

HAAS C.N.C. LATHE PREPARATORY FUNCTIONS

MODAL
NON-MODAL
DEFAULT *
OPTION**

G00*	RAPID POSITIONING MOTION (X,Y,Z,U,W,V) (SETTING: 10, 10%)	G70	REGULAR PATH STOCK REMOVAL CYCLE (P,Q,U,W,K,D,S,T,F) (SETTING: 10, 10)
G01	LINEAR INTERPOLATION MOTION (X,Y,Z,U,W,V) (SETTING: 10, 10%)	G71	FACE GROOVING - HIGH SPEED/PECK DRILL CYCLE (X,Y,Z,U,W,K,D,F) (SETTING: 10, 10)
G02	CHAMFERING AND CORNER ROUNDOFF (X,Y,Z,U,W,K,D,F) (SETTING: 10, 10%)	G72	O.D. I.D. PECK GROOVING CYCLE (X,Y,Z,U,W,K,D,F) (SETTING: 10, 10)
G03	CW CIRCULAR INTERPOLATION MOTION (X,Y,Z,U,W,K,D,F) (SETTING: 10, 10%)	G73	THREAD CUTTING CYCLE, MULTIPLE PASS (X,Y,Z,U,W,K,D,F) (SETTING: 10, 10, 10, 10)
G04	CCW CIRCULAR INTERPOLATION MOTION (X,Y,Z,U,W,K,D,F) (SETTING: 10, 10%)	G74	PLATTING CYCLE (X,Y,Z,U,W,K,D,F) (SETTING: 10, 10)
G05	DWELL (P) (P=seconds) (P=milliseconds)	G75	CANCEL CANNED CYCLE (SETTING: 10)
G06*	PIVOT SPINDLE CONTROL MOTION (X,Y,Z,U,W,V) (LIVE TOOLING)	G76	DRILL CANNED CYCLE (X,Y,Z,U,W,V) (SETTING: 10, 10)
G07	EXACT STOP NON-MODAL	G77	SPOT DRILL / COUNTERSINK CANNED CYCLE (X,Y,Z,U,W,V) (SETTING: 10, 10)
G08	PROGRAMMABLE OFFSET SETTING (X,Y,Z,U,W,V) (SETTING: 10, 10)	G78	PECK DRILLING CANNED CYCLE (X,Y,Z,U,W,K,D,F) (SETTING: 10, 10)
G09*	MAIN SPINDLE SHIFT TO SUB-SPINDLE	G79	TAPPING CANNED CYCLE (X,Y,Z,U,W,V) (SETTING: 10, 10)
G10**	MAIN SPINDLE SHIFT TO SUB-SPINDLE CANCEL	G80	BORE IN, BORE OUT CANNED CYCLE (X,Y,Z,U,W,K,D,F) (SETTING: 10, 10)
G11**	CIRCULAR MOTION RY PLANE SELECTION (G02-G03) (LIVE TOOLING)	G81	BORE IN, STOP, RAPID OUT CANNED CYCLE (X,Y,Z,U,W,K,D,F) (SETTING: 10, 10)
G12**	CIRCULAR MOTION ZX PLANE SELECTION (G02-G03) (LIVE TOOLING)	G82	BORE IN, STOP, MANUAL RETRACT CANNED CYCLE (X,Y,Z,U,W,K,D,F) (SETTING: 10, 10)
G13**	CIRCULAR MOTION YZ PLANE SELECTION (G02-G03) (LIVE TOOLING)	G83	BORE IN, DWELL, MANUAL RETRACT CANNED CYCLE (X,Y,Z,U,W,K,D,F) (SETTING: 10, 10)
G14**	VERIFY X-AXIS COORDINATE POSITIONING (SETTING: 0 needs to be ON)	G84	BORE IN, DWELL, BORE OUT CANNED CYCLE (X,Y,Z,U,W,K,D,F) (SETTING: 10, 10)
G15	VERIFY Y-AXIS COORDINATE POSITIONING (SETTING: 0 needs to be ON)	G85	O.D. I.D. TURNING CYCLE, MODAL (X,Y,Z,U,W,V) (SETTING: 10, 10)
G16	MACHINE ZERO RETURN THRU REF. POINT (X,Y,Z) (P=mm)	G86	THREADING CYCLE, MODAL (X,Y,Z,U,W,V) (SETTING: 10, 10)
G17	BORE TO LOCATION THRU REF. POINT (X,Y,Z) (P=mm)	G87	END FACE LIVE TOOLING RISED TAP (X,Y,Z,U,W,V) (SETTING: 10, 10)
G18**	FEED-UNITS, SWP FUNCTION (X,Y,Z,U,W,V) (SETTING: 10, 10)	G88	CONSTANT SURFACE SPEED, CSM ON (X) (SETTING: 10, 10)
G19	THREAD CUTTING PATH, MODAL (X,Y,Z,U,W,V) (SETTING: 10, 10)	G89	CONSTANT SURFACE SPEED, CSM OFF (X) (SETTING: 10, 10)
G40*	TOOL NOSE COMPENSATION CANCEL (G41-G42) (X,Y,Z,U,W,V) (SETTING: 10, 10)	G90	FEED PER MINUTE (F) (SETTING: 10, 10)
G41	TOOL NOSE COMPENSATION, LEFT (X,Y,Z,U,W,V) (SETTING: 10, 10)	G91	FEED PER REVOLUTION (F) (SETTING: 10, 10)
G42	TOOL NOSE COMPENSATION, RIGHT (X,Y,Z,U,W,V) (SETTING: 10, 10)	G92	MIRROR IMAGE CANCEL, G93
G93	SPINDLE SPEED MAXIMUM RPM LIMIT (S) (SETTING: 10, 10)	G93	MIRROR IMAGE (X,Y,Z) (SETTING: 10, 10)
G94	RETURN TO MACHINE ZERO, CANCEL OFFSET (P=mm)	G94	PROGRAMMABLE OUTPUT TO RS-232 (X,Y,Z) (SETTING: 10, 10)
G95	WORK-OFFSET COORDINATE POSITIONING (P=mm)	G95	LIMIT BLOCK LOOKAHEAD (P=0-999,999, for number control look ahead)
G96	GLOBAL WORK COORDINATE SYSTEM SHIFT (P=mm)	G96	SERVO-BAK COMMAND
G97	MACHINE COORDINATE POSITIONING, NON-MODAL (X,Y,Z) (SETTING: 10, 10)	G110-G111	WORK-OFFSET COORDINATE POSITIONING #1-#2
G98	WORK-OFFSET COORDINATE POSITIONING #1 (SETTING: 10)	G112	CARTESIAN TO POLAR TRANSFORMATION
G99	WORK-OFFSET COORDINATE POSITIONING #2 (SETTING: 10)	G113	CARTESIAN TO POLAR TRANSFORMATION CANCEL
G100	WORK-OFFSET COORDINATE POSITIONING #3 (SETTING: 10)	G114-G115	WORK-OFFSET COORDINATE POSITIONING #3-#4
G101	WORK-OFFSET COORDINATE POSITIONING #4 (SETTING: 10)	G116	BACKGROUND-PECK/UP PART RETURN
G102	WORK-OFFSET COORDINATE POSITIONING #5 (SETTING: 10)	G117	APL, AXIS COMMAND MODE ON
G103	EXACT STOP, MODAL (X,Y,Z) (SETTING: 10)	G118	APL, AXIS COMMAND MODE OFF
G104	EXACT STOP G41 CANCEL (SETTING: 10)	G119	REVERSE TAPPING CANNED CYCLE (X,Y,Z,U,W,V) (SETTING: 10, 10)
G105	MACRO SUBROUTINE CALL	G120	ACCURACY CONTROL FOR HIGH SPEED MACHINING (S) (SETTING: 10)
G106	FINISHING CYCLE (P,Q) (SETTING: 10, 10)	G121	SUB-SPINDLE TAPPING CANNED CYCLE (X,Y,Z,U,W,V) (SETTING: 10, 10)
G107	O.D. I.D. STOCK REMOVAL CYCLE (P,Q,U,W,K,D,S,T,F) (SETTING: 10, 10)	G122	LIVE TOOLING VECTOR TAPPING (X,Y,Z) (SETTING: 10, 10)
G108	END FACE STOCK REMOVAL CYCLE (P,Q,U,W,K,D,S,T,F) (SETTING: 10, 10)	G123	LIVE TOOLING VECTOR TAPPING REVERSE (X,Y,Z) (SETTING: 10, 10)
G109		G124	INDEX ON THE FLY (X,Y,Z,U,W,V) (SETTING: 10, 10)

Note: These G and M codes are useful reference information, on a desk, or at the machine. They're great to have laminated with G codes on one side and M codes on the other. As a suggestion; get some white 90lb. cardstock and print G-codes on one side and M-codes on the other. Cut out the square section and go to Kinko's copies or local printer to get them laminated.

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web metal ferrous metal astm steel carbon steel low carbon steel material notes commercial quality zinc coated galvanized steel vendors available properties density typical of astm steel coating weight single spot test both sides alloyed coating a 25 coating weight single spot test both sides regular coating g 30

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web oct 15 1993 astm a525 1993 edition october 15 1993 standard specification for general requirements for steel sheet zinc coated galvanized by the hot dip process this specification covers the general requirements for the delivery of steel sheet in coils and cut lengths zinc coated galvanized on continuous lines by the hot dip process

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web a255 20a standard test methods for determining hardenability of steel a434 a434m 18 standard specification for steel bars alloy hot wrought or cold finished quenched and tempered a689 97 2018 standard specification for carbon and alloy steel bars for springs a125 96 2018 standard specification for steel springs helical heat treated

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web astm a525 galvanized steel categories metal ferrous metal astm steel carbon steel low carbon steel material notes commercial quality zinc coated galvanized steel vendors no vendors are listed for this material

astm b525 specification for sintered austenitic stainless steel - Apr 04 2022

web mil std 2073 1 standard practice for military packaging 48cfr ch1 52 99 federal acquisition regulations system astm d3935 standard classification system and basis for specification for polycarbonate pc unfilled and reinforced material document number astm b525 83a revision level 1983a edition status superseded