

(G70-G71 LATHE CYCLES - 10T.NC)  
(PETER SMID - CNC PROGRAMMING HANDBOOK)  
(FANUC 10/11/15T VERSION)

(T01 - FACE AND ROUGH OD - 85 DEG TOOL)

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N1 G20 G40 T0100 G50 S2000
N2 G96 S400 M03
N3 G00 G41 X4.2 Z0 T0101 M08
N4 G01 X-0.07 F0.006
N5 G00 Z0.1
N6 G42 X3.8
N7 G71 P8 Q16 U0.05 W0.003 D1250 F0.01
N8 G00 X1.2
N9 G01 X1.5 Z-0.05 F0.004
N10 Z-0.875 F0.008
N11 X2.0 Z-2.375
N12 Z-3.375
N13 G02 X3.0 Z-3.875 R0.5
N14 G01 X3.65
N15 X3.95 Z-4.025 F0.005
N16 U0.2 F0.02
N17 G00 G40 X5.0 Z4.0 T0100
N18 M01
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(T03 - FINISH OD - 55 DEG TOOL)

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N19 G50 S2000 T0300
N20 G96 S500 M03
N21 G00 G42 X4.2 Z0.1 T0303 M08
N22 G70 P8 Q16
N23 G00 G40 X5.0 Z4.0 T0300 M09
N24 M30
%
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(G70-G71 LATHE CYCLES - 0T.NC)  
(PETER SMID - CNC PROGRAMMING HANDBOOK)  
(FANUC 0T/16/18T/21T VERSION)

(T01 - FACE AND ROUGH OD - 85 DEG TOOL)

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N1 G20 G40 T0100 G50 S2000
N2 G96 S400 M03
N3 G00 G41 X4.2 Z0 T0101 M08
N4 G01 X-0.07 F0.006
N5 G00 Z0.1
N6 G42 X3.8
N7 G71 U0.125 R0.04
N8 G71 P9 Q17 U0.05 W0.003 F0.01
N9 G00 X1.2
N10 G01 X1.5 Z-0.05 F0.004
N11 Z-0.875 F0.008
N12 X2.0 Z-2.375
N13 Z-3.375
N14 G02 X3.0 Z-3.875 R0.5
N15 G01 X3.65
N16 X3.95 Z-4.025 F0.005
N17 U0.2 F0.02
N18 G00 G40 X5.0 Z4.0 T0100
N19 M01
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(T03 - FINISH OD - 55 DEG TOOL)
N20 G50 S2000 T0300
N21 G96 S500 M03
N22 G00 G42 X4.2 Z0.1 T0303 M08
N23 G70 P9 Q17
N24 G00 G40 X5.0 Z4.0 T0300 M09
N25 M30
%
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