COMPUMACHINE

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# RIGID TAPPING with FADAL CNC

## FORMAT 1

N1 M6T1 **(4-40 TAP)**
**N2 G0 G80 G90 S1500.2 M5** (SELECT CORRECT SPINDLE RANGE)
( DO NOT TURN THE SPINDLE ON!)
**N3 G0 E1 X1. Y1.** (RAPID TO FIRST HOLE LOCATION.)
**N4 H1 Z.4 M8** (RAPID TO .4 ABOVE PART AND TURN ON COOLANT)
**N5 G84.1 G98 X1. Y1. Z-.5 R.4 Q.025 F1500** (RIGID TAP CYCLE, SEE VARIABLES BELOW)
**N6 X2. Y2.** (NEXT HOLE)
**N7 G80** (CANCEL RIGID TAP)

X1. Y1. = FIRST HOLE LOCATION
Z-.5 = FINAL Z DEPTH
R.4 = RETURN TO .4 ABOVE PART
Q.025 = THREAD LEAD (1/ THREADS PER INCH, 1/40=.025)
F1500.2 = SPINDLE SPEED IN HIGH RANGE

## FORMAT 2

N1 M6T1 **(4-40 TAP)**
**N2 G0 G80 G90 S1500.2 M5** (SELECT CORRECT SPINDLE RANGE)
(DO NOT TURN THE SPINDLE ON!)
**N3 G0 E1 X1. Y1.** (RAPID TO FIRST HOLE LOCATION.)
**N4 H1 Z.4 M8** (RAPID TO .4 ABOVE PART AND TURN ON COOLANT)
**N5 G84.1 G98 X1. Y1. Z-.5 R.4 S1500 F37.5** (RIGID TAP CYCLE, SEE VARIABLES BELOW)
**N6 X2. Y2.** (NEXT HOLE)
**N7 G80** (CANCEL RIGID TAP)

X1. Y1. = FIRST HOLE LOCATION
Z-.5 = FINAL Z DEPTH
R.4 = RETURN TO .4 ABOVE PART
S1500.2= SPINDLE SPEED IN HIGH RANGE
F37.5 = FEED RATE ((1/TPI )*SPINDLE SPEED)
G98= RETURN TO INITIAL PLANE

*********NOTE********

SPINDLE SPEED IN LINE # 2 NEEDS HIGH/ LOW RANGE CODE AFTER SPINDLE SPEED.
1-749 RPM = .1 (LOW RANGE) EXAMPLE S500.1
750- 3000 RPM = .2 ( HIGH RANGE) EXAMPLE S2000.2