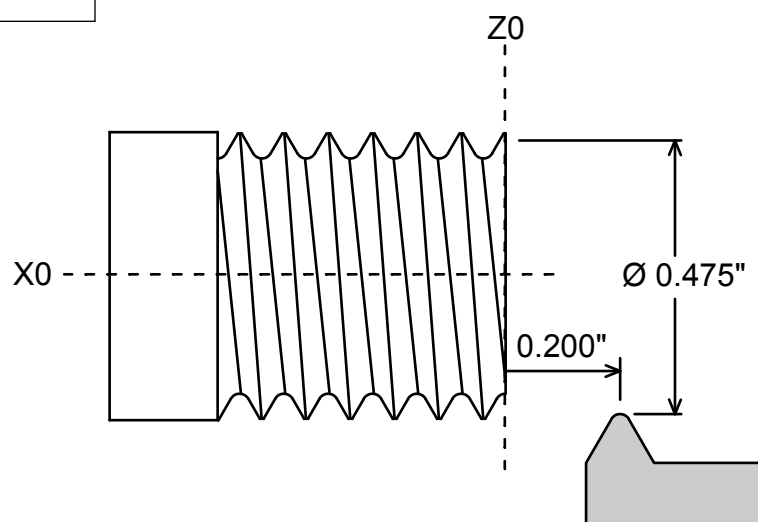
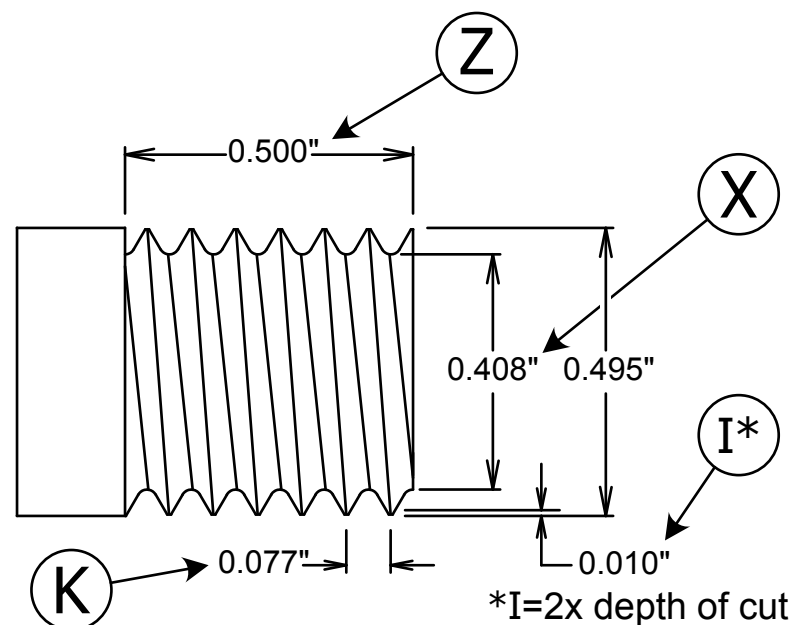


## G33 Example: 1/2-13 thread (G33XnZnInKnAnCaPO)

**Xn:** Minor diameter of the thread  
**Zn:** Z location of end of the thread  
**In:** 2x depth of cut ( $\emptyset$  mode) 1st pass  
**Kn:** The lead of the thread  
**An:** Tapered thread; X increment  
**Cn:** Infeed angle (29° default)  
**P:** Pull out while threading  
**O:** Single pass at finish depth



### Code Fragment

```

:
:
T4 (threading tool)
x0z.2
x.475
g33x.408z-.5i.02k.077p
:
:

```