

SUPPORTED G CODES

G0	RAPID POSITIONING
G1	LINEAR INTERPOLATION
G2	CLOCKWISE CIRCULAR/HELICAL INTERPOLATION
G3	COUNTERCLOCKWISE CIRCULAR/HELICAL INTERPOLATION
G4	DWELL
G10	COORDINATE SYSTEM ORIGIN SETTING
G12	CLOCKWISE CIRCULAR POCKET
G13	COUNTERCLOCKWISE CIRCULAR POCKET
G15/G16	POLAR COORDINATE MOVES IN G0 AND G1
G17	X, Y PLANE SELECT
G18	X, Z PLANE SELECT
G19	Y, Z PLANE SELECT
G20/G21	INCH / MILLIMETER UNITS
G28	RETURN HOME
G28.1	REFERENCE AXIS
G30	RETURN HOME
G31	STRAIGHT PROBE
G40	CANCEL CUTTER RADIUS COMPENSATION
G41/G42	START CUTTER RADIUS COMPENSATION LEFT / RIGHT
G43	APPLY TOOL LENGTH OFFSET (PLUS)
G49	CANCEL TOOL LENGTH OFFSET
G50	RESET ALL SCALE FACTORS TO 1.0
G51	SET AXIS DATA INPUT FACTORS
G52	TEMPORARY COORDINATE SYSTEM OFFSETS
G53	MOVE IN ABSOLUTE MACHINE COORDINATE SYSTEM
G54	USE FIXTURE OFFSET 1
G55	USE FIXTURE OFFSET 2
G56	USE FIXTURE OFFSET 3
G57	USE FIXTURE OFFSET 4
G58	USE FIXTURE OFFSET 5
G59	USE FIXTURE OFFSET 6
G61/G64	EXACT STOP / CONSTANT VELOCITY MODE
G73	CANNED CYCLE- PECK DRILLING
G80	CANNED MOTION CYCLE (INCLUDING CANNED CYCLES)
G81	CANNED CYCLE- DRILLING
G82	CANNED CYCLE-DRILLING WITH DWELL
G83	CANNED CYCLE- PECK DRILLING
G84	CANNED CYCLE-RIGHT HAND RIGID TAPPING
G85	CANNED CYCLE- BORING, NO DWELL, FEED OUT
G86	CANNED CYCLE- BORING, SPINDLE STOP, RAPID OUT
G88	CANNED CYCLE- BORING, SPINDLE STOP, MANUAL OUT
G89	CANNED CYCLE- BORING, DWELL, FEED OUT
G90	ABSOLUTE DISTANCE MODE
G91	INCREMENTAL DISTANCE MODE
G92	OFFSET COORDINATES AND SET PARAMETERS
G92.X	CANCEL G92 ETC.
G93	INVERSE TIME FEED MODE
G94	FEED PER MINUTE MODE
G95	FEED PER REVOLUTION MODE
G98	INITIAL LEVEL RETURN AFTER CANNED CYCLES
G99	R-POINT LEVEL RETURN AFTER CANNED CYCLES