

PLASMA TABLE PROGRAMMING REFERENCE

No	Command	Description
1	G99	ROTATION PROPORTION, MIRROR IMAGE
2	G92	REFERENCE COORDINATE
3	G91*	RELATIVE COORDINATES
4	G90	ABSOLUTE COORDINATES
5	G20	INCH UNITS
6	G21*	METRIC UNITS
7	G41	LEFT CUTTER COMP
8	G42	RIGHT CUTTER COMP
9	G40	CANCEL CUTTER COMP
10	G00	RAPID LINEAR MOVE
11	G1	FEED MOVE
12	G2	CIRCULAR MOVE, CLOCKWISE
13	G3	CIRCULAR MOVE, COUNTERCLOCKWISE
14	G4	PAUSE
15	M7	START CUTTING
16	M8	STOP CUTTING
17	M2	PROGRAM END

QUICK PROGRAM FORMAT

G92	(SETS CURRENT POSITION TO X0 Y0
G91	USE RALATIVE COORDINATE SYSTEM
G99	SETS SCALING, ANGLE AND MIRROR (OPT)
G41	TURN ON LEFT CUTTER COMP
M07	START CUTTING CYCLE
G20	SET UNITS TO INCH
G1	CUTTING MOVE
G2	CUTTING MOVE
G1	CUTTING MOVE
M8	END CUTTING CYCLE
G40	CANCEL CUTTER COMP
M2	END EPROGRAM

G99	X = SCALING FACTOR, Y= ANGLE (-360=360) I = MIRROR X AXIS J=MIRROR Y AXIS
G92	IF NO X,Y, SETS CURRENT POS TO 0,0. IF X,Y ARE NON ZERO, SETS NEW START OFFSET
G91*	SETS RELATIVE COORDINATES
G90	SETS ABSOLUTE COORDINATES
G20	SETS UNITS TO INCHES
G21*	SETS UNITS TO MILLIMETER
G41	LEFT CUTTER COMP
G42	RIGHT CUTTER COMP
G40	CANCEL CUTTER COMP
G00	RAPID MOVE
G1	LINEAR FEED MOVE (I,J MAKES RELATIVE MOVE IF IN G90)
G2	CLOCKWISE FEED MOVE X,Y = COORDINATES OF END POINT, I,J = COORDINATES OF CENTER POINT (REL)
G3	COUNTER CLOCKWISE FEED MOVE X,Y = COORDINATES OF END POINT, I,J = COORDINATES OF CENTER POINT (REL)
G4	DWELL
M7	BEGIN TORCH CUTTING CYCLE (TORCH IGNITES, LOWERS TO PART HEIGHT)
M8	END TORCH CUTTING CYCLE (TORCH CUTS OFF, RAISES TO HOME POSITION)
M2	PROGRAM END

* ASTERISK INDICATES DEFAULT MODE