

## Siemens - Fanuc Code Comparisons

Any commands not listed below are the same on both controls

Siemens Code	Description	Fanuc Code
G04 F2.0	Dwell	G04 X2.0
G70 -or-INCHMODE	Inch mode	G20
G71 -or-METRICMODE	Metric mode	G21
CLAMPCONTROL	Opens clamps	M97
CLAMPLOCATION	Scans clamps	O9100
CLAMPVERIFY (X,Y)	Verifies clamps	G178X20.0Y48.0
CLEAROFFSET	Clears <b>all</b> offsets	M31
FORMINGMODEOFF	Forming OFF	M42
FORMINGMODEON	Forming ON	M41
INCHMODE	Inch mode	G70
MARKINGMODEON	Marking on	M40
MARKINGMODEOFF	Marking off	M42
METRICMODE	Metric mode	G21
PARTDOOR	Part door cycle	M80
PRESET(X,Y)	Preset command	G92X0.0Y0.0
PUNCHOFF	Punch OFF	M85
PUNCHON	Punch ON	M75
RAMREPO(X)	Repo with ram	G176X10.0
REPOSITION(X)	Reposition	G175X10.0
RESTOREOFFSET	Restore repo offset	M29
SETCUTMODE	Prep torch to cut	None
SETMARKMODE-----	Prep torch to mark	None
TAPMODE-----	Tap/Drill ON	M23
TAPCANCEL-----	Tap/Drill OFF	M25
TAPCHANGE-----	Move Y to -60"	None
TOOLCHANGE("Name")-	Tool change	T2M06
TOOLDEPOSIT-----	Active tool to rail	G188
TOOLPICKUP(X)-----	Use after Deposit	G178X2.
TOOLPOCKET(X)-----	Tool change	T02M06
TORCHOFF-----	Turns torch off	M18
TORCHON-----	Ignites torch	M17
TORCHSETTING(X,Y)---	Set up torch	M100A200.0D0.5
YVUNSYNC-----	Parks the V-axis	G160Y-48.0
YVSYNC-----	Re-synch Y and V	G161

**Part Handler II™ Specific User Cycles**

Siemens Code	Description	Fanuc Code
EDGEFIND-----	Aligns material	M189
MATLTHK-----	Verify thickness	None
RAWLOAD-----	Performs auto load	M171
STOCK_TABLE-----	Platen to stock	None