

G-Code Reference List

G Code	Function
G00	Positioning at rapid travel;
G01	Linear interpolation using a feed rate;
G02	Circular interpolation clockwise;
G03	Circular interpolation, counterclockwise;
G04	Dwell
G17	Select X-Y plane;
G18	Select Z-X plane;
G19	Select Z-Y plane;
G20	Imperial units;
G21	Metric units;
G27	Reference return check;
G28	Automatic return through reference point;
G29	Move to a location through reference point;
G31	Skip function;
G32	Thread cutting operation on a Lathe;
G33	Thread cutting operation on a Mill;
G40	Cancel cutter compensation;
G41	Cutter compensation left;
G42	Cutter compensation right;
G43	Tool length compensation;
G44	Tool length compensation;
G50	Set coordinate system (Mill);
G50	Maximum RPM (Lathe);
G52	Local coordinate system setting;
G53	Machine coordinate system setting;
G54	Set Datum;
G55	Set Datum;
G56	Set Datum;
G57	Set Datum;

G Code	Function
G58	Set Datum;
G59	Set Datum;
G70	Finish cycle (Lathe);
G71	Rough turning cycle (Lathe);
G72	Rough facing cycle (Lathe);
G73	Chip break drilling cycle;
G74	Left hand tapping (Mill);
G74	Face grooving cycle;
G75	OD groove pecking cycle (Lathe);
G76	Boring cycle (Mill);
G76	Screw cutting cycle (Lathe);
G80	Cancel cycles;
G81	Drill cycle;
G82	Drill cycle with dwell;
G83	Peck drilling cycle;
G84	Tapping cycle;
G85	Bore in, bore out;
G86	Bore in, rapid out;
G87	Back boring cycle;
G90	Absolute programming;
G91	Incremental programming;
G92	Reposition origin point (Mill);
G92	Screw thread cutting cycle (Lathe);
G94	Per minute feed;
G95	Per revolution feed;
G96	Constant surface speed (Lathe);
G97	Constant surface speed cancel;
G98	Feed per minute (Lathe);
G99	Feed per revolution (Lathe);

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Kelly Curran,Jon Stenerson

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Table of Contents G Code M Code Cnc Programming List Gujarati English

1. Understanding the eBook G Code M Code Cnc Programming List Gujarati English
 - The Rise of Digital Reading G Code M Code Cnc Programming List Gujarati English
 - Advantages of eBooks Over Traditional Books
2. Identifying G Code M Code Cnc Programming List Gujarati English
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an G Code M Code Cnc Programming List Gujarati English
 - User-Friendly Interface
4. Exploring eBook Recommendations from G Code M Code Cnc Programming List Gujarati English
 - Personalized Recommendations
 - G Code M Code Cnc Programming List Gujarati English User Reviews and Ratings
 - G Code M Code Cnc Programming List Gujarati English and Bestseller Lists
5. Accessing G Code M Code Cnc Programming List Gujarati English Free and Paid eBooks
 - G Code M Code Cnc Programming List Gujarati English Public Domain eBooks
 - G Code M Code Cnc Programming List Gujarati English eBook Subscription Services
 - G Code M Code Cnc Programming List Gujarati English Budget-Friendly Options

6. Navigating G Code M Code Cnc Programming List Gujarati English eBook Formats
 - ePub, PDF, MOBI, and More
 - G Code M Code Cnc Programming List Gujarati English Compatibility with Devices
 - G Code M Code Cnc Programming List Gujarati English Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of G Code M Code Cnc Programming List Gujarati English
 - Highlighting and Note-Taking G Code M Code Cnc Programming List Gujarati English
 - Interactive Elements G Code M Code Cnc Programming List Gujarati English
8. Staying Engaged with G Code M Code Cnc Programming List Gujarati English
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers G Code M Code Cnc Programming List Gujarati English
9. Balancing eBooks and Physical Books G Code M Code Cnc Programming List Gujarati English
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection G Code M Code Cnc Programming List Gujarati English
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine G Code M Code Cnc Programming List Gujarati English
 - Setting Reading Goals G Code M Code Cnc Programming List Gujarati English
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of G Code M Code Cnc Programming List Gujarati English
 - Fact-Checking eBook Content of G Code M Code Cnc Programming List Gujarati English
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements

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