

Hole Events (Face and Side)

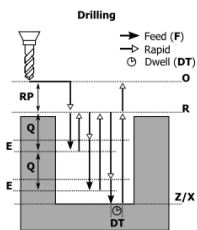
DynaPath WinDelta CNC Lathe · Conversational Programming Quick Guide

Hole events drill, tap or bore along Z into the **end face** (G83-G85) or along X into the **side** of the part (G87-G89). CM clamps the C-axis on machines that have one. [15.6]

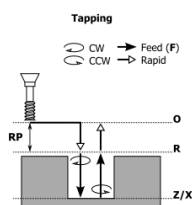
Event	Axis	Parameters
Face drill G83	Z	T · S · F · Z end · Q peck · E escape per peck · RP start · DT dwell · CL · DS · CM
Face tap G84	Z	T · P pitch · S · Z end · Q peck · RP start · CL · CM · TT rigid / normal
Face bore G85	Z	T · S · F · Z end · RP start · DT dwell · CL · DS · CM
Side drill G87	X	T · S · F · X end · Q peck · E escape per peck · RP start · DT dwell · CL · DS · CM
Side tap G88	X	T · P pitch · S · X end · Q peck · RP start · CL · CM · TT rigid / normal
Side bore G89	X	T · S · F · X end · RP start · DT dwell · CL · DS · CM

Parameter meanings

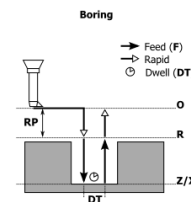
Code	Meaning	Code	Meaning
T	Tool	S	Spindle RPM
F	Feed (per min)	Z / X	End position
RP	Start position	Q	Peck increment
E	Escape (retract) each peck	DT	Dwell at the bottom (s)
P	Tap pitch	TT	Tapping: rigid or normal
CL	Coolant on / off	DS	Spindle direction CW / CCW
CM	Clamp the C-axis on / off		



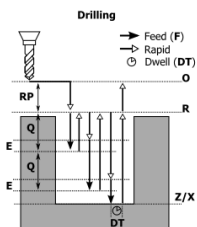
Face drilling G83



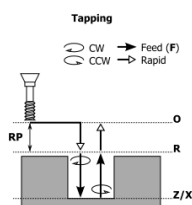
Face tapping G84



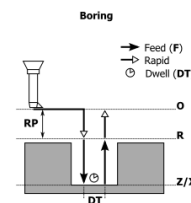
Face bore G85



Side drilling G87



Side tapping G88



Side bore G89