

Example on programming instructions for Grippex

FANUC

```
:0001  
G0 T1212 M5  
X0. Z30.  
G1 G98 Z-80. F3000  
M8  
G4 U1.  
M69  
G4 U0.1  
G1 Z-1.  
M68  
M9  
G0 G99 Z...  
X...  
M99  
%
```

SUB Program

```
Coolant ON, Grippex clamp  
Dwell  
Chuck unclamp  
Dwell  
Pulling-out the bar to a specific z-extent  
Chuck clamp  
Coolant OFF, Grippex unclamp  
Leave the bar
```

OKUMA

```
.  
.  
G0 X0 Z55 T090909  
G0 Z-2  
M08  
G04 F2  
G0 M84  
G04 F2  
G0 Z.....  
M83  
M09  
G04 F03  
G0 Z.....  
X..... Z.....  
.  
.
```

SUB Program

```
Change to Grippex (example)  
Approach bar to be pulled  
Coolant ON, Grippex clamp  
Dwell  
Chuck unclamp  
Dwell  
Pulling-out the bar to a specific z-extent  
Chuck clamp  
Coolant OFF, Grippex unclamp  
Dwell  
Leave the bar  
Return to Zero and calling a new tool
```