

Codes Honored by the OmniTurn control

CI	CInnn.nn	Incremental spindle angle (optional - GT-75 only)
CA	CAnnn.nn	Absolute spindle angle (optional - GT-75 only)
C	XnZnCn	Automatic chamfer at intersection
D	Dn	Secondary offsets, axis correction or TNR comp value
F	Fn	Feedrates, dwell
LS	LSn	Loop start
LF	LF	Loop finish
R	XnZnRn	Automatic radius at intersection
S	Sn	Spindle speed, SFM or PRM
T	Tn	Tool offset call command
S	Sn	Spindle speed selection (optional), SFM or RPM
/	/	Block delete
}	}n	Subroutine jump to
G00	G00	Rapid move
G01	G01Fn	Feed move
G02	G02XnZnInKnFn or G02XnZnRn	Arc - Clockwise
G03	G03XnZnInKnFn or G03XnZnRn	Arc - Counter Clockwise
G04	G04Fn	Dwell
G10	G10XnZn	Work Shift
G33	G33XnZnInKnPOCn	Threading cycle
G34	G34ZnInKnP	Threading cycle, special single pass for course pitch
G35	G35n	Extra Course feeds in IPR
G36	G36	Cancles G35
G40	G40	Cancle Tool Nose Radius Compensation
G41	G41	Left hand Tool Nose Radius Compensation
G42	G42	Right hand Tool Nose Radius Compensation
G70	G70	Inch mode
G71	G71	Metric mode
G72	G72	Diameter programming mode
G73	G73	Radius programming mode
G74	G74XnZnInUnFn	Box Roughing cycle
G75	G75InUnFnPn	Box Contour Roughing cycle

G78	G78UnFnPn	Rough Contour Cycle
G76	G76Sn	Minimum spindle speed for constant surface feet
G77	G77Sn	Maximum spindle speed for constant surface feet
G81	G81ZnFn	Drill cycle
G83	G83ZnKnFn RnLnCn	Peck drill cycle
G90	G90	Absolute mode selection
G91	G91	Incremental mode selection
G92	G92XnZn	Preset axis position
G94	G94Fn	Inches per minute mode
G95	G95Fn	Inches per revolution mode
G96	G96Sn	Spindle speed set as surface feet
G97	G97	Spindle speed set as RPM
M00	M00	Program stop - cancels active “M” functions
M01	M01	Optional stop
M02	M02	End program - does not cancel “M” functions
M03	M03Sn	Spindle on, CW
M04	M04Sn	Spindle on, CCW
M05	M05	Spindle off, stop
M08	M08	Coolant on
M09	M09	Coolant off
M12	M12	Collet clamp
M13	M13	Collet unclamp
M19	M19	Spindle Positioning (optional - GT-75 only)
M25	M25	User assigned on
M26	M26	User assigned off
M30	M30	End of program - cancels all active “M” functions
M98	M98Pn	Jump to subroutine
M99	M99	Return at end of subroutine