

<i>Code</i>	<i>Usage</i>	<i>Description</i>	<i>Code</i>	<i>Usage</i>	<i>Description</i>
G00	G00	Rapid move	M08	M08	Coolant on
G01	G01Fn	Feed move	M09	M09	Coolant off
G02	G02XnZnInKnFn	Arc -Clockwise	M12	M12	Collet clamp
G02	G02XnZnRn	Arc -Clockwise	M13	M13	Collet unclamp
G03	G03XnZnInKnFn	Arc -Counter Clockwise	M19	M19	Spindle Positioning; lock at home (optional C-Axis only)
G03	G03XnZnRn	Arc -Counter Clockwise	M25	M25	User assigned on (Note: Four additional codes available)
G04	G04Fn	Dwell	M26	M26	User assigned off (Note: Four additional codes available)
G10	G10XnZn	Work Shift	M30	M30	End of program - cancels all active "M" functions
G33	G33XnZnInKnAnCaPO	Threading cycle	M31	M31	Cancels Cycle Repeat mode
G40	G40	Cancels Tool Nose Radius Compensation	M84	M84	Locks feedrate & spindle speed override pots at 100%
G41	G41	Left hand Tool Nose Radius Compensation	M85	M85	Re-enables override pots (M30, M02, T# also re-enables)
G42	G42	Right hand Tool Nose Radius Compensation	M87	M87	Real-time Work Shift from digital indicator
G70	G70	Inch mode	M88	M88	Spindle Positioning; lock at home; high res (opt: C-Axis only)
G71	G71	Metric mode	M89	M89	Spindle Positioning; lock at arbitrary home (opt: C-Axis only)
G72	G72	Diameter programming mode	M91	M91	Wait for HDR111 to be open circuit
G73	G73	Radius programming mode	M92	M92	Wait for HDR111 to be shorted
G74	G74XnZnInUnFn	Box Roughing cycle	M93	M93	Wait for HDR110 to be open circuit
G75	G75InUnFnPn	Box Contour Roughing cycle	M94	M94	Wait for HDR110 to be shorted
G76	G76Sn	Minimum spindle speed for constant surface feet	M95	M95	Jump to subroutine 1 if HDR112 is shorted
G77	G77Sn	Maximum spindle speed for constant surface feet	M97	M97InCnPn	Jump to subroutine, conditional (optional: PLC option)
G78	G78UnFnPn	Rough Contour Cycle	M98	M98Pn	Jump to subroutine
G81	G81ZnFn	Drill cycle	M99	M99	End subroutine
G83	G83ZnKnFn RnLnCn	Peck drill cycle	CI	CInnn.nn	Incremental spindle angle (optional: C-Axis only)
G90	G90	Absolute mode selection	CA	CAnnn.nn	Absolute spindle angle (optional: C--Axis only)
G91	G91	Incremental mode selection	C	XnZnCn	Automatic chamfer at intersection
G92	G92XnZn	Preset axis position	D	Dn	Secondary offsets, axis correction or TNR comp value
G94	G94Fn	Inches per minute mode	F	Fn	Feedrates, dwell
G95	G95Fn	Inches per revolution mode	LS	LSn	Loop start
G96	G96Sn	Spindle speed set as surface feet	LF	LF	Loop finish
G97	G97	Spindle speed set as RPM	P	P	Start any move in sync with spindle
M00	M00	Program stop - does not cancel active "M" functions	R	XnZnRn	Automatic radius at intersection
M01	M01	Optional stop	S	Sn	Spindle speed selection, SFM or RPM
M02	M02	End program - does not cancel active "M" functions	T	Tn	Tool offset call command
M03	M03Sn	Spindle on, forward (top coming)	/	/	Block delete
M04	M04Sn	Spindle on, reverse (top going)	}	}n	Begin subroutine
M05	M05	Spindle off, stop			