

G Code Programming G2 and G3

- G2 and G3 can also be written as G02 and G03.
- G2 is a clockwise arc.
- G3 is a counter clockwise arc.
- For G2 and G3 an endpoint and a radius are required.
- G2 X50. Y50. R20. (X50. Y50. are the endpoint the radius is 20mm)
- You can put any radius between two points provided it is physically possible to fit the radius in.
- If you try to fit a small radius between two points that will not fit the machine will generate an alarm.
- The alarm will say “end point not found”.
- You can machine a full circle with G2 and G3.
- The control looks at your current position and fits a radius between that and the endpoint you give.
- The radius is not always tangential to the last straight line.