Iso

ISO codes

Primitive	ISO	Nota
Rapid	G00	Movement at rapid speed
Line	G01	Line
CW circle	G02	Clockwise Arc (final point and center)
CCW circle	G03	C-clockwise Arc (final point and center)
Delay	G04	G04 K2.5 is a delay of 2.5 seconds
Kerf	G40, G41, G42	Kerf compensation left side on\off value set in P19
Absolute	G90	Quotes referred to te origin
Incremental	G91	Quotes referred to te lasts
Counter	G100	Profile counter
Plasma On	M50	Start cut.
Plasma Off	M51	End cut.
HC enable	M52	Enables the high control if it is been disabled by M53
HC disable	M53	Disable the high control, it will be enabled automatically by next M50 (if not disabled by the user).
Enable Torches	M54 [En]	Enable torch En. To enable two torches: M54 E1 M54 E2
Disable Torches	M55 [En]	M55 disable the all the cutting torches. M55 En disable the head n, Es: M54 E1 Disable the first torch
Plasma sw\off	M56	Switch off the plasma arc without axes stop
Ignore sw-off	M57	Ignore if the plasma switches off by itself
Point	M58	If plasma selected it does only the piercing, if marker selected it does only a marking point.
	M59	WaterJet machines only
Reset technologies	M60	Disables all the selected technologies.
	M61	Oxyfuel
Enable plasma	M62 [Qn]	Enables plasma technology. M62 Q1 selects parameters 1, M62 Q2 selects parameters 2, …
Enable marker	M63	Select marking technology tecnologia di marcatura (bulino, marcatore a polvere, pennarello, …).
WaterJet	M64	Activate waterjet technology
	M68	Enable pipe cutting (option)
Active parameters	M98	Activate al the parameters set by means of P variables
Save parameters	M98 [Qn]	Save the parameters on the "n" table. Es: M98 Q1 -> save the parameters (previous P=...) on the table 1 M98 Q2 -> save the parameters (previous P=...) on the table 2 The parameters between brackets [] are optional and should be