

Nokta CNC Software G-Code Support List

- G00** Positioning. Rapid advance in idle
- G01** Feed, cutting, chip removal with a specified cutting speed F
- G02** Circular interpolation to clockwise rotation - Radius pass chip removal
- G03** Circular interpolation counterclockwise-Radius pass chip removal
- G04** Temporary hold (Ex. G04 P2 (waits 2 seconds))
- G17** X - Y Plane selection
- G18** Z - X Plane selection
- G19** Y - Z Plane selection
- G20** Program input in G20 inch system
- G21** Program input in G21 Metric (mm) system
- G27** Return control to G27 Machine Reference position
- G28** Sends G28 Machine to Home Reference position
- G32** Left screwing (fixed pitch)
- G33** Right screwing (fixed pitch)
- G40** Tool nose radius compensation cancel
- G41** Tool nose radius waste (left)
- G42** Tool nose radius compensation (right)
- G43** Open tool diameter compensation
- G49** Tool diameter compensation cancel
- G50** Setting up G50 Maximum Speed limitation / or coordinate system
- G52** Local coordinate system setup
- G54** Workpiece coordinate system, zero point (1st choice)
- G55** Workpiece coordinate system, zero point (2nd choice)
- G56** Workpiece coordinate system, zero point (3rd choice)
- G57** Workpiece coordinate system, zero point (4th choice)

- G58** Workpiece coordinate system, zero point (5th choice)
- G59** Workpiece coordinate system, zero point (6th selection)
- G61** Stop - Switches to Stop Mode. (Used to obtain Sharp Corners.)
- G64** Velocity - Switches to Speed Mode. (Trajectory Orbit Planner can be activated with P and Q parameters. For example G64 P1 Q1 vs.)
- G80** Cycles cancellation (operation function cancellation)
- G81** Drilling cycle, spot drilling cycle
- G82** Temporary dwell time hole (dot) drilling cycle
- G83** Step-by-step drilling cycle. (For deep holes (pecking)
- G84** Threading cycle
- G85** Boring cycle
- G90** Absolute command system.
- G91** Incremental (Additive) command system
- G92** Threading cycle
- G94** Feed mm / min.
- G95** Feed mm / rev
- G96** Constant surface cutting speed control ($S = m / \text{min.}$)
- G97** Constant speed control ($S = \text{rpm.}$ (Also G96 cancellation)

M Code Support List

- M00** Program stop (Stop)
- M01** Optional program stop (Optional Stop)
- M02** End of program
- M03** Clockwise Spindle (Spindle - Mirror) rotation
- M04** Clockwise counter Spindle (Spindle - Mirror) rotation
- M05** Stop Spindle (Spindle - Mirror)
- M06** Tool change T refers to the tool number. (Ex. M06T6)
- M07** Open coolant as fog
- M08** Open coolant at maximum level
- M09** Shut off coolant
- M30** Return to End of Program and Per Program
- M98** Subprogram call
- M99** Subprogram end (Return to main program)