

1` Codes meaning

G71 – Metric unit

G90 – Absolute co-ordinate system

G92 – Initial position's co-ordinates

M06 – Tool Change Ex- M06 T05

M03 – Spindle On, CW

M04 – Spindle On, CCW

S### - Spindle speed

F### - Feed rate (mm per second)

G01 – Linear Path

G81 – Drill Start, Then mention the depth of drilling; then only mention x,y co-ordinate

G80 – Drill stop

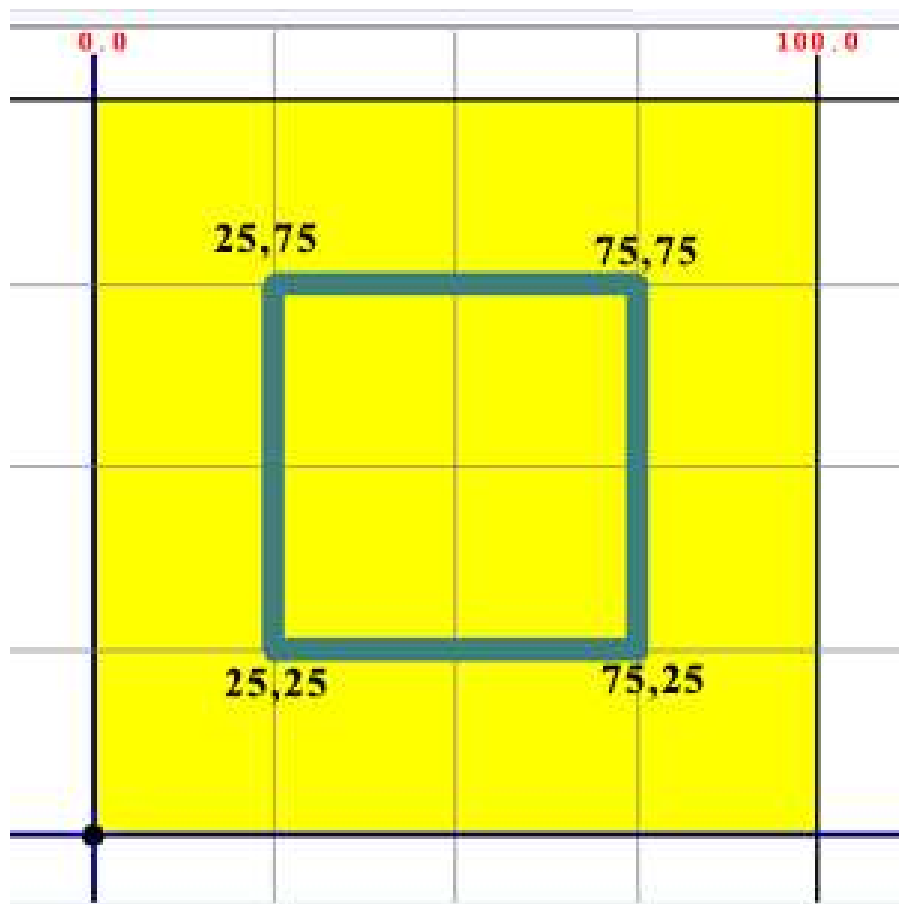
Ex: N11 G81 Z-15;

 N12 X500 Y500

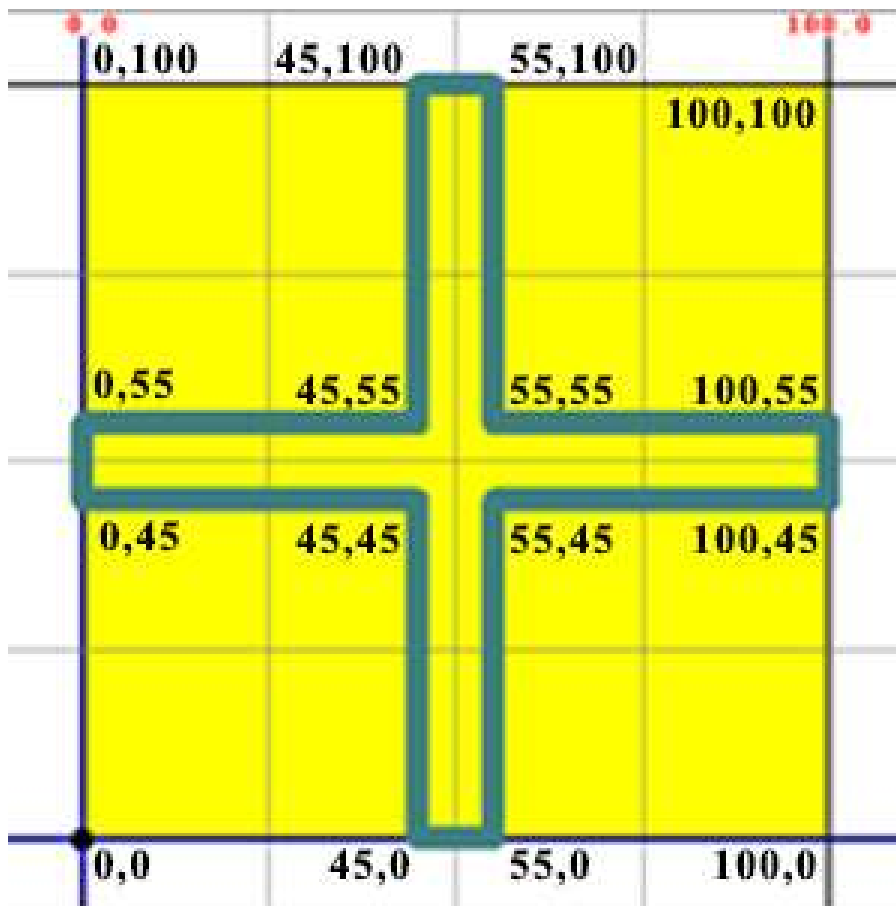
 N13 G80;

M05 – Spindle off

M02 – Program end



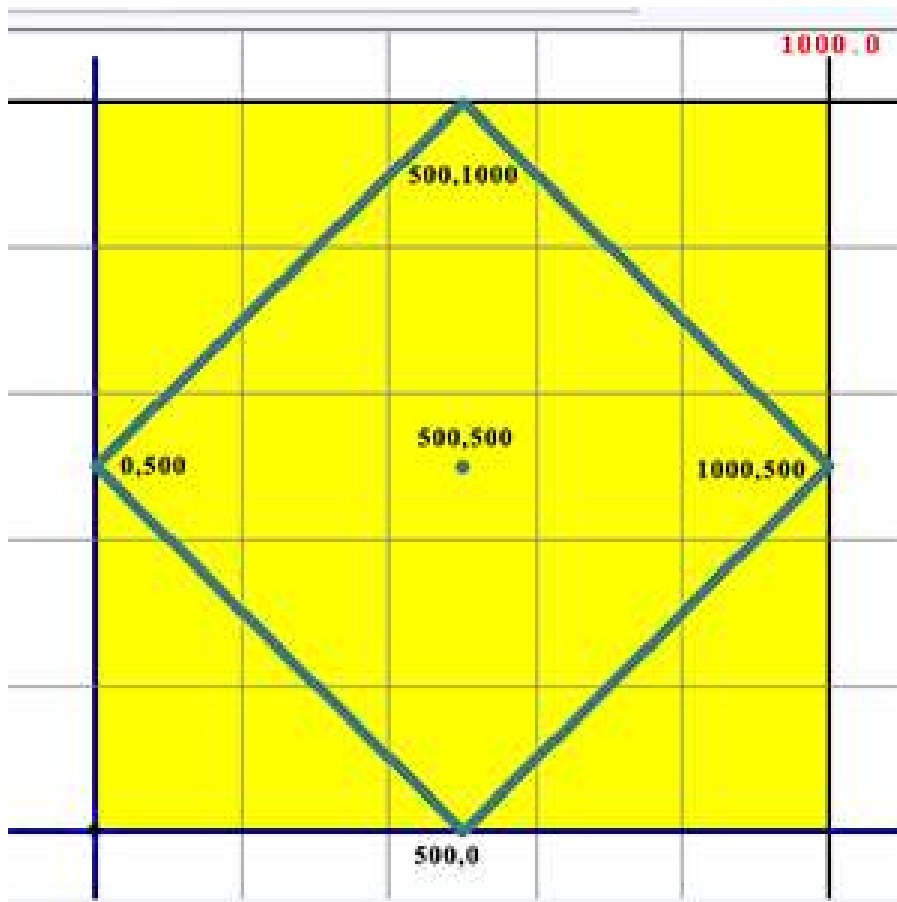
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N00 G71 G90;  
N01 G92 X0 Y0 Z5;  
N02 M06 T05;  
N03 M03 S800;  
N04 G01 X25 Y25 F100;  
N05 G01 Z-15;  
N06 G01 X75;  
N07 G01 Y75;  
N08 G01 X25;  
N09 G01 Y25;  
N10 G01 Z5;  
N11 G01 X0 Y0;  
N12 G01 M05 M02;
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N00 G71 G90;
N01 G92 X0 Y0 Z5;
N02 M06 T05;
N03 M03 S800;
N04 G01 Y45 F100;
N05 G01 Z-15;
N06 G01 X45;
N07 G01 Y0;
N08 G01 X55;
N09 G01 Y45;
N10 G01 X100;
N11 G01 Y55;
N12 G01 X55;
N13 G01 Y100;
N14 G01 X45;
N15 G01 Y55;
N16 G01 X0;
N17 G01 Y45;
N18 G01 Z5;
N19 G01 X0 Y0;
N20 M05 M02;

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N00 G71 G90;
N01 G92 X0 Y0 Z5;
N02 M06 T05;
N03 M03 S800;
N04 G01 X500 Y0 F100;
N05 G01 Z-15;
N06 G01 X1000 Y500;
N07 G01 X500 Y1000;
N08 G01 X0 Y500;
N09 G01 X500 Y0;
N10 G01 Z5;
N11 G81 Z-15;
N12 X500 Y500
N13 G80;
N14 G01 Z-15;
N15 G01 Z5;
N16 G01 X0 Y0;
N17 M05 M02;

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