

Lathe G-code

released: Oct 13

P3 ckd

new codes since last release

	Ref Man	Type Code	Code	Functional explanation	S/B
p	pgm	B	G00	Positioning	\$
p	pgm	B	G01	Linear interpolation	\$
p	pgm	B	G02	Circular interpolation (CW)	\$
p	pgm	B	G03	Circular interpolation (CCW)	\$
p	pgm	B	G04	Dwell	\$
			G05		
			G06		
			G07		
			G08		
			G09		
p	spc		G10	Coordinate move Parallel/Rotate mode OFF	\$
p	spc		G11	Coordinate move Parallel/Rotate mode ON	
	2spH	A	G11	OGL- Ignore In-position state	\$
			G12		
p	pgm	B	G13	Turret selection: Turret A	\$
p	pgm	B	G14	Turret selection: Turret B	\$
	2spH	A	G15	OGL- Position Skip Command (Adapt G00)	\$
p	spc		G15	Coordinate select (modal)	
p	spc		G16	Coordinate select (Single block)	\$
p	pgm	I	G17	Tool nose radius comp: X-Y plane selection	\$
p	pgm	I	G18	Tool nose radius comp: X-Z plane selection (default)	\$
p	yax	I	G19	Tool nose radius comp: Y-Z plane selection	
p	yax	I	G20	Move to home position (HP=x, 1-8)	\$
p	mult	I	G21	Move to ATC home position (HP=x, 1-6)	\$
p	pgm	I	G22	Torque skip	\$
p	2spH	I	G23	OGL- Torque limit check	\$
p	list		G24	Move to ATC home position (not rapid linear interp)	
p	list		G25	Joint position movement (not rapid linear interp)	\$
	2spH	A	G26	OGL- Variable Accel/Decel OFF	\$
	2spH	A	G27	OGL- Variable Accel/Decel ON	
p	pgm	I	G28	Torque limit: Cancel	\$
p	pgm	I	G29	Torque limit	\$
p	gag	I	G30	Skip cycle (gauging)	\$
			Thread Cycles		--
p	pgm	B	G31	Fixed thread cutting cycle: Longitudinal	\$
p	pgm	B	G32	Fixed thread cutting cycle: End face	\$
p	pgm	B	G33	Fixed thread cutting cycle: Longitudinal	\$
p	pgm	B	G34	Variable lead thread cutting cycle: Increasing lead	\$
p	pgm	B	G35	Variable lead thread cutting cycle: Decreasing lead	\$
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			G38	(G37/36: used for Rigid tap)	\$
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			G46		
			G47		
p	list		G48	Service Use: Start APA trace (was G38)	\$

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