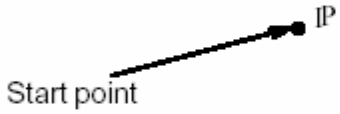
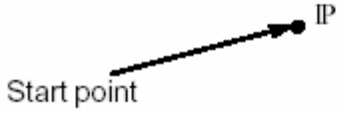
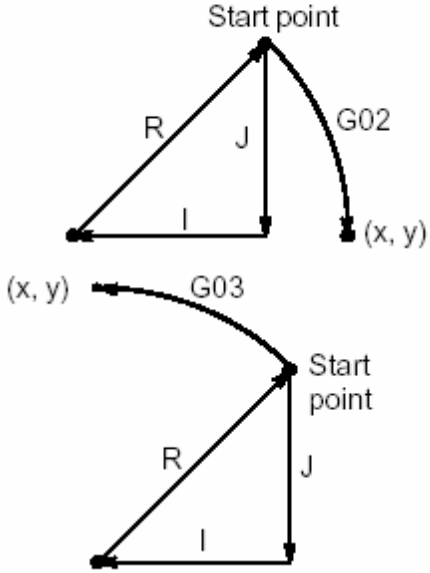
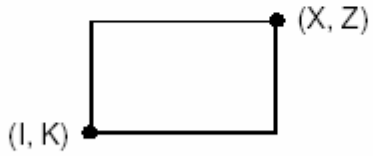
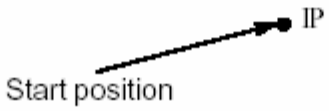
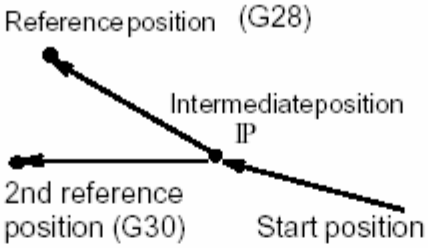
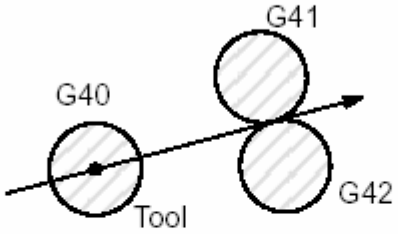
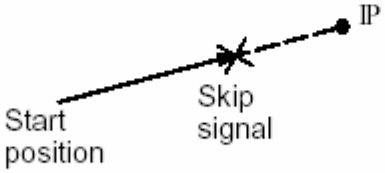
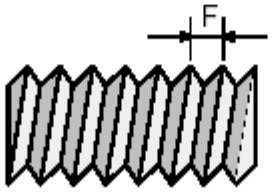
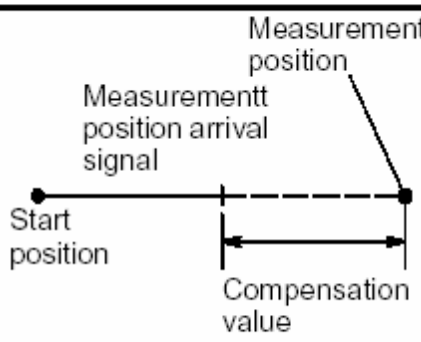
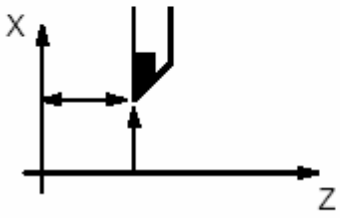
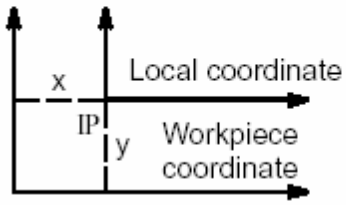
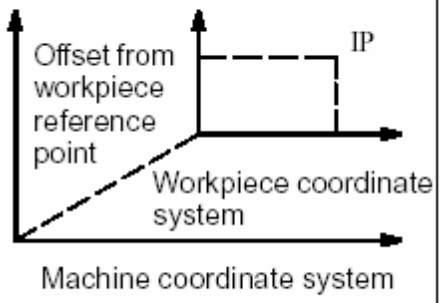
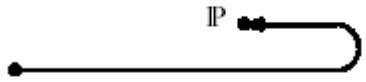
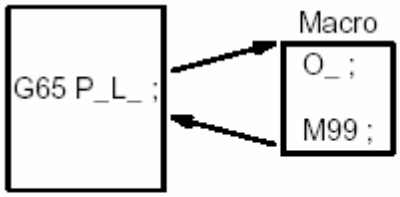
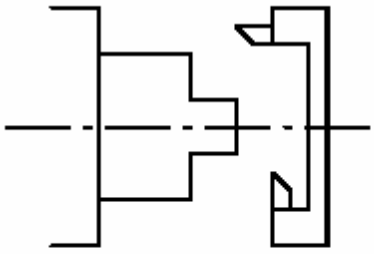
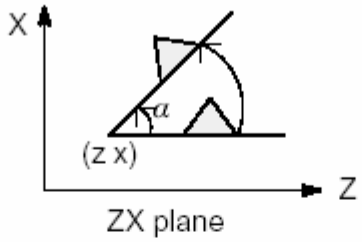
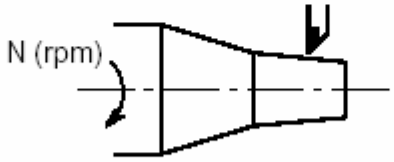
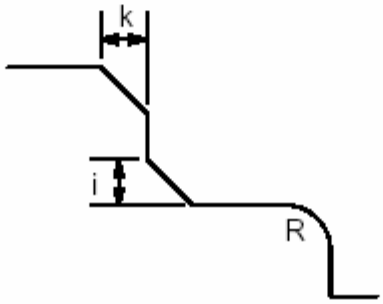
Functions	Illustration	Tape format
Positioning (G00)		G00 IP_ ;
Linear interpolation (G01)		G01 IP_ F_;
Circular interpolation (G02, G03)		$\left\{\begin{matrix}G02\\G03\end{matrix}\right\}$ X_ Z_ $\left\{\begin{matrix}R\_\\I\_\ K\_\end{matrix}\right\}$ F_ ;
Dwell (G04)		G04 $\left\{\begin{matrix}X\_\\P\_\end{matrix}\right\}$;
Cylindrical interpolation (G07.1)		G07.1 IP_r_; Cylindrical interpolation mode G07.1 IP0 ; Cylindrical interpolation mode cancel r: Radius of cylinder
Look–ahead control (G08)		G08 P1 ; Look–ahead control mode on G08 P0 ; Look–ahead control mode off

Functions	Illustration	Tape format
Change of offsetvalue by program(G10)		Tool geometry offset value G10 P_ X_ Z_ R_ Q_ ; P=1000+Geometry offset number Tool wear offset value G10 P_ X_ Z_ R_ Q_ ; P=Wear offset number
Plane selection (G17, G18, G19)		G17 ; G18 ; G19 ;
Inch/metric conversion (G20, G21)		Inch input : G20 Metric input : G21
Stored stroke check 2, 3 (G22, G23)		G22X_ Z_ I_K_ ; G23 ;
Spindle speed fluctuation detection (G25, G26)		G25 ; G26 P_ Q_ R_ ;
Reference position return check (G27)		G27 IP_ ;
Reference position return (G28) 2nd, reference position return (G30)		G28 IP_ ; G30 IP_ ;
Cutter compensation (G40, G41, G42)		{G41 / G42} P_ ; P : Tool offset number G40 : Cancel
Skip fubction (G31)		G31 IP_ F_;
Thread cutting (G32)		Equal lead thread cutting G32 IP_ F_;

Functions	Illustration	Tape format
Automatic tool compensation (G36, G37)		G36 X_xa_ ; G37 Z_za_ ;
Coordinate system setting Spindle speed setting (G50)		G50 X_ Z_ ; Coordinate system setting G50 S_ ; Spindle speed setting
Local coordinate system setting (G52)		G52 IP _ ;
Machine coordinate system selection (G53)		G53 IP _ ;
Workpiece coordinate system selection (G54 to G59)		{ G54 : G59 } IP _ ;
Unidirectional positioning (G60)		G60 IP_ ;
Custom macro (G65, G66, G67)		One–shot call G65 P_L <argument> ; P : Program number L : Repetition count Modal call G66 P_L <argument> ; G67 ; Cancel
Mirror image for double turret (G68, G69)		G68 ; Mirror image for double turret on G69 ; Mirror image cancel

Functions	Illustration	Tape format
Coordinate system rotation (G68.1, G69.1)	 ZX plane	G68.1 { G17 X_Y_ / G18 Z_X_ / G19 Y_Z_ } R α ; G69.1 ; Cancel
Feed per minute (G98) Feed per revolution (G99)	mm/min inch/min mm/rev inch/rev	G98 ... F_ ; (Feed per minute) G99 ... F_ ; (Feed per revolution)
Constant surface speed control (G96/G97)	m/min or feet/min 	G96 S_ ; G97 ; Cancel
Chamfering, Corner R		X_ ; { C ± k / R_ } P_ ; Z_ ; { C ± i / R_ } P_ ;
Canned cycle (G71 to G76) (G90, G92, G94)	Refer to II.13. FUNCTIONS TO SIMPLIFY PROGRAMMING	N_ G70 P_ Q_ ; G71 U_ R_ ; G71 P_ Q_ U_ W_ F_ S_ T_ ; G72 W_ R_ ; G72 P_ Q_ U_ W_ F_ S_ T_ ; G73 U_ W_ R_ ; G73 P_ Q_ U_ W_ F_ S_ T_ ; G74 R_ ; G74 X(u)_ Z(w)_ P_ Q_ R_ F_ ; G75 R_ ; G75 X(u)_ Z(w)_ P_ Q_ R_ F_ ; G76 P_ Q_ R_ ; G76 X(u)_ Z(w)_ P_ Q_ R_ F_ ; { G90 / G92 } X_ Z_ I_ F_ ; G94 X_ Z_ K_ F_ ;
Absolute/incremental programming		X_Z_C_ ; Absolute programming U_W_H_ ; Incremental programming (Identified by an address word specified with a G function such as G00 or G01)