

### 1.3 G Code List

Code	Group	Description	Modal	Page
G00	1	Rapid Move	Y	10
G01	1	Linear Feed Move	Y	10
G02	1	Clockwise Arc Feed Move	Y	11
G03	1	Counter Clockwise Arc Feed Move	Y	11
G04	0	Dwell	N	14
G09	0	Exact stop	N	14
G10	0	Fixture and Tool Offset Setting	N	15
G12	1	Clockwise Circle	Y	18
G13	1	Counter Clockwise Circle	Y	18
G15	11	Polar Coordinate Cancel	Y	18
G16	11	Polar Coordinate	Y	18
G17	2	XY Plane Select	Y	20
G18	2	ZX Plane Select	Y	20
G19	2	YZ Plane Select	Y	20
G20	6	Inch	Y	20
G21	6	Millimeter	Y	20
G28	0	Zero Return	N	21
G30	0	2 <sup>nd</sup> , 3 <sup>rd</sup> , 4 <sup>th</sup> Zero Return	N	22
G31	1	Probe function	N	22
G32	1	Threading*	N	23
G40	7	Cutter Compensation Cancel	Y	23
G41	7	Cutter Compensation Left	Y	25
G42	7	Cutter Compensation Right	Y	25
G43	8	Tool Length Offset + Enable	Y	25
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

# G Code Reference Manual

**M Lipman**



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