



STANDARD G CODE CHART FOR LATHES

STANDARD G CODE	SPECIAL G CODE	SPECIAL G CODE C	FUNCTION
G00	G00	G00	positioning (rapid)
G01	G01	G01	linear interpolation (feed)
G02	G02	G02	circular interpolation CW
G03	G03	G03	circular interpolation CCW
G04	G04	G04	dwell
G07	G07	G07	hypothetical axis interpolation (sine curve)
G09	G09	G09	exact stop
G10	G10	G10	offset value setting
G20	G20	G70	inch data input
G21	G21	G71	metric data input
G22	G22	G22	stored stroke limit ON
G23	G23	G23	stored stroke limit OFF
G27	G27	G27	reference point return check
G28	G28	G28	return to reference point
G29	G29	G29	return from reference point
G30	G30	G30	return to 2nd, 3rd & 4th reference point
G31	G31	G31	skip cutting
G32	G33	G33	thread cutting
G34	G34	G34	variable thread cutting
G36	G36	G36	automatic tool compensation X
G37	G37	G37	automatic tool compensation Y
G40	G40	G40	tool nose radius compensation cancel
G41	G41	G41	tool nose radius compensation left
G42	G42	G42	tool nose radius compensation right programming of absolute zero point
G50	G92	G92	maximum spindle speed setting
G65	G65	G65	user macro simple call
G66	G66	G66	user macro modal call
G67	G67	G67	user macro modal call cancellation
G68	G68	G68	mirror image for double turrets ON
G69	G69	G69	mirror image for double turrets OFF
G70	G70	G72	finishing cycle

Memex Automation Inc., Suite 200 - 3425 Harvester Rd, Burlington, Ontario Canada L7N 3N1

Phone: 905-635-1540 Fax: 905-631-9640

Internet: <http://www.memex.ca>

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G71	G71	G73	stock removal in turning
G72	G72	G74	stock removal in facing
G73	G73	G75	pattern repeating
G74	G74	G76	peck drilling in Z axis
G75	G75	G77	grooving in X axis
G76	G76	G78	thread cutting cycle
G90	G77	G20	cutting cycle A
G92	G78	G21	thread cutting cycle
G94	G79	G24	cutting cycle B
G96	G96	G96	constant surface speed control
G97	G97	G97	constant surface speed control cancel
G98	G94	G94	per minute feed
G99	G95	G95	per revolution feed
---	G90	G90	absolute programming
---	G91	G91	incremental programming

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