FANUC Rigid Tapping Example

G0 G40 G80 G90 —— Safety Block
T1 M6 —— Tool Change
G54 G0 X10. Y10. M3 S400 —— First Positioning, Turn Spindle On is needed
G43 H1 Z1. —— Go to Clearance Height
M8 —— Coolant On
S400 M29 —— Rigid Taping On
X? Y? —— New Position
X? Y? —— New Position
X? Y? —— New Position
G0 G80 Z1. —— Canned Cycle Over
M5 —— Spindle Off
M9 —— Coolant Off
G91 G28 G0 Z0 —— Spindle Go Home
M30 —— Program End

FANUC Rigid Peck Tapping Example (option 1)*

G0 G40 G80 G90 —— Safety Block
T1 M6 —— Tool Change
G54 G0 X10. Y10. M3 S400 —— First Positioning, Turn Spindle On is needed
G43 H1 Z1. —— Go to Clearance Height
M8 —— Coolant On
S400 M29 —— Rigid Taping On
X? Y? —— New Position
X? Y? —— New Position
X? Y? —— New Position
G0 G80 Z1. —— Canned Cycle Over
M5 —— Spindle Off
M9 —— Coolant Off
G91 G28 G0 Z0 —— Spindle Go Home
M30 —— Program End

*Option 1 for rigid peck tapping is only usable if the correct Fanuc parameter bit is valid. Contact our applications department for more information.
FANUC Rigid Peck Tapping Example (option 2)

G0 G40 G80 G90 ——— Safety Block
T1 M6 ——— Tool Change
G54 G0 X10. Y10. M3 S400 ——— First Positioning, Turn Spindle On is needed
G43 H1 Z1. ——— Go to Clearance Height
M8 ——— Coolant On
S400 M29 ——— Rigid Taping On
  
  Z-.5 ——— New Depth
  Z-.75 ——— New Depth
  Z-1. ——— New Depth

G0 G80 Z1. ——— Canned Cycle Over
M5 ——— Spindle Off
M9 ——— Coolant Off
G91 G28 G0 Z0 ——— Spindle Go Home
M30 ——— Program End