

Basic G-codes

(G-Codes vary from machine to machine)

G00 RAPID POSITIONING MOTION (X,Z,U,W,B) (SETTING 10, 104)
G01 LINEAR INTERPOLATION MOTION (X,Z,U,W,B,F)
G01 CHAMFERING AND CORNER ROUNDING (X,Z,U,W,B,I,K,R,A,F)
G02 CW CIRCULAR INTERPOLATION MOTION (X,Z,U,W,I,K,R,F)
G03 CCW CIRCULAR INTERPOLATION MOTION (X,Z,U,W,I,K,R,F)
G04 DWELL (P) (P=seconds, milliseconds)
G05 FINE SPINDLE CONTROL MOTION (X,Z,U,W,R,F) (LIVE TOOLING)
G09 EXACT STOP, NON-MODAL
G10 PROGRAMMABLE OFFSET SETTING (X,Z,U,W,I,L,P,Q,R)
G14 MAIN-SPINDLE SHIFT TO SUB-SPINDLE
G15 MAIN-SPINDLE SHIFT TO SUB-SPINDLE CANCEL
G17 CIRCULAR MOTION XY PLANE SELECTION (G02-G03) (LIVE TOOLING)
G18 CIRCULAR MOTION ZX PLANE SELECTION (G02-G03) (SETTING 56)
G19 CIRCULAR MOTION YZ PLANE SELECTION (G02-G03) (LIVE TOOLING)
G20 VERIFY INCH COORDINATE POSITIONING (SETTING 9 needs to be INCH)
G21 VERIFY METRIC COORDINATE POSITIONING (SETTING 9 needs to be METRIC)
G22 SPINDLE STOP, LEFT-THREADED, FIRST (X,Z,U,W,I,L,P,Q,R)
G23 SPINDLE STOP, RIGHT-THREADED, FIRST (X,Z,U,W,I,L,P,Q,R)
G24 SPINDLE STOP, LEFT-THREADED, SECOND (X,Z,U,W,I,L,P,Q,R)
G25 SPINDLE STOP, RIGHT-THREADED, SECOND (X,Z,U,W,I,L,P,Q,R)
G40 TOOL NOSE COMPENSATION CANCEL (G41/G42 (X,Z,U,W,I,K,R) (SETTING 54)
G41 TOOL NOSE COMPENSATION, LEFT (X,Z,U,W) (SETTING 43, 44, 58)
G42 TOOL NOSE COMPENSATION, RIGHT (X,Z,U,W) (SETTING 43, 44, 58)
G50 SPINDLE SPEED MAXIMUM RPM LIMIT (S)
G51 RETURN TO MACHINE ZERO, CANCEL OFFSET (Yasnac)
G52 WORK OFFSET COORDINATE POSITIONING (Yasnac)
G52 GLOBAL WORK COORDINATE SYSTEM SHIFT (Fanuc)
G53 MACHINE COORDINATE POSITIONING, NON-MODAL (X,Z,B)
G54 WORK OFFSET COORDINATE POSITIONING #1 (SETTING 50)
G55 WORK OFFSET COORDINATE POSITIONING #2
G56 WORK OFFSET COORDINATE POSITIONING #3
G57 WORK OFFSET COORDINATE POSITIONING #4

G154 REV
G157 ACB
(SETTING
G154 SUB
G155 LIVE
G156 LIVE
G200 INDI

Basic M-c
M00 PROG
M01 OPTI
M02 END

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M04 SPIN
M05 SPIN
M06 COO
M08 COO
M10 CHU
M11 CHU
M12 UT
M13 UT
M14 MAP
M15 MAP
M17 ROT
M18 ROT
M19 ORG
M21 TAIL
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