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will rapid to the R plane, drill to the Z  
depth and return to the starting height  
of Z+1.00 when the cycle is finished.  
example: G98 G81 X## Y## Z-.875  
R.100 F## G99 = Retract the tool to  
the R plane when the drilling cycle is

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**MTT - CNC Machine Repair &**

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**Used Machine Tools & Engineering  
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