

HAAS C.N.C. LATHE PREPARATORY FUNCTIONS

MODAL
NON-MODAL
DEFAULT *
OPTION**

G00	RAPID POSITIONING MOTION (X,Z,U,W,R) (SETTING 14, 15)	G70	IRREGULAR PATH STOCK REMOVAL CYCLE (P,Q,U,W,R,D,S,T,F) (SETTING 12, 13)
G01	LINEAR INTERPOLATION MOTION (X,Z,U,W,R,F) (SETTING 14, 15)	G71	FACE GROOVING & HIGH SPEED-PECK DRILL CYCLE (X,Z,U,W,R,K,D,F) (SETTING 22)
G02	CHAMFERING AND CORNER ROUNDOFF (X,Z,U,W,R,K,L,F) (SETTING 14, 15)	G72	O.D. I.D. PECK GROOVING CYCLE (X,Z,U,W,R,K,D,F) (SETTING 22)
G03	CW CIRCULAR INTERPOLATION MOTION (X,Z,U,W,R,K,L,F) (SETTING 14, 15)	G73	THREAD CUTTING CYCLE, MULTIPLE PASS (X,Z,U,W,R,K,A,D,F) (SETTING 16, 18, 19, 20)
G04	DWELL (P) (P=seconds) (SETTING 14, 15)	G74	FLATTING CYCLE (X,Z,U,W,R,S,R) (SETTING 14, 15)
G05	FINE SPINDLE CONTROL MOTION (X,Z,U,W,R,F) (LIVE TOOLING)	G75	CANCEL CANNED CYCLE (SETTING 16)
G06	EXACT STOP NON-MODAL	G76	DRILL CANNED CYCLE (X,Z,U,W,R,F)
G07	PROGRAMMABLE OFFSET SETTING (X,Z,U,W,R,F,G,H)	G77	SPOT DRILL / COOLANT/BORNE CANNED CYCLE (X,Z,U,W,R,F)
G08	MAIN SPINDLE SHIFT TO SUB-SPINDLE	G78	PECK DRILLING CANNED CYCLE (X,Z,U,W,R,K,L,Q,P,R,F) (SETTING 16, 18)
G09	MAIN SPINDLE SHIFT TO SUB-SPINDLE CANCEL	G79	TAPPING CANNED CYCLE (X,Z,U,W,R,F)
G10	CIRCULAR MOTION BY PLANE SELECTION (G02-G03) (LIVE TOOLING)	G80	BORE IN, BORE OUT CANNED CYCLE (X,Z,U,W,R,L,F)
G11	CIRCULAR MOTION IN PLANE SELECTION (G04-G05) (SETTING 14)	G81	BORE IN, STOP, RAPID OUT CANNED CYCLE (X,Z,U,W,R,L,F)
G12	CIRCULAR MOTION YZ PLANE SELECTION (G06-G07) (LIVE TOOLING)	G82	BORE IN, STOP, MANUAL RETRACT CANNED CYCLE (X,Z,U,W,R,L,F)
G13	VERIFY X/Y/Z COORDINATE POSITIONING (SETTING 2 needs to be ON)	G83	BORE IN, DWELL, MANUAL RETRACT CANNED CYCLE (X,Z,U,W,R,L,F)
G14	VERIFY METRIC COORDINATE POSITIONING (SETTING 2 needs to be OFF)	G84	O.D. I.D. TURNING CYCLE, MODAL (X,Z,U,W,R,F)
G15	MACHINE ZERO RETURN FROM REF. POINT (X,Z,U,W,R,S) (Panned)	G85	THREADING CYCLE, MODAL (X,Z,U,W,R,F) (SETTING 16, 18)
G16	MOVE TO LOCATION THROUGH G28 REF. POINT (X,Z) (Panned)	G86	END FACE LIVE TOOLING RIND TAP (X,Z,U,W,R,F)
G17	FEED-LIMIT, SWP FUNCTION (X,Z,U,W,R,F)	G87	CONSTANT SURFACE SPEED, CS# ON (S)
G18	THREAD CUTTING WITH MODAL (X,Z,U,W,R,F)	G88	CONSTANT SURFACE SPEED, CS# OFF (S) (SETTING 16)
G19	TOOL NOSE COMPENSATION CANCEL (G40) (X,Z,U,W,R,K) (SETTING 16)	G89	FEED PER REV/REV (F) (SETTING 16)
G20	TOOL NOSE COMPENSATION, LEFT (X,Z,U,W,R) (SETTING 16, 18, 19)	G90	FEED PER REVOLUTION (F) (SETTING 16)
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G24	WORK-OFFSET COORDINATE POSITIONING (Panned)	G94	LIMIT BLOCK LOOKAHEAD (P,Q, S=1000, for number control blocks ahead)
G25	GLOBAL WORK COORDINATE SYSTEM SHIFT (Panned)	G95	SERVO-BAK CORRECTING
G26	MACHINE COORDINATE POSITIONING, NON-MODAL (X,Z) (S)	G96	WORK-OFFSET COORDINATE POSITIONING #1-#5
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G31	WORK-OFFSET COORDINATE POSITIONING #5	G101	APL, APL COMMAND MODE ON
G32	WORK-OFFSET COORDINATE POSITIONING #6	G102	APL, APL COMMAND MODE OFF
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G34	EXACT STOP G41 CANCEL (SETTING 16)	G104	ACCURACY CONTROL, FOR HIGH SPEED MACHINING (S) (SETTING 16)
G35	MACRO-SUBROUTINE CALL	G105	SUB-SPINDLE TAPPING CANNED CYCLE
G36	FRESHING CYCLE (P,Q)	G106	LIVE TOOLING VECTOR TAPPING (X,Z)
G37	O.D. I.D. STOCK REMOVAL CYCLE (P,Q,U,W,R,K,D,S,T,F) (SETTING 12, 13)	G107	LIVE TOOLING VECTOR TAPPING REVERSE (X,Z)
G38	END FACE STOCK REMOVAL CYCLE (P,Q,U,W,R,K,D,S,T,F) (SETTING 12, 13)	G108	INDEX ON THE FLY (X,Z,U,W,T)

Note: These G and M codes are useful reference information, on a desk, or at the machine.

They're great to have laminated with G codes on one side and M codes on the other.

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Haas G Code Reference Manual

Léo Pomar



Haas G Code Reference Manual:

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