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NC functions with syntax acc. to DIN 66025

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NC function name			Group	Description
Name	Short form	Alias		
↘ G0	-	G00 G000	Interpolation	Straight line interpolation (rapid traverse)
↘ G1	-	G01 G001	Interpolation	Straight line interpolation (feed)
↘ G2	-	G02 G002	Geometry	Motion on a circular path in clockwise rotation
↘ G3	-	G03 G003	Geometry	Motion on a circular path in counterclockwise rotation
↘ G8	-	-	Path slope	Path slope ON Based on the Motion command: *opt-cont-motion* with payload {"permType": "PermOn"}
↘ G9	-	-	Path slope	Path slope OFF Based on the Motion command: *opt-cont-motion* with payload {"permType": "PermOff"}
↘ G16	-	-	Active plane	Active plane off

NC function name			Group	Description
Name	Short form	Alias		
↘ G17 (G17-19)	-	-	Active plane	Select active plane XY, ZX or YZ
↘ G47	-	-	Tool length correction	Switching on tool length correction Based on the Motion command: *opt-pcs-tool* with payload {"permType": "PermOn"}
↘ G48	-	-	Tool length correction	Switching off tool length correction Based on the Motion command: *opt-pcs-tool* with payload {"permType": "PermOff"}
↘ G53	-	-	Zero offset	All zero offsets OFF
↘ G54	-	-	Zero offset	Motion command option PCS set (group) G54 ON
↘ G55	-	-	Zero offset	Motion command option PCS set (group) G55 ON
↘ G56	-	-	Zero offset	Motion command option PCS set (group) G56 ON
↘ G57	-	-	Zero offset	Motion command option PCS set (group) G57 ON
↘ G58	-	-	Zero offset	Motion command option PCS set (group) G58 ON

NC function name			Group	Description
Name	**Short form**	**Alias**		
↘ G59	-	-	Zero offset	Motion command option PCS set (group) G59 ON
↘ G90	-	-	Programming mode	Absolute dimension programming
↘ G91	-	-	Programming mode	Relative dimension programming
↘ G94	-	-	Feed mode	Programming (mm/min)
↘ G152				G152(SET = <setName>) Enabling the product coordinate system with set (group) names
↘ G153				Switching off product coordinate system