

1.3 G Code List

Code	Group	Description	Modal	Page
G00	1	Rapid Move	Y	10
G01	1	Linear Feed Move	Y	10
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G18	2	ZX Plane Select	Y	20
G19	2	YZ Plane Select	Y	20
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G21	6	Millimeter	Y	20
G28	0	Zero Return	N	21
G30	0	2 nd , 3 rd , 4 th Zero Return	N	22
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G44	8	Tool Length Offset - Enable	Y	25
G49	8	Tool Length Offset Cancel	Y	25
G50	9	Cancel Scaling	Y	25
G51	9	Scale Axes	Y	25
G52	0	Local Coordinate System Shift	Y	26

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