

<i>Modal</i>		<i>Non-Modal</i>			
<i>GCode</i>	<i>Function</i>	<i>GCode</i>	<i>Function</i>	<i>MCode</i>	<i>Function</i>
<b>G 0</b>	Positioning –Rapid Traverse	<b>G 4</b>	Dwell	<b>M 0</b>	Program Stop
<b>G 1</b>	Linear Interpolation – Feed	<b>G 5</b>	Ellipse	<b>M 2</b>	End of Program
<b>G 2</b>	Circular Interpolation –CW	<b>G 6</b>	Spiral	<b>M 3</b>	Spindle ON FWD
<b>G 3</b>	Circular Interpolation- CCW	<b>G 9</b>	Exact Stop Check	<b>M 4</b>	Spindle ON REV
<b>G22</b>	Stored Stroke Limit ON	<b>G28</b>	Return to Machine Home	<b>M 5</b>	Spindle Off
<b>G40</b>	Tool Radius Compensation (Cancel)	<b>G29</b>	Return from Machine Home	<b>M 6</b>	Change Tool
<b>G41</b>	Tool Radius Compensation (Left)	<b>G45</b>	Mold Rotation	<b>M 8</b>	Coolant ON
<b>G42</b>	Tool Radius Compensation (Right)	<b>G49</b>	Elbow Milling	<b>M 9</b>	Coolant Off
<b>G53</b>	Work Coordinate System (Fixture offset )	<b>G62</b>	Automatic Feed Override for Arcs	<b>M30</b>	Jump to New Program
<b>G59</b>	Modal Corner Rounding	<b>G63</b>	Automatic Feed override for Arcs Cancel	<b>M98</b>	Call Sub Program
<b>G60</b>	Modal Corner Rounding Off	<b>G65</b>	User Macro Single Call	<b>M99</b>	End Sub Program
<b>G61</b>	Exact Stop Check Mode	<b>G66</b>	User Macro Modal Call	<b>M100</b>	Mirror Image
<b>G64</b>	Cutting Mode (continuous Path ON)	<b>G67</b>	User Macro Modal Call Cancel	<b>M105</b>	Dry Run All Axis
<b>G66</b>	User Macro Modal Call	<b>G68</b>	Coordinate System Rotation	<b>M106</b>	Dry Run No Axis
<b>G67</b>	User Macro Modal Call Cancel	<b>G73</b>	Draft Pocket Milling Cycle	<b>M107</b>	Dry Run Off (Cancel M105)
<b>G68</b>	Coordinate System Rotation	<b>G74</b>	Area Clearance (Face) Cycle		
<b>G70</b>	Inch Programming	<b>G75</b>	Frame Milling	<b>M19</b>	Spindle Index & Manual Arm Rotation Unlock
<b>G71</b>	MM Programming	<b>G76</b>	Hole Milling Cycle	<b>M61</b>	Tool Pot Down
<b>G72</b>	Axis Scaling	<b>G77</b>	Circular Pocket Cycle	<b>M62</b>	Tool Pot Down
<b>G81</b>	Basic Drilling Cycle	<b>G78</b>	Rectangular Pocket Cycle	<b>M63</b>	Tool Un Clamp
<b>G82</b>	Counter bore Drilling Cycle	<b>G79</b>	Bolt Hole Circle Cycle	<b>M64</b>	Tool Clamp
<b>G83</b>	Basic Peck Cycle	<b>G80</b>	Cancel Modal Drilling	<b>M66</b>	Arm Rotation For one Stop
<b>G84</b>	Tapping Cycle	<b>G169</b>	Area Clearance	<b>M67</b>	Tool Pot No=1
<b>G85</b>	Basic Bore Cycle	<b>G170</b>	Facing Cycle	<b>M68</b>	Tool in Spindle = 0
<b>G86</b>	Uni-directional Boring Cycle	<b>G171</b>	Circular Profile Cycle		
<b>G87</b>	Chip Break Drilling Cycle	<b>G172</b>	Rectangular Profile Cycle		
<b>G89</b>	Flat Bottom Bore Cycle	<b>G177</b>	Plunge Circular Pocket		
<b>G90</b>	Absolute Programming	<b>G178</b>	Plunge Rectangular Pocket		
<b>G91</b>	Incremental Programming	<b>G179</b>	Hole Pattern Drilling		
<b>G92</b>	Absolute Programming				
<b>G94</b>	Per Minute Feed				