



Rigid Tapping – Hyundai-Kia SKT LMS Lathe Series

Application Notes:

General Format for Rigid Tapping:

N... G98(G99) G84 X(U)... C(H)... Z(W)... R... P... F... (M...) (K...)

G98(G99).. Reference starting position

X(U)..... Hole position absolute or incremental in the X-axis

Z(W) Drilling depth absolute or incremental in the Z-axis

C[°] Drilling position

R [mm] Incremental value of withdrawal amount, with reference to the starting position in the Z-axis, signed value

P [msec] dwell time at the hole bottom: P1000 = 1 sec

F feed

M90 M-code for C-axis clamping

(K) number of the cycle repetitions (to be used only for incremental programming)

G54 G98 G40

G28 U0.W0. (X Z GO HOME)

G0T1111 (TOOL CALL WITH OFFSET)

M05 (MAIN SPINDLE OFF)

G0 XXX ZXX (POSITION)

G97G18 (ZX PLANE)

M43 (TURN C-AXIS ON)

M111 (LIVE TOOL SELECT)

M?? <------(IN THIS LINE, M13 OR M14)

M126 (LIVE TOOL RIGID TAP)

M129S???? (FANUC RIGID TAP)

M90 (SPINDLE BRAKE)

G84 Z??? R??? F??? M90

G80 (END CANNED CYCLE)

M91 TURN OFF SPINDLE BREAK)

M15 (MILL SPINDLE OFF)

M110 (DESELECT LIVE TOOL)

M128 (FANUC RIGID TAP)

M127 (CANCEL RIGID TAP LIVE TOOL)

M40 (TURN OFF C-AXIS)

G28U0.W0. (GO HOME)

T1100. (NULL TOOL CALL)

M13 DIRECTS RIGHT HAND, AND M14 DIRECTS LEFT HAND.