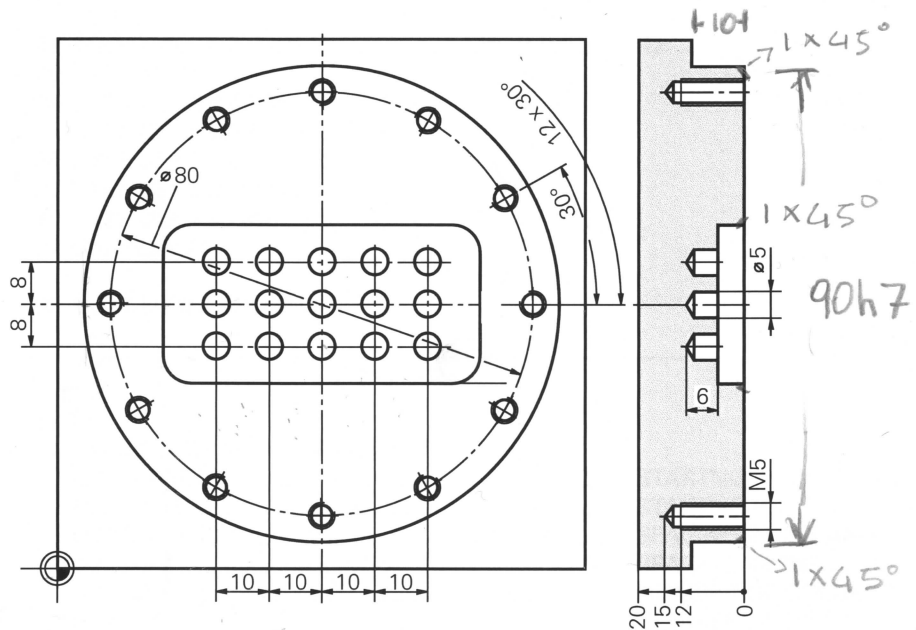




Main program

```

0 BEGIN PGM 266 MM
1 BLK FORM 0.1 Z X+0 Y+0 Z-20
2 BLK FORM 0.2 X+100 Y+100 Z+0
3 CALL PGM 26501 ..... HELP PROGRAM
4 TOOL CALL 5 Z S2000 ..... R2,5
5 L Z+100 M3
6 CYCL DEF 200 DRILLING
  Q200=2 ..... SET UP CLEARANCE
  Q201=-6 ..... DEPTH
  Q206=200 ..... FEED RATE FOR PLUNGING
  Q202=6 ..... PLUNGING DEPTH
  Q210=0 ..... DWELL TIME AT TOP
  Q203=-5 ..... SURFACE COORDINATE
  Q204=20 ..... 2ND SET UP CLEARANCE
7 CALL LBL 1
8 L Z+100 R0 F9999 M6

9 TOOL CALL 4 Z S2000 ..... R2
10 L Z+100 M3
11 CYCL DEF 1.0 PECKING
12 CYCL DEF 1.1 SET UP 2
13 CYCL DEF 1.2 DEPTH -2,8
14 CYCL DEF 1.3 PECKG 2,8
15 CYCL DEF 1.4 DWELL 0
16 CYCL DEF 1.5 F200
17 CALL LBL 2
18 L Z+100 M6

19 TOOL CALL 5 Z S1500 ..... R2,5
20 L Z+100 M3
21 CYCL DEF 200 DRILLING
  Q200=2 ..... SET UP CLEARANCE
  Q201=-15 ..... DEPTH
  Q206=200 ..... FEED RATE FOR PLUNGING
  Q202=8 ..... PLUNGING DEPTH
  Q210=0 ..... DWELL TIME AT TOP
  Q203=+0 ..... SURFACE COORDINATE
  Q204=20 ..... 2ND SET UP CLEARANCE
22 CALL LBL 2
23 L Z+100 M6

```

