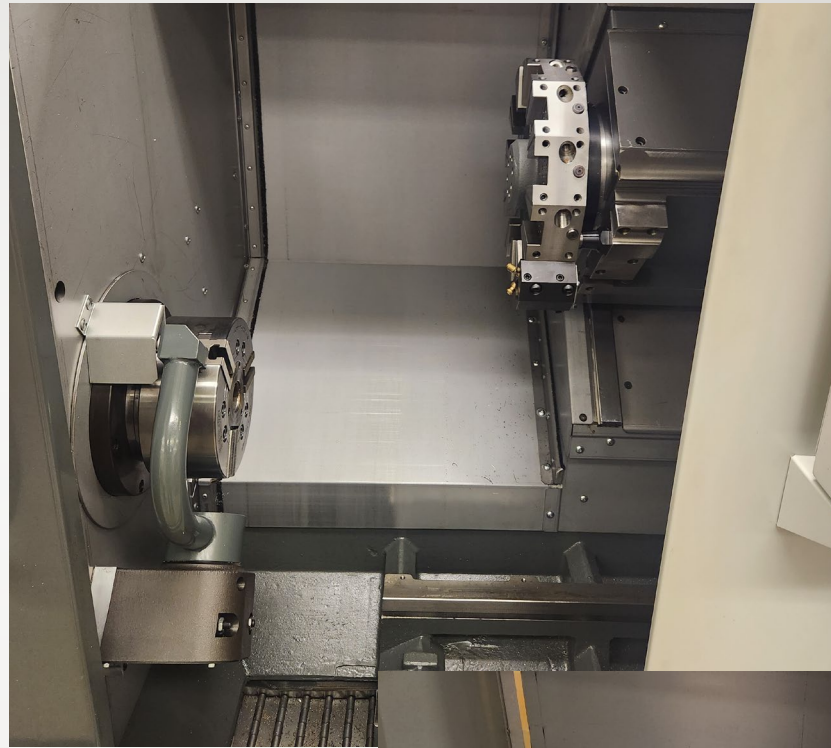
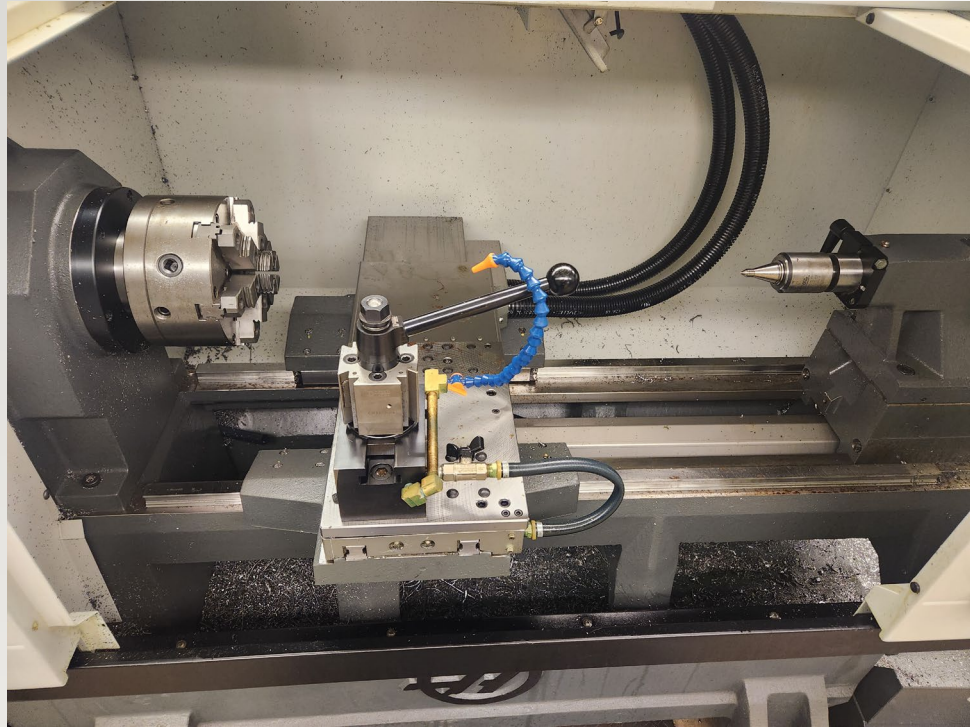




# CNC CODES

LATHE

# Lathe Architecture



## Basic Lathe G-Codes

Code	Function	Subcodes
G00	Rapid Travel Positioning	X,Z,U,W,B
G01	Linear Travel Move	X,Z,U,W,B,F
G02/G03	Circular Interpolation CW/CCW	X,Z,U,W,I,K,R,F
G04	Dwell	P (P=Seconds)
G17/G18/G19	Circular motion plane XY/ZX/YZ	
G20/G21	INCH/METRIC	
G28	Rapid to machine Reference (home)	X,Z,U,W,B
G40	Tool nose Compensation Cancel	X,Z,U,W,I,K
G50	Spindle Speed RPM Limit	S (S=Rpms)
G54-G59	Work offset	
G154 P1-P99	Work offset	
G96	Constant Surface Speed (SFM)	S (S=sfm)
G97	Constant RPM	S (S=rpm)
G98	Feed per minute	F (ipm)
G99	Feed per Revolution	F (inches)

## Basic Lathe M-Codes

Code	Function	Subcodes
M00	Program Stop	
M01	Optional Stop	
M03/M04	Spindle on FWD/REV	
M05	Spindle Stop	
M08/M09	Coolant ON/OFF	
M10/M11	Chuck Clamp ON/OFF	
M14/M15	Main Spindle Clamp ON/OFF	
M19	Orient Spindle	
M21/M22	Tailstock ADV/RET	
M31/M33	Chip Auger ON/OFF	