

, ..... 1  
(Chamfer) ..... 1  
(Round) ..... 2

### (Chamfer)

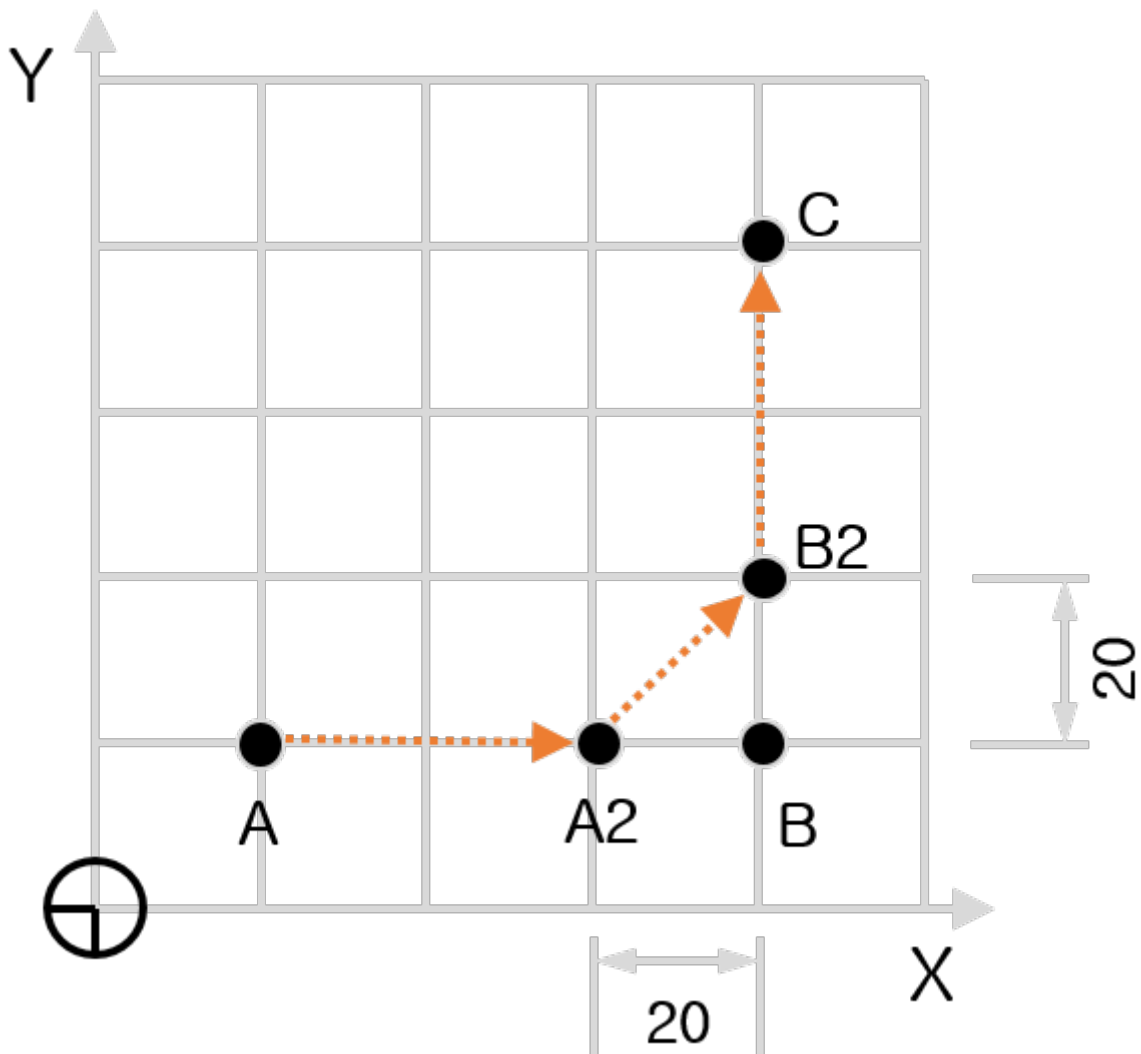
#### Summary

- 

#### Format

- G01 X\_Y\_C\_

#### Description



- A → A2 → B2 → C

```
G90
G01 X20 Y20 //( → A)
G01 X60 //(A → A2)
G01 X80 Y40 //(A2 → B2)
G01 Y80 //(B2 → C)
```

- A → A2 → B2 → C

```
G90
G01 X20 Y20 //( → A)
G01 X80 C20 //(A → B2, )
G01 Y80 //(B2 → C)
```

### Example

The screenshot shows a CNC emulator interface. On the left, a code editor window titled 'main.g' displays the following G-code program:

```
1 O123456
2
3 M98 P1000
4 M02
5
6 P1000
7
8 G90 F5
9 G01 X20Y0
10 G01 X100 C20
11 G01 Y60 C20
12 G01 X0 C20
13 G01 Y0 C20
14 G01 X20Y0
15
```

On the right, the 'Emulator' window shows a 2D coordinate system with a grid. The vertical axis is labeled 'Ch 1' and the horizontal axis is labeled 'Ch 0'. A red line represents the tool path, starting at the origin (0,0), moving to (20,0), then to (100,60), then to (0,60), and finally back to (20,0). A red square marker is positioned at the origin (0,0), and a red circle marker is at (20,0). The text '0 0000' is visible near the origin.

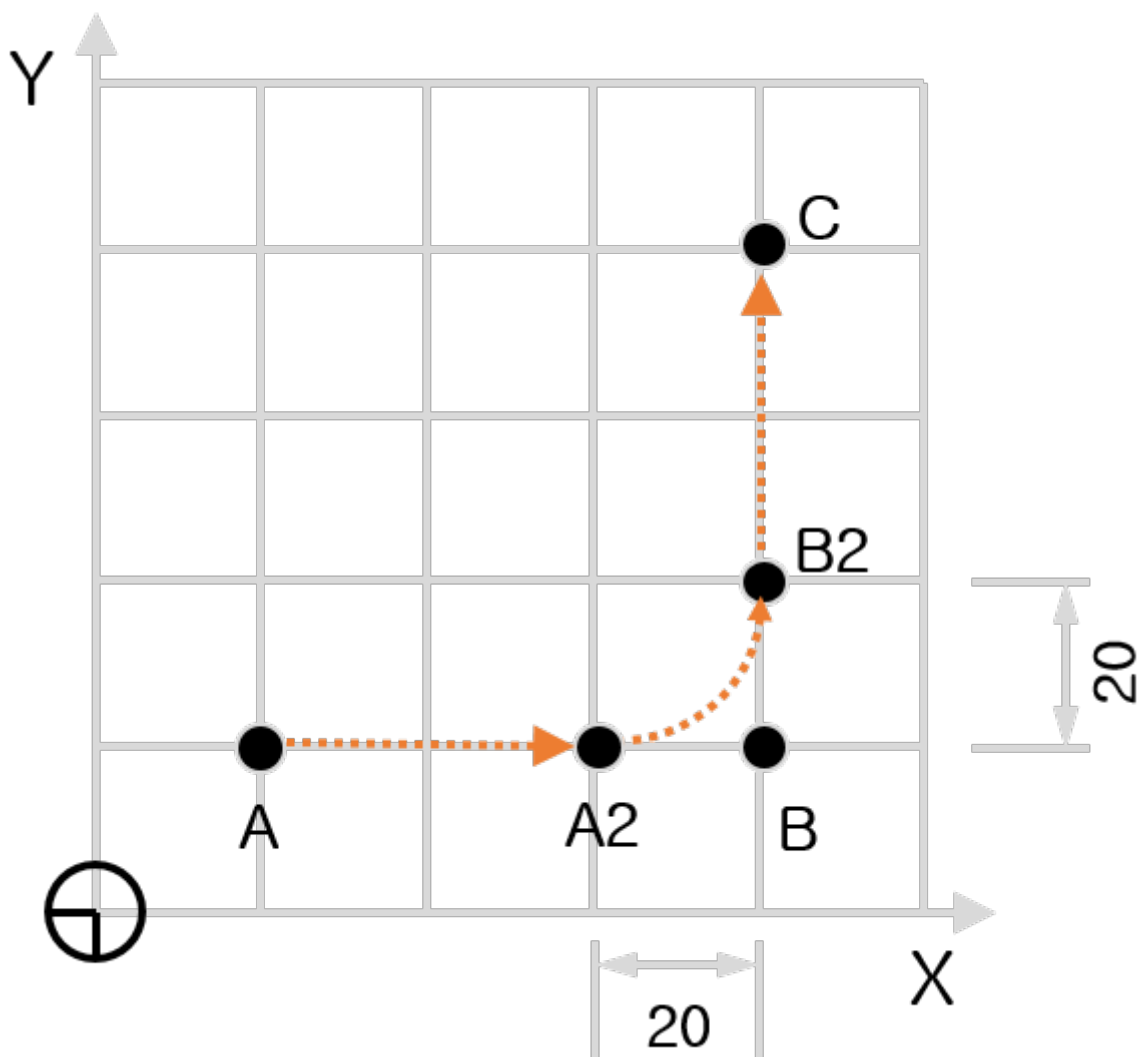
(Round)

### Summary

**Format**

- G01 X\_Y\_R\_

**Description**



- A → A2 → B2 → C

```
G90
G01 X20 Y20      //(    → A)
G01 X60          //(A → A2)
G03 X80 Y40 R20  //(A2 → B2)
G01 Y80          //(B2 → C)
```

- A → A2 → B2 → C

```
G90
G01 X20 Y20 //( → A)
G01 X80 R20 //(A → B2, )
G01 Y80 //(B2 → C)
```

### Example

The screenshot shows a G-code editor window titled 'main.g' with the following code:

```
1 O123456
2
3 M98 P1000
4 M02
5
6 P1000
7
8 G90 F5
9 G01 X20Y0
10 G01 X100 R20
11 G01 Y60 R20
12 G01 X0 R20
13 G01 Y0 R20
14 G01 X20Y0
15
```

To the right is an 'Emulator' window displaying a 2D coordinate system with axes labeled 'Ch 0' (horizontal) and 'Ch 1' (vertical). A red path is plotted on a grid, starting at the origin (0,0), moving right to X=20, then following a quarter-circle arc with a radius of 20 to Y=60, then moving left to X=0, and finally moving down to Y=0. The path ends at (20,0). Tick marks on the X-axis are labeled '0-0000' and '20000'.

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