



Common G codes and M codes for CNC machine controls

G Code	Function	Mill	Lathe
G00	Positioning at rapid speed	✓	✓
G01	Linear interpolation [machining a straight line]	✓	✓
G02	Circular interpolation clockwise [machining arcs]	✓	✓
G03	Circular interpolation, counter clockwise	✓	✓
G04	Dwell	✓	✓
G09	Exact stop	✓	✓
G10	Setting offsets in the program	✓	✓
G12	Circular pocket milling, clockwise	✓	✗
G13	Circular pocket milling, counterclockwise	✓	✗
G17	X-Y plane for arc machining [with live tooling]	✓	✓
G18	Z-X plane for arc machining [with live tooling]	✓	✓
G19	Z-Y plane for arc machining [with live tooling]	✓	✓
G20	Inch units	✓	✓
G21	Metric units	✓	✓
G27	Reference return check	✓	✓
G28	Automatic return through reference point	✓	✓
G29	Move to location through reference point [different for each machine]	✓	✓
G31	Skip function	✓	✓
G32	Thread cutting	✗	✓
G33	Thread cutting	✓	✗
G40	Cancel diameter offset Cancel tool nose offset	✓	✓
G41	Cutter compensation left Tool nose radius compensation left	✓	✓
G42	Cutter compensation right Tool nose radius compensation right	✓	✓
G43	Tool length compensation	✓	✗
G44	Tool length compensation cancel [sometimes G49]	✓	✗
G50	Set coordinate system and maximum RPM	✗	✓
G52	Local coordinate system setting	✓	✓
G53	Machine coordinate system setting	✓	✓
G54- G59	Workpiece coordinate system settings #1 to #6	✓	✓
G61	Exact stop check	✓	✓
G65	Custom macro call	✓	✓
G70	Finish cycle	✗	✓
G71	Rough turning cycle	✗	✓
G72	Rough facing cycle	✗	✓
G73	Irregular rough turning cycle	✗	✓
G73	Chip break drilling cycle	✓	✗
G74	Left hand tapping	✓	✗

G74	Face grooving or chip break drilling	✗	✓
G75	OD groove pecking	✗	✓
G76	Fine boring cycle	✓	✗
G76	Threading cycle	✗	✓
G80	Cancel cycles	✓	✓
G81	Drill cycle	✓	✓
G82	Drill cycle with dwell	✓	✗
G83	Peck drilling cycle	✓	✗
G84	Tapping cycle	✓	✓
G85	Bore in, bore out	✓	✓
G86	Bore in, rapid out	✓	✓
G87	Back boring cycle	✓	✗
G90	Absolute programming		
G91	Incremental p		
G92	Reposition origin point	✓	✗
G92	Thread cutting cycle	✗	✓
G94	Per minute feed	✓	✗
G95	Per revolution feed	✓	✗
G96	Constant surface speed control	✗	✓
G97	Constant surface speed cancel		
G98	Per minute feed	✗	✓
G99	Per revolution feed	✗	✓

M Code	Function	Mill	Lathe
M00	Program stop	✓	✓
M01	Optional program stop	✓	✓
M02	Program end	✓	✓
M03	Spindle on clockwise	✓	✓
M04	Spindle on counterclockwise	✓	✓
M05	Spindle	✓	✓
M06	Toolchange	✓	✗
M08	Coolant on	✓	✓
M09	Coolant off	✓	✓
M10	Chuck or rotary table clamp	✓	✓
M11	Chuck or rotary table clamp off	✓	✓
M19	Orient spindle	✓	✓
M30	Program end, return to start	✓	✓
M97	Local sub-routine call	✓	✓
M98	Sub-program call	✓	✓
M99	End of sub program	✓	✓

Mill and Lathe Conversions

To Find:

Revolutions Per Minute	RPM	=	[SFM x 3.8197] ÷ D
Surface Feet Per Minute	SFM	=	RPM x D x 0.2618
Surface Meters Per Minute [Metric]	SMPM	=	SFM x 0.3048
Inches Per Minute Milling Feedrate	IPM	=	FPT x T x RPM
Feed Per Tooth Mill	FPT	=	IPM ÷ [T x RPM]
Feed Per Revolution	FPR	=	IPM ÷ RPM
Inches Per Minute Lathe	IPM	=	IPR x RPM
Metal Removal Lathe	MMR	=	W x d x F
Advance Per Revolution [Inches]	ADV/R	=	F ÷ RPM

Miscellaneous

Radius of Circle	=	Circumference x 0.159155
Diameter of Circle	=	Circumference x 0.31831
Circumference of Circle	=	D x 3.1416
Area of Circle	=	R ² x 3.1416
Cutting Time in Minutes [Mill]	=	L x IPM
Cutting Time in Seconds [Lathe]	=	Distance to go x 60 sec IPR x RPM

Amada G M Codes

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