

Letter	Meaning
A	A-axis of machine
B	B-axis of machine
C	C-axis of machine
D	tool radius compensation number
F	feedrate
G	general function (see Table 5)
H	tool length offset index
I	X-axis offset for arcs X offset in G87 canned cycle
J	Y-axis offset for arcs Y offset in G87 canned cycle
K	Z-axis offset for arcs Z offset in G87 canned cycle
L	number of repetitions in canned cycles key used with G10
M	miscellaneous function (see Table 7)
N	line number
P	dwel time in canned cycles dwel time with G4 key used with G10
Q	feed increment in G83 canned cycle
R	arc radius canned cycle plane
S	spindle speed
T	tool selection
X	X-axis of machine
Y	Y-axis of machine
Z	Z-axis of machine
Table 3. Word-starting Letters	