill point angle
- P = Tool point length (drill point length)

Even the presented solution is not as efficient as might be desired, due to the automatic return of the tool in the fixed cycle. The new program still contains some inefficient motions, but is a significant improvement over the original version.

(26-06 - WEB DRILLING)
(T01 - 5 MM DIA DRILL)

```

N1 G21
N2 G17 G40 G80
N3 G90 G00 G54 X75.0 Y50.0 S1200 M03
N4 G43 Z20.0 H01 M08
N5 G99 G81 R2.0 Z-6.5 F175.0 (TOP PLATE)
N6 R-23.0 Z-33.0 (MIDDLE PLATE)
N7 G98 R-57.5 Z-69.0 (BOTTOM PLATE)
N8 G80 G00 Z20.0 M09
N9 G28 Z20.0 M05
N10 G28 X75.0 Y50.0
N11 M30
%
```

