**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



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;



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;



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;