

List of G Codes

Code	Description
G00	Rapid Motion (appears as a dotted line in graphics)
G01	Straight Line Cutting Motion
G02	Circular Cutting Motion Clockwise (CW)
G03	Circular Cutting Motion Counter Clockwise (CCW)
G04	Dwell (ex. G04 x5.0 to dwell for 5 seconds)
G05	X Axis Mirror image (turns CRT read red when on)
G06	Y Axis Mirror image (turns CRT read red when on)
G08	X-Y Exchange (turn x,y,u,v to lower case letter when on)
G09	Cancels G05, G06, G08
G11	Block Skip On (activates Slash Code "/" in NC program)
G12	Block Skip Off
G13	AWT REF=1 (wire break recovery goes to G29/T91 threads and goes in with power settings C888)
G14	AWT REF=0 (message on CRT of broken Wire)
G15	AWT REF=2 (wire break recovery goes to G29/T91 threads and goes in with wire run & low pressure flush)
G22	Soft Limits turned On
G23	Soft Limits turned Off
G26	Pattern Rotation Turned on (ex G26 RA45.0 rotates program 45 degrees)
G27	Pattern Rotation Turned Off
G29	Thread Reference Point
G30	Returns to the Last G92 Location
G40	Wire Radius Compensation Canceled
G41	Wire Radius Compensation Left (walking behind wire)
G42	Wire Radius Compensation Right (walking behind wire)
G50	Taper Canceled
G51	Taper Left (relationship of upper head to lower head walking behind wire)
G52	Taper Right (relationship of upper head to lower head walking behind wire)
G54-G59	Work Coordinate System Numbers (resettable)
G154-G159	Work Coordinate System Numbers (resettable)
G254-G259	Work Coordinate System Numbers (resettable)
G354-G359	Work Coordinate System Numbers (resettable)
G454-G459	Work Coordinate System Numbers (resettable)
G545-G559	Work Coordinate System Numbers (resettable)
G654-G659	Work Coordinate System Numbers (resettable)
G754-G759	Work Coordinate System Numbers (resettable)
G854-G859	Work Coordinate System Numbers (resettable)
G954-G959	Work Coordinate System Numbers G958 is used for Codeless G959 is Machine Home

Code	Description
G74	4 Axis Program On X Y U V
G75	4 Axis Program Off
G80	Sensor Touch (ex. T80G80X+ move wire X+ until it makes contact)
G81	Move to Limits (ex. G81X+ moves machine to X+ limit)
G82	Move to Half of Axis Displayed
G83	Reads Current Position and Store to An H Register
G90	Absolute Program
G91	Incremental Program
G92	Assign Values to Axis Display in Current Work Coordinates
G97	Assign Values to Axis Display in All Work Coordinates except G959
G126	Coordinate Rotation On (KA45.0;G126)
G127	Coordinate Rotation Off
G140	4 axis offset off
G141	4 axis offset left
G142	4 axis offset right

T Codes

T80	Wire Drive On
T81	Wire Drive Off
T82	Worktank Drain Closed
T83	Worktank Drain Open
T84	High Pressure Flushing Mode On (high flush)
T85	High Pressure Flushing Mode Off (low flush)
T86	Flushing Pump On (lower pressure flush)
T87	Flushing Pump Off
T89	Switch to Non-submersed Machining
T90	Cut Wire Automatically
T91	Thread Wire Automatically
T94	Switch to Submersed Machining
T96	Worktank Fill Pump On
T97	Worktank Fill Pump Off
*	<i>Important Codes to Remember</i>

M Codes

M00	Program Stop (hard stop)
M01	Stop Optional
M02	End of Program (there is NO M30 end of program and rewind)
M05	Ignore Sensor Touch and Move
M36	Half Tank Door Height (AQ & AG Machines Only)
M46	Full Tank Door Height (AQ & AG Machines Only)
M98	Jump to Subprogram (ex M98P1000 jumps to N1000)
M99	Ends Subprogram and return to main program
M199	Ends Q-Routine and returns to main program