

AUX CODE	EXPLANATION
100	MIRROR X
200	MIRROR Y
300	MIRROR X & Y
400	MIRROR Z
500	MIRROR X & Z
600	MIRROR Y & Z
700	MIRROR X, Y, & Z
800	CANCEL ALL MIRRORS
900	DOUBLE X, Y, & Z
1000	TURN ON CONTOURING
1101	ENABLE ZERO SHIFT
1110	DISABLE OUTER LIMIT
1111	SET AND ENABLE SOFTWARE LIMIT SWITCHES
1112	ENABLE OUTER LIMIT
1113	SET LIMITS ONLY
1114	DISABLE INNER LIMIT
1115	SET AND ENABLE INNER LIMIT SWITCHES
1116	ENABLE INNER LIMITS
1117	SET LIMITS ONLY
1121	SEEK FIRST ZERO CROSSING ON X AXIS
1122	SEEK FIRST ZERO CROSSING ON Y AXIS
1124	SEEK FIRST ZERO CROSSING ON Z AXIS
1131	SEEK LIMIT SWITCH, REVERSE AND STOP AT FIRST ZERO CROSSING ON X
1132	SEEK LIMIT SWITCH, REVERSE AND STOP AT FIRST ZERO CROSSING ON Y
1134	SEEK LIMIT SWITCH, REVERSE AND STOP AT FIRST ZERO CROSSING ON Z
1141	ENABLE ZERO CROSSING ON X AXIS
1142	ENABLE ZERO CROSSING ON Y AXIS
1144	ENABLE ZERO CROSSING ON Z AXIS
1150	DISABLE SHIFTED OUTER LIMIT
1151	SET AND ENABLE SHIFTED LIMIT
1152	ENABLE SHIFTED OUTER LIMIT
1153	SET LIMITS ONLY
1154	DISABLE SHIFTED INNER LIMIT
1155	SET AND ENABLE SHIFTED INNER LIMIT
1156	ENABLE SHIFTED INNER LIMIT
1157	SET LIMITS ONLY
1160	DISABLE BACKLASH COMPENSATION
1161	SET AND ENABLE BACKLASH COMPENSATION
1162	ENABLE BACKLASH COMPENSATION
1165	DISABLE LIMITS ON U AND W (G-ONLY)
1166	SET AND ENABLE LIMITS ON U AND W (G-ONLY)
1167	ENABLE LIMITS ON U AND W (G-ONLY)
1168	SET LIMITS U AND W (G-ONLY)
1170	EXECUTE FOR DISPLAY OF ABSOLUTE COORDINATE
1171	EXECUTE TO STOP DISPLAY OF ABSOLUTE COORDINATE
1200	DISABLE LATHE MODE
1201	DISABLE LATHE MODE
1210	ENABLE AXIAL THREADING
1211	ENABLE RADIAL THREADING
1212	DISABLE AXIAL TURNING
1213	ENABLE AXIAL TURNING

1300	CANCEL AXIS SWAPING
1310	SWAP X & Y AXIS
1311	SWAP Y & Z AXIS
1312	SWAP X & Z AXIS
1313	ENABLE Z PLANE RETRACT IN G80 CYCLES
1314	DISABLE Z PLANE RETRACT IN G80 CYCLES
1400	DISABLE FEED RATE OVERRIDE FOR RAPID MOVES
1401	ENABLE FEED RATE OVERRIDE FOR RAPID MOVES
1410	CANCEL VECTORIAL RAPID MODE
1411	SET VECTORIAL RAPID MODE
1420	CLEAR BOTH (Z & FEED) MOVE INHIBIT
1421	SET Z MOVE INHIBIT
1422	CLEAR Z MOVE INHIBIT
1423	SET FEED MOVE INHIBIT
1424	CLEAR FEED MOVE INHIBIT
1425	SET BOTH (Z & FEED) MOVE INHIBIT
1440	SET RAPID SPEED (V01=X & Y, V02=Z)
1500	ENABLE PROGRAM ENTER MODE
1501	DISABLE PROGRAM ENTER MODE
1600	DISABLE DRY RUN MODE
1601	ENABLE DRY RUN WITH CUTTER COMPENSATION
1602	ENABLE DRY RUN WITHOUT CUTTER COMPENSATION
1603	SIMULATION OFF
1604	SIMULATION ON
1606	BEEPER ON FOR KEYS
1607	CLEAR DRIFT REGISTERS
1608	DISPLAY AVAILABLE MEMORY
1609	CLEAR HANDWHEEL MODE
1610	SET HANDWHEEL MODE
1611	SYSTEM WARM RESET (M ONLY)
1612	COLD START (M ONLY)
1613	MOVE DEFAULT FIELD MODS TO SHARED MEMORY (G-ONLY)
1614	TERMINATE MOVE (G-ONLY)
1615	PRESET AXIS FOR A MANUAL STEP (G-ONLY)
1800	BREAK OUT OF DO LOOP IF 'V0' NOT ZERO
1801	BREAK OUT OF DO LOOP IF 'V1' NOT ZERO
1802	BREAK OUT OF DO LOOP IF 'V2' NOT ZERO
1803	BREAK OUT OF DO LOOP IF 'V3' NOT ZERO
1804	BREAK OUT OF DO LOOP IF 'V4' NOT ZERO
1805	BREAK OUT OF DO LOOP IF 'V5' NOT ZERO
1806	BREAK OUT OF DO LOOP IF 'V6' NOT ZERO
1807	BREAK OUT OF DO LOOP IF 'V7' NOT ZERO
1808	BREAK OUT OF DO LOOP IF 'V8' NOT ZERO
1809	BREAK OUT OF DO LOOP IF 'V9' NOT ZERO
1810	SET INFINITE LOOP
1900	SINGLE STEP BY EVENT (DEFAULT)
1901	SINGLE STEP BY MOTION
2000	TURN OFF CONTOURING MODE
2100	TURN OFF LOW GAIN AT TARGET MODE
2101	TURN ON DRIFT
2102	TURN OFF DRIFT
2110	TURN OFF AC TARGET DRIFT

2111	SET AC DRIFT GAIN / 246 (LOWEST)
2112	SET AC DRIFT GAIN / 128
2113	SET AC DRIFT GAIN / 64
2114	SET AC DRIFT GAIN / 32
2115	SET AC DRIFT GAIN / 16
2116	SET AC DRIFT GAIN / 8 (HIGHEST)
2200	TURN ON LOW GAIN AT TARGET MODE
2500	TURN OFF "Z AXIS READOUT ONLY" MODE
2600	TURN ON "Z AXIS READOUT ONLY" MODE
2700	WRITE TO RS-232 DEVICE IN RS-274 FORMAT
2701	RECEIVE FROM RS-232 DEVICE IN RS-274 FORMAT
2702	WRITE TO RS-232 DEVICE IN ANILAM FORMAT
2711	ENABLE CONTINUOUS DOWNLODE MODE
2740	RS-232 LOOP BACK TEST
2754	USE RS-244-A (ISO) CHARACTER SET
2758	USE RS-258 (ASCII) CHARACTER SET
2765	SET 5 BITS PER CHARACTER
2766	SET 6 BITS PER CHARACTER
2767	SET 7 BITS PER CHARACTER
2768	SET 8 BITS PER CHARACTER
2770	SET NO PARITY
2771	SET ODD PARITY
2772	SET EVEN PARITY
2780	SET BAUD RATE TO 110 BITS PER SECOND
2781	SET BAUD RATE TO 150 BITS PER SECOND
2782	SET BAUD RATE TO 300 BITS PER SECOND
2783	SET BAUD RATE TO 600 BITS PER SECOND
2784	SET BAUD RATE TO 1200 BITS PER SECOND
2785	SET BAUD RATE TO 1800 BITS PER SECOND
2786	SET BAUD RATE TO 2400 BITS PER SECOND
2787	SET BAUD RATE TO 4800 BITS PER SECOND
2788	SET BAUD RATE TO 9600 BITS PER SECOND
2789	SET BAUD RATE TO 19200 BITS PER SECOND
2790	SET NO HANDSHAKE
2791	SET SOFTWARE HANDSHAKE (X ON X OFF)
2792	SET HARDWARE HANDSHAKE (DTR, DSR)
2800	CONVERT FROM 13 BYTE FORM TO COMPACT FORM
2801	CONVERT FROM COMPACT FORM TO 13 BYTE FORM
2900	PACK PROGRAM TO SHORTEST FORM
4000	V xx (- SCALED V xx)
4300	ADD WITHOUT TYPE CONVERT
4400	SUBTRACT WITHOUT TYPE CONVERT
4500	MULTIPLY WITH TYPE CONVERT
4600	DIVIDE WITH TYPE CONVERT
9000	STORE FEED RATE AND POSITION IN V REGISTER
9000	V26 (- actual X coordinates)
9000	V27 (- actual Y coordinates)
9000	V28 (- actual Z coordinates)
9000	V29 (- programmed FEED RATE)
9030	CANCEL MOLD ROTATION
9031	MOLD ROTATION ON X
9032	MOLD ROTATION ON Y

9033	MOLD ROTATION ON Z
9090	CANCEL X, Y, AND Z EXPANSION IN G8Xx CYCLE
9093	CLEAR UNITS/REV EXPANSION
9094	ENABLE UNITS/MIN MODE
9095	ENABLE UNITS/REV MODE
17XX	FILL REG XX WITH SPINDLE DIRECTION