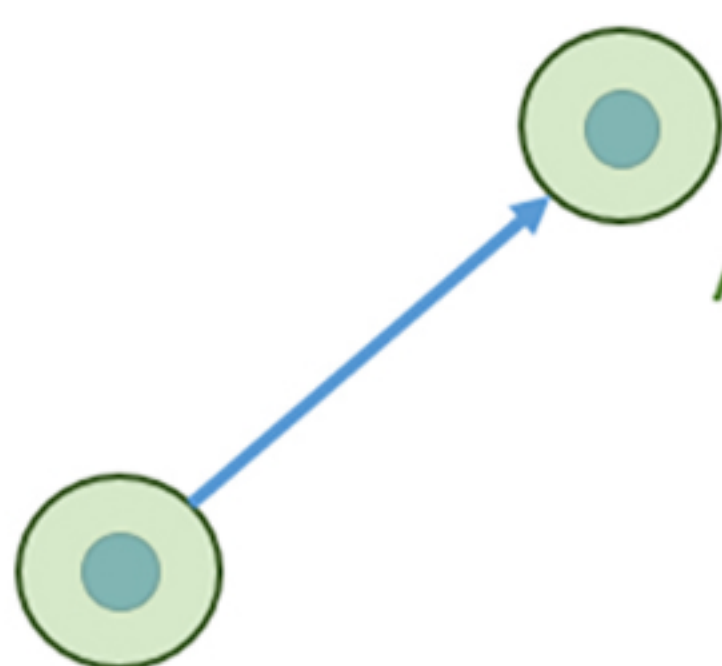


# G-Code Cheat Sheet

## G01 Straight Line Moves



Before: X=0 Y=0

After: X=1 Y=1

Example: G01 X1Y1  
Important:  
Moves at Feedrate!

## "F" is for Feedrate



Example: F100

Sets Feedrate to 100 IPM,  
or 100 whatever units  
your machine uses.

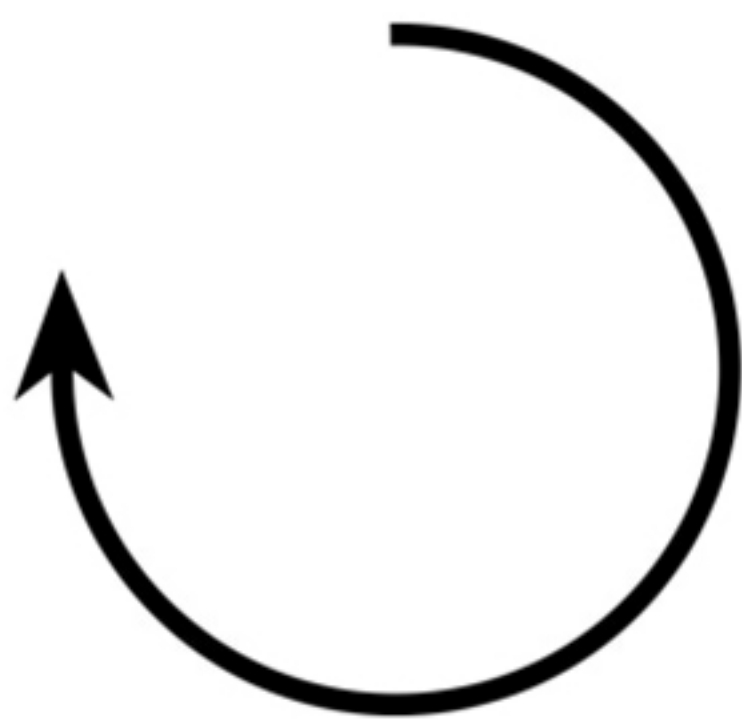
## S is for Spindle Speed (RPMs)



Example: S2000

Sets Spindle to 2000 RPM,  
but doesn't start it spinning

## M03 starts the spindle clockwise



Example: M03

Speed is whatever the last  
"S" word asked for

M05 will stop the spindle

## Coolant Options



On most machines:

- M07: Air Blast
- M08: Flood Coolant
- M09: Turn Off Coolant

## Tool Changes



On most machines:

- T03 asks for Tool #3
- M06 causes the toolchange

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## Peck Drilling



G83 XYZ R P Q F L

- XY: Coordinates of the hole
- Z: Hole bottom
- R: Retract position in Z. Motions from initial Z to R are performed at rapids speeds. From R to hole bottom is done at feed speed.
- P: Dwell time at bottom of hole.
- Q: Depth to increase on each peck.
- F: Cutting feedrate
- L: Number of repeats