

# PDX CNC G-Code Cheat Sheet

COMMAND	DESCRIPTION	EXAMPLE
L110 T{t}	<b>Set new tool number</b> (changes WinCNC tool # w/o physical tool change)	L110 T3
L111 T{t}	<b>Check for tool</b> already loaded	L111 T3
L20	<b>Soft Limits On</b>	L20
L21	<b>CAUTION</b> - Soft Limits Off	L21
L29	<b>CAUTION</b> - Move without limits before homing	L29
M3	<b>Start Spindle</b>	M3
M5	<b>Stop Spindle</b>	M5
M11C1	<b>Release Tool</b>	M11C1
M12C1	<b>Clamp Tool / Stop Airflow</b> after T0	M12C1
M11C3	Toggle <b>Pop-Up</b> Alignment Pins	M11C3
G0	Linear move at <b>Rapid</b> speed	G0 X12Y24
G0.1	Rapid move with Vertical lift	G0.1
G1	Linear move at <b>Feed</b> speed	G0.1
G4	<b>Dwell</b> indefinitely - Enter or Start to resume	G4
G4 x {s}	<b>Dwell</b> for a specific amount of time	G4 x 2
G5 T# M"text"	T# : 0-4; 0=default, simple OKAY message box	G5 T0 M"How R U?"
G5 T1 M"text"	<b>1 = Abort</b> – Yes/No	G5 T1 M"Abort?"
G5 T2 M"text"	<b>2 = Continue</b> – Yes/No	G5 T2 M"Continue?"
G5 T3 M"text"	<b>3 = Run Next Command</b> – Yes/No	G5 T3 M"Run Next?"
G5 T4 M"text"	<b>4 = Skip to Next Command</b> – Yes/No	G5 T4 M"Skip to Next?"
G53 T{#} XY	Go to <b>XY tool load position</b> - <i>caution unsure if this will crash into rack</i>	
G53 T{#} Z	Spindle to <b>load height</b>	
G92	<b>Set Origin</b> at a specific location	G92 Z2
M98	Run another program in the middle of another	M98 DB-Clean.tap