

Haas CNC Milling G code List

G Code	Function
G00	Rapid Motion
G01	Linear Interpolation Motion
G02	CW Interpolation Motion
G03	CCW Interpolation Motion
G04	Dwell
G09	Exact Stop
G10	Programmable Offset Setting
G12	CW Circular Pock Milling (Yasnac)
G13	CCW Circular Pock Milling (Yasnac)
G17	XY Plane Selection
G18	ZX Plane Selection
G19	YZ Plane Selection
G20	Inch Programming Selection
G21	Metric Programming Selection
G28	Return to Machine Zero
G29	Move to Location Through G29 Reference
G31	Skip Function
G35	Automatic Tool Diameter Measurement
G36	Automatic Work Offset Measurement
G37	Automatic Tool Length Measurement
G40	Cutter Comp Cancel
G41	Cutter Compensation Left
G42	Cutter Compensation Right
G43	Tool Length Compensation +

G44	Tool Length Compensation –
G47	Engraving
G49	G43/G44 Cancel
G50	G51 Cancel
G51	Scaling
G52	Select Work Coordinate System G52 (Yasnac)
G52	Set Local Coordinate System (Fanuc)
G52	Set Local Coordinate System (HAAS)
G53	Non-Modal Machine Coordinate Selection
G54	Select Work Coordinate System 1
G55	Select Work Coordinate System 2
G56	Select Work Coordinate System 3
G57	Select Work Coordinate System 4
G58	Select Work Coordinate System 5
G59	Select Work Coordinate System 6
G60	Unidirectional Positioning
G61	Exact Stop Modal
G64	G61 Cancel
G65	Macro Subroutine Call
G68	Rotation
G69	G68 Cancel
G70	Bolt Hole Circle (Yasnac) Example1 Example2 Example3
G71	Bolt Hole Arc (Yasnac) Example
G72	Bolt Holes Along an Angle (Yasnac) Example
G73	High Speed Peck Drill Canned Cycle
G74	Reverse Tap Canned Cycle
G76	Fine Boring Canned Cycle

G77	Back Bore Canned Cycle
G80	Canned Cycle Cancel
G81	Drill Canned Cycle Example1 Example2 Ex3 Ex4 Ex5
G82	Spot Drill Canned Cycle Ex1
G83	Peck Drill Canned Cycle Ex1 Ex2
G84	Tapping Canned Cycle Example1 Peck Tapping
G85	Boring Canned Cycle
G86	Bore/Stop Canned Cycle
G87	Bore/Manual Retract Canned Cycle
G88	Bore/Dwell Canned Cycle
G89	Bore Canned Cycle
G90	Absolute
G91	Incremental
G92	Set Work Coordinates – FANUC or HAAS
G92	Set Work Coordinates – YASNAC
G93	Inverse Time Feed Mode ON
G94	Inverse Time Feed Mode OFF/Feed Per Minute ON
G98	Initial Point Return
G99	R Plane Return
G100	Disable Mirror Image
G101	Enable Mirror Image
G102	Programmable Output To RS-232
G103	Block Look ahead Limit
G107	Cylindrical Mapping
G110	Select Coordinate System 7
G111	Select Coordinate System 8

G112	Select Coordinate System 9
G113	Select Coordinate System 10
G114	Select Coordinate System 11
G115	Select Coordinate System 12
G116	Select Coordinate System 13
G117	Select Coordinate System 14
G118	Select Coordinate System 15
G119	Select Coordinate System 16
G120	Select Coordinate System 17
G121	Select Coordinate System 18
G122	Select Coordinate System 19
G123	Select Coordinate System 20
G124	Select Coordinate System 21
G125	Select Coordinate System 22
G126	Select Coordinate System 23
G127	Select Coordinate System 24
G128	Select Coordinate System 25
G129	Select Coordinate System 26
G136	Automatic Work Offset Center Measurement
G141	3D+ Cutter Compensation
G143	5 Axis Tool Length Compensation+
G150	General Purpose Pocket Milling
G153	5 Axis High Speed Peck Drill Canned Cycle
G154	P1-P99 Replaces G110-G129 on newer machines
G155	5 Axis Reverse Tapping Canned Cycle
G161	5 Axis Drill Canned Cycle
G162	5 Axis Spot Drill/Counterbore Canned Cycle

G163	5 Axis Peck Drill Canned Cycle (Setting 22)
G164	5 Axis Tapping Canned Cycle
G165	5 Axis Bore in, Bore out Canned Cycle
G166	5 Axis Bore in, Stop, Rapid out Canned Cycle
G169	5 Axis Bore, Dwell, Bore out Canned Cycle
G174	Special Purpose Non-Vertical Rigid Tapping CCW
G184	Special Purpose Non-Vertical Rigid Tapping CW
G187	Accuracy Control for High Speed Machining
G188	Get Program From PST (Program Schedule Table)