

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 13, 14)
G01	LINEAR INTERPOLATION MOTION (X,Z,U,W,R,F) (SETTING 14, 15)	G71	FACE GROOVING & HIGH SPEED RECH DRILL CYCLE (X,Z,U,W,R,K,D,F) (SETTING 20, 21)
G02	CHAMFERING AND CORNER ROUNDOFF (X,Z,M,R,S,U,K,U,R,F) (SETTING 14, 15)	G72	O.D. I.D. PEAK GROOVING CYCLE (X,Z,U,W,R,K,D,F) (SETTING 20, 21)
G03	CW CIRCULAR INTERPOLATION MOTION (X,Z,U,W,R,U,R,F) (SETTING 14, 15)	G73	THREAD CUTTING CYCLE, MULTIPLE PASS (X,Z,U,W,R,K,A,D,F) (SETTING 16, 17, 18, 19)
G04	DRWELL (P) (P=seconds) (POSITIONING)	G74	FLATTING CYCLE (J,L,R,S,R) (L&S TOOLING)
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,U,R,F)	G77	SPOT DRILL / COUINTERBORE 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,A,Q,P,R,F) (SETTING 16, 17)
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,U,R,F)
G11	CIRCULAR MOTION IN PLANE SELECTION (G04-G05) (SETTING 16)	G81	BORE IN, STOP, RAPID OUT CANNED CYCLE (X,Z,U,W,R,U,R,F)
G12	CIRCULAR MOTION YZ PLANE SELECTION (G06-G07) (LIVE TOOLING)	G82	BORE IN, STOP, MANUAL, RETRACT CANNED CYCLE (X,Z,U,W,R,U,R,F)
G13	VERIFY X/Y/Z COORDINATE POSITIONING (SETTING 2 needs to be ON)	G83	BORE IN, DRWELL, BORE OUT CANNED CYCLE (X,Z,U,W,R,U,R,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,U,F) (SETTING 16, 17)
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,U) (SETTING 16)	G89	FEED PER REVOLUTE (F) (SETTING 16)
G20	TOOL NOSE COMPENSATION, LEFT (X,Z,U,W,R) (SETTING 16, 17, 18)	G90	FEED PER REVOLUTION (F) (SETTING 16)
G21	TOOL NOSE COMPENSATION, RIGHT (X,Z,U,W,R) (SETTING 16, 17, 18)	G91	MIRROR IMAGE CANCEL, G21
G22	SPINDLE SPEED MAXIMUM RPM LIMIT (S)	G92	MIRROR IMAGE (X,Z) (SETTING 16, 17)
G23	RETURN TO MACHING ZERO, CANCEL, OFFSET (Panned)	G93	PROGRAMMABLE OUTPUT TO RS-232 (X,Z)
G24	WORK-OFFSET COORDINATE POSITIONING (Panned)	G94	LIMIT BLOCK LOOKAHEAD (P,Q-S) (max. for number control blocks ahead)
G25	GLOBAL WORK COORDINATE SYSTEM SHIFT (Panned)	G95	SERVO-BAK CORRECTION
G26	MACHINE COORDINATE POSITIONING, NON-MODAL (X,Z,S)	G96	G14-G15 WORK OFFSET COORDINATE POSITIONING #1-#2
G27	WORK-OFFSET COORDINATE POSITIONING #1 (SETTING 16)	G97	G16-G17 WORK OFFSET COORDINATE POSITIONING #3-#4
G28	WORK-OFFSET COORDINATE POSITIONING #2	G98	G18-G19 WORK OFFSET COORDINATE POSITIONING #5-#8
G29	WORK-OFFSET COORDINATE POSITIONING #3	G99	APL, APL COMMAND MODE ON
G30	WORK-OFFSET COORDINATE POSITIONING #4	G100	APL, APL COMMAND MODE OFF
G31	WORK-OFFSET COORDINATE POSITIONING #5	G101	REVERSE TAPPING CANNED CYCLE (X,Z,U,W,R,F) (SETTING 16)
G32	EXACT STOP, MODAL (X,Z)	G102	ACCURACY CONTROL, FOR HIGH SPEED MACHINING (S) (SETTING 16)
G33	EXACT STOP G41 CANCEL (SETTING 16)	G103	SUB-SPINDLE TAPPING CANNED CYCLE
G34	MACRO-SUBROUTINE CALL	G104	LIVE TOOLING VECTOR TAPPING (X,Z)
G35	FRESHING CYCLE (P,Q)	G105	LIVE TOOLING VECTOR TAPPING REVERSE (X,Z)
G36	O.D. I.D. STOCK REMOVAL CYCLE (P,Q,U,W,R,K,D,S,T,F) (SETTING 13, 14)	G106	INDEX ON THE FLY (X,Z,U,W,T)
G37	END FACE STOCK REMOVAL CYCLE (P,Q,U,W,R,K,D,S,T,F) (SETTING 13, 14)		

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.

As a suggestion, get some white 90lb. cardstock and print G-codes on one side and M-codes on the other. Cut out the square section and go to Kinko's copies or local printer to get them laminated.

Haas G Code Reference Manual

L Darling-Hammond



Haas G Code Reference Manual:

Haas G Code Reference Manual Book Review: Unveiling the Power of Words

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