

G00 = RAPID
G01= LINEAR FEED
G02= CLOCKWISE CIRCULAR
G03= COUNTER CLOCKWISE CIRCULAR
G90= ABSOLUTE
G91= INCREMENTAL
G80= CANCEL CANNED CYCLES
G43= Z OFFSET COORDINATES FROM ZERO
G49= CANCEL Z OFFSET
G54-G59= WORK COORDINATE OFFSETS
G40= CANCEL CUTTER COMPENSATION
G41= CUTTER COMP LEFT
G42= CUTTER COMPENSATION RIGHT
G81= DRILL CYCLE COMMON R FOR RAPID TO GAGE HEIGHT
G82= DRILL CYCLE WITH DWELL, COMMON R FOR RAPID TO GAGE HEIGHT,
P WORD FOR AMOUNT OF DWELL TIME AT THE BOTTOM OF THE
HOLE
G83= DRILL CYCLE WITH PECK MOTION, DEEP HOLE DRILLING AND CHIP
BREAKER, COMMON R FOR RAPID TO GAGE HEIGHT, Q WORD IS THE
INCREMENTAL PECKING MOTION ON Z AXIS
G84= TAP CYCLE
G92= ABSOLUTE COMMAND THAT CAN BE USED AT ANY TIME TO CHANGE
THE PART ZERO POINT WITH NO REGARD TO THE WORK
COORDINATE OFFSETS
M00= OPTIONAL STOP
M02= STOPS ALL SLIDES, ENDS A PROGRAM BUT DOES NOT REWIND
MEMORY
M30= STOPS ALL SLIDES, REWINDS MEMORY AND ENDS A PROGRAM
M03= STARTS SPINDLE CLOCKWISE
M04= STARTS SPINDLE COUNTER CLOCKWISE
M05= TURNS SPINDLE OFF
M06= TOOL CHANGE
M08= TURNS ON COOLANT
M09= TURNS OFF COOLANT
M98= GOTO SUBROUTINE USED WITH A P WORD AS THE ADDRESS TO
BRANCH TOO
M99= RETURN TO M98, SHOULD BE AT THE END OF THE SUBROUTINE
PROGRAM
G17= XY PLANE
G18=XZ PLANE
G19=YZ PLANE