

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,U,W,R,K,L,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,K,L,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,Q) (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,F,Q,R)	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, 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,K,L,F)
G11	CIRCULAR MOTION IN PLANE SELECTION (G04-G05) (SETTING 16)	G81	BORE IN, STOP, RAPID OUT CANNED CYCLE (X,Z,U,W,R,K,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,K,L,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,K,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, 17)
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Note: These G and M codes are useful reference information, on a desk, or at the machine.

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