hyatt cheat sheet		
motion	G0	Rapid positioning
motion	G1	Linear interpolation
motion	G2	Clockwise circular/helical interpolation
motion	G3	Counterclockwise circular/Helical interpolation
non-modal	G4	Dwell
non-modal	G10	Coordinate system origin setting
plane	G17	XY Plane select
plane	G18	XZ plane select
plane	G19	YZ plane select
unit	G20	Inch unit
unit	G21	Millimeter unit
non-modal	G28	Return home
non-modal	G28.1	Reference axes
non-modal	G30	Go Predefined Position
non-modal	G30.1	Set Predefined Position
probe	G31	Straight probe
probe	G38.2	probe toward workpiece, stop on contact, signal error if failure
probe	G38.3	probe toward workpiece, stop on contact
probe	G38.4	probe away from workpiece, stop on loss of contact, signal error if failure
probe	G38.5	probe away from workpiece, stop on loss of contact
cutter/tool	G40	Cancel cutter radius compensation
cutter/tool	G43.1	Apply tool length offset (plus)
cutter/tool	G49	Cancel tool length offset
non-modal	G53	Move in absolute machine coordinate system
coordinate	G54	Use fixture offset 1
coordinate	G55	Use fixture offset 2
coordinate	G56	Use fixture offset 3
coordinate	G57	Use fixture offset 4
coordinate	G58	Use fixture offset 5
coordinate	G59	Use fixture offset 6 / use general fixture number
motion	G80	Cancel motion mode (including canned cycles)
distance	G90	Absolute distance mode
distance	G91	Incremental distance mode
arc	G91.1	Arc IJK Distance Mode
non-modal	G92	Offset coordinates and set parameters
non-modal	G92.1	Cancel G92 etc.
feed	G93	Inverse time feed mode
feed	G94	Feed per minute mode
program	M0	Program stop
program	M1	Optional program stop
program	M2	Program end
spindle	M3	Rotate spindle clockwise
spindle	M4	Rotate spindle counterclckwise
spindle	M5	Stop spindle rotation
coolant	M7	Mist coolant on
coolant	M8	Flood coolant on
coolant	M9	All coolant off
program	M30	Program end and Rewind
setting	Tx	Tool select
setting	Sx	Spindle speed
setting	Fx	Feed rate
grbl	$G	View gcode parser state
grbl	$#	View gcode parameters
grbl	$H	Home cycle
grbl	$X	Kill alarm lock
grbl	?	Status Report Query
grbl	~	Cycle State/Resume
grbl	!	Feed hold