

G Code Programming G1

- G1 can also be written as G01.
- This means feed in a straight line.
- A feed-rate would be required
- G1 X50. F200. (Feed to X50. at 200 mm per minute)
- Three four and 5 axes can all be programmed at once.
- G1 X50. Y50. Z-20. F200. (Three axis move)
- You always need a feed-rate with G1. Use an F word.
- The control will pick up the last commanded feed-rate.
- An alarm will occur if no feed-rate is active.
- Feed-rate stays in control until it is changed or the control is switched off.
- When machine is first switched on it has no feed-rate.
- F500. Feed at 500 mm per minute.
- G1 always has an endpoint and machine will feed from where it is to this point in a straight line.