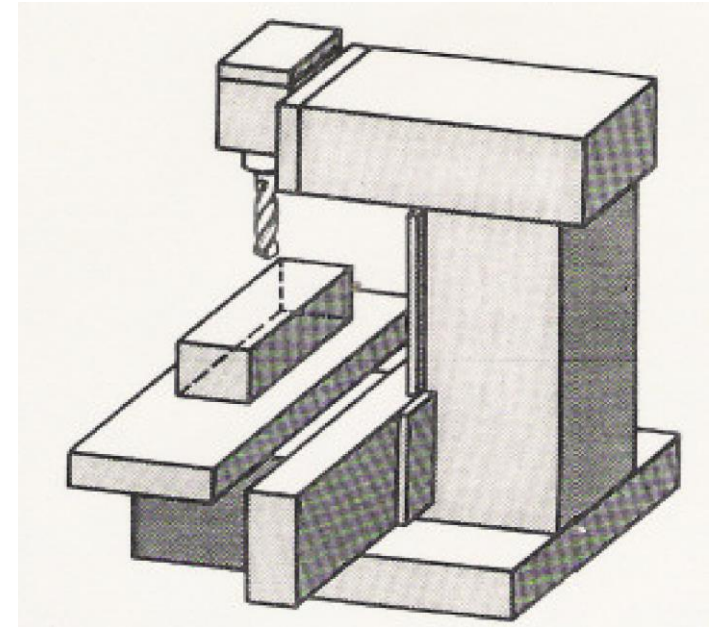


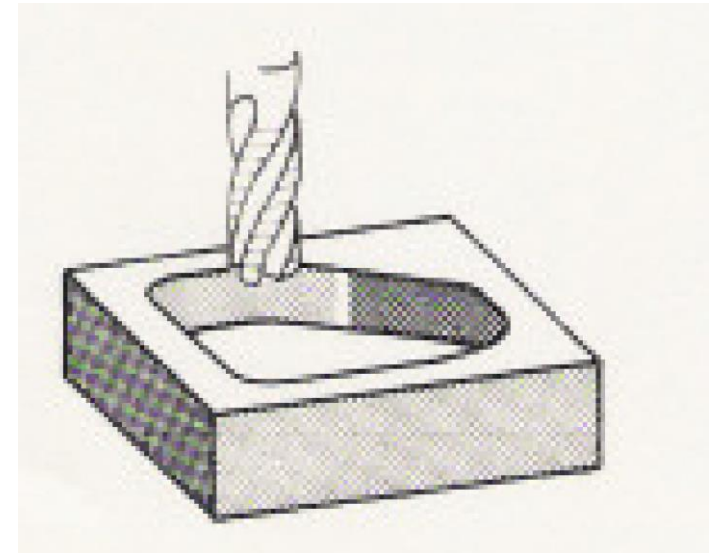
Programming of CNC Machine

G & M code

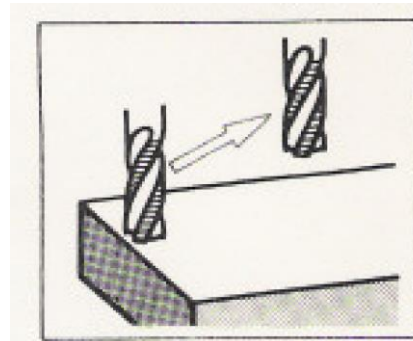
CNC milling machines



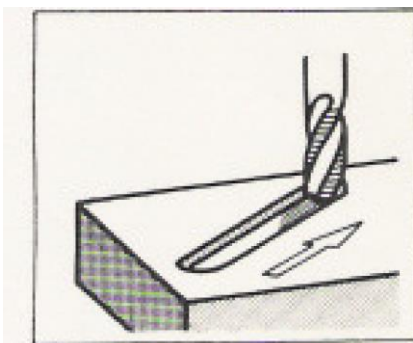
Prismatic or flat part



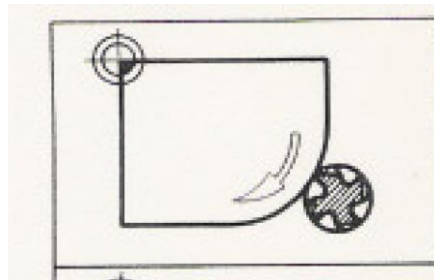
G00 rapid linear motion



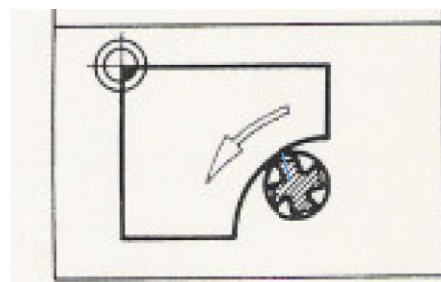
G01 linear motion at feed rate



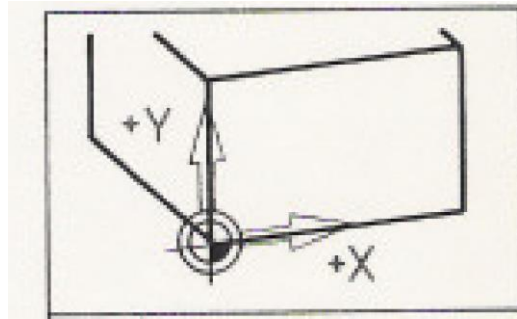
G02 circular motion
clockwise feed



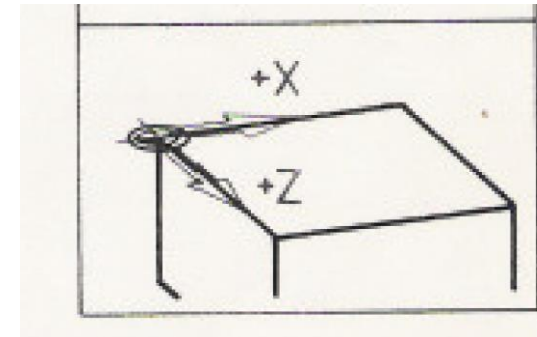
G03 circular motion
anti-clockwise feed



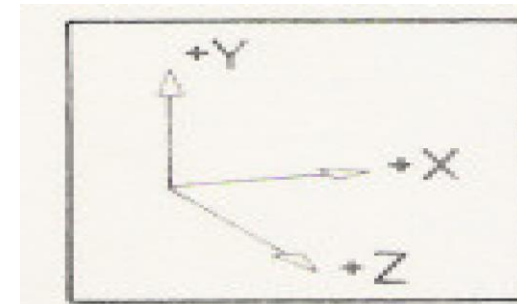
G17 X Y plane



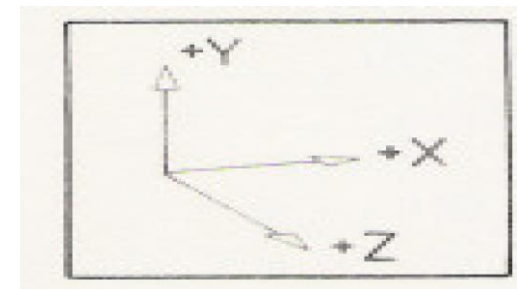
G18 X Z plane



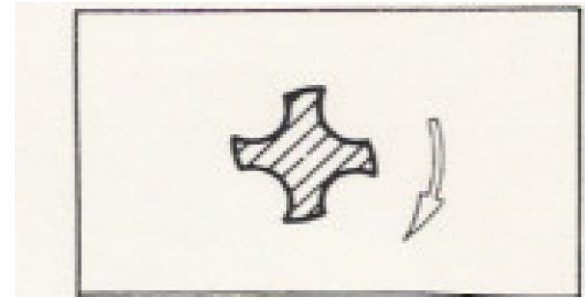
G90 absolute dimension



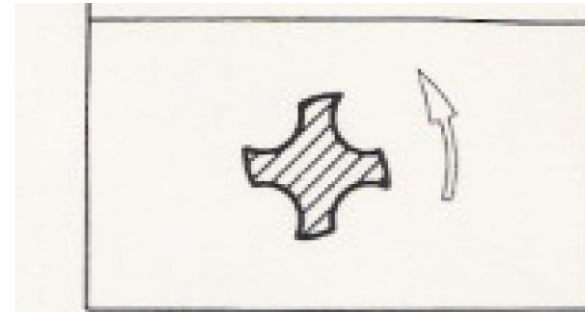
G91 incremental dimension



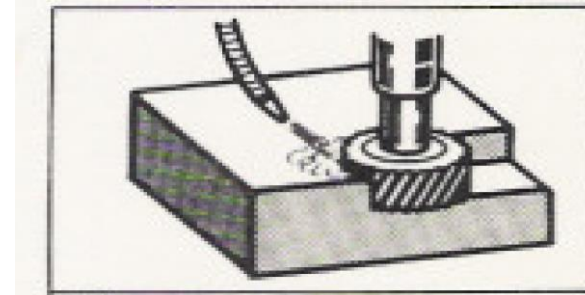
M03 direction of rotation to the right



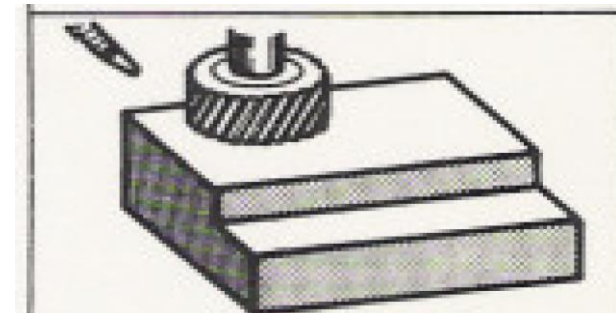
M04 direction of rotation to the left



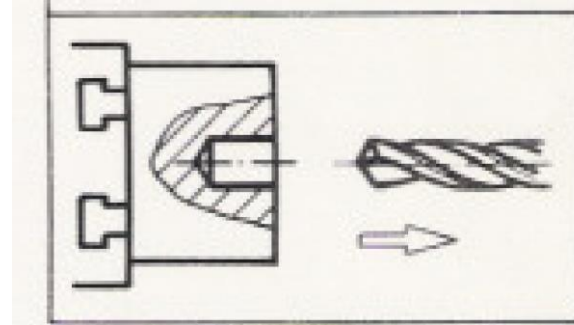
M08 coolant in



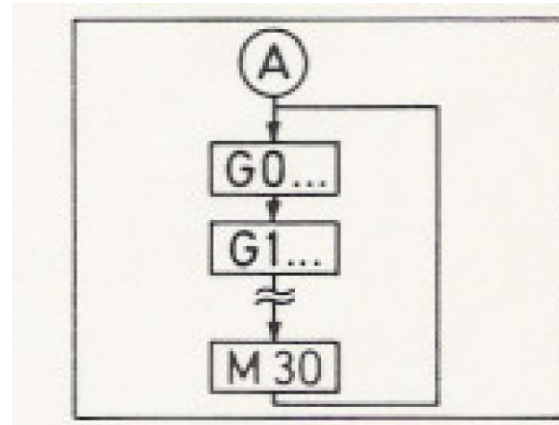
M09 coolant off

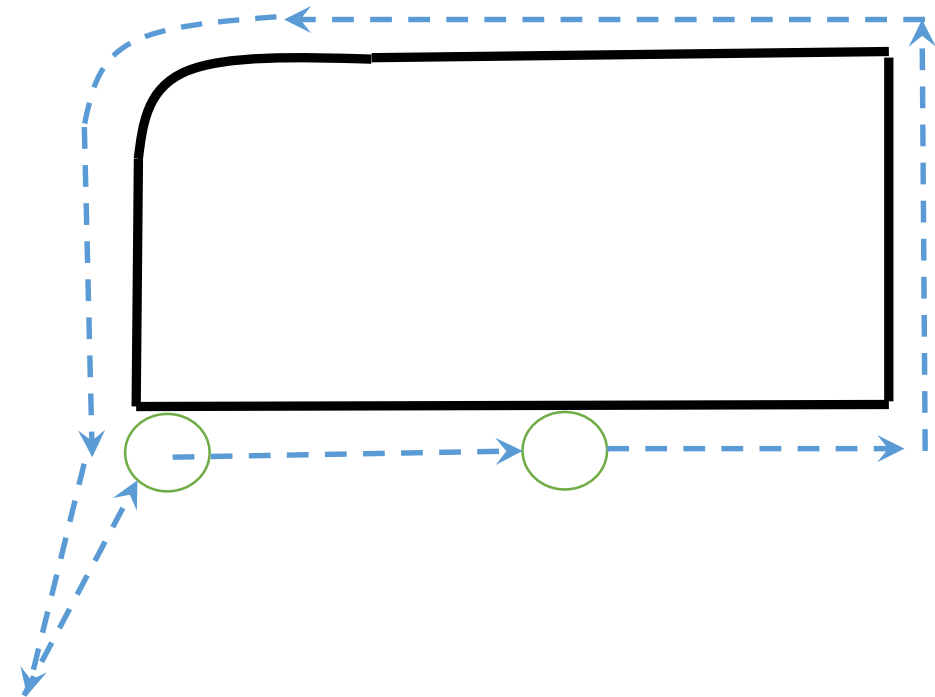
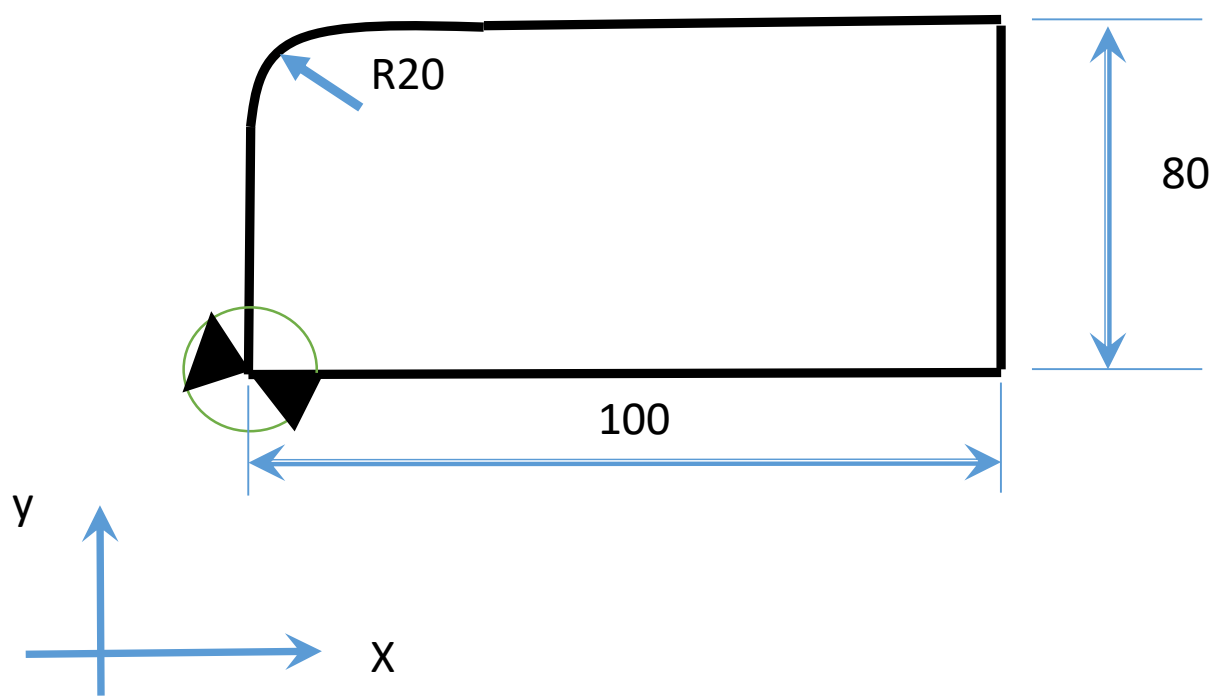


M66 tool change



M30 end of program
and return to start
program





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N10 G90 G17 S1000 T2 M3
N20 G00 G42 X0 Y0 Z5
N30 G01 Z-5 F150
N40 X100
N50 Y80
N60 X20
N70 G03 X0 Y40 R20
N80 G01 Y0
N90 G01 Z5
N100 G00 G40 X-30 Y-40 Z20 M30

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