

G0 0	Rapid linear move . Example: G00 X### Y### Z### (X,Y,Z = position)
G0 1	Feed linear move Example: G01 F### X### Y### Z### (F=feedrate to move at)
G0 2	Circular move CW. Example: G02 X### Y### I### J### (XY=end point, IJ=center point)
G0 2	Circular move CW. Example: G02 X### Y### R±### (R=size of radius arc to swing. R+ if radius < 180°, R- if radius is > 180°)
G0 3	Circular move CCW. Example: G03 X### Y### I### J### (XY=end point, IJ=center point)
G0 3	Circular move CCW. Example: G03 X### Y### R±### (R=size of arc radius to swing. R+ if radius < 180°, R- if radius is > 180°)
G0 4	Dwell time. Example: G04 P### (P=time to dwell. P20000 is 2 seconds)
G1 0	Zero offset shift. Example: G10 X### Y### Z###(X=shift dist. Y=shift dist. Z=shift dist.)
G1 1	Zero offset shift cancel. Example: G11
G1 7	Contour plane is XY (Z = spindle) . Example: G17
G1 8	Contour plane is ZX (Y = spindle). Example: G18
G1 9	Contour plane is YZ (X = spindle). Example: G19
G2 0	Inch mode (G70 on older controls). Example: G20
G2 1	MM mode (G71 on older controls). Example: G21
G2 8	Return to reference point. Example: G0 G91 G28 X### Y### Z### (Go to machine XYZ home,passing thru XYZ incremental zero)
G2 9	Return from reference point. Example: G0 G90 G29 X### Y### Z### (Go to this XYZ position, returning from home)
G3 0	Return to 2nd, 3rd (ect..) reference point. Example: Similar to G28
G4 0	Cutter (dia.or rad.) compensation off. Example: G40 X### Y###
G4 1	Cutter compensation to the left of the programmed path. Example: G40 X### Y###
G4 2	Cutter compensation to the right of the programmed path . Example: G40 X### Y###
G4 3	Tool length compensation with spindle approach from + side. Example: G43 H### Z###
G4 4	Tool length compensation with spindle approach from - side. Example: G44 H### Z###
G4 9	Tool length compensation cancel. Example: G49
G4	Increase end position by tool offset value. Example: G45 X### D### (Go

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CNC MACHINE (Operating and Programming) ajay dhamande,2023-07-01 This book of CNC MACHINE operating and programming of machines it is useful to students of ITI DIPLOMA and DEGREE ENGINEERING and those are working in machining industries The book mainly divide in 4 parts 1 how to operate the machine 2 setting process of machine 3 cutting tool selection process 4 how to write programming according to the process carried out In support it has technical topics like Drawing reading About Geometric Dimension and tolerances Speed and feed calculations All topic has ended up with the possible question that can be raised will facing exam or interviews and the answers are accessible to each user by email notification more than 20 solved programs for each process that were carried out on CNC TURNING and VMC machines and assess will be for more solved exercises through scanning given at the end of each chapter the author has shared his 18 years of training and working experience while describing each topic looking at the need for freshers to well experienced fellows you can communicate with us through the given channel on book back covers for any assistance all the best **The**

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