SS	0-99999(rpm)	Specify Speed of 2nd Spindle
F	0.01-15000mm/min	Feedrate per minute
	0.001-500mm/r	Feedrate per rev
	0.1~1000mm	Thread Lead in Metric
X	±99999.999mm	Coordinates in X directtion
	0~9999.999(s)	Dwell time
U	±99999.999mm	Increment in X directtion
	Finish allowance in X direction in G71,G72,G73	
	Cutting depth in G71	
	Moving distance of tool retraction in X direction in G73	
Z	±99999.999mm	Coordinates in Z directtion
W	±99999.999mm	Increment in Z directtion
	Finish allowance in Z direction in G71,G72,G73	
	Cutting depth in G72	
	Moving distance of tool retraction in Z direction in G73	
I	00-99 teeth/inch	Thread Lead in Inch
	±99999.999mm	Vector of arc center relative to starting point I in X direction
K	±99999.999mm	Vector of arc center relative to starting point in Z direction
R	0.001-99999.999mm	Arc radius
	Moving distance of cycle tool retraction in G71,G72	
	Cycle times of roughing in G73	
	Moving distance of tool retraction after Cutting in G74, G75	
	Moving distance of tool retraction after cutting to the end point in G74, G75	
	Finishing allowance in G76	
	Taper in G90, G92, G94, G96	
P	0.001-65s	Dwell time
	0000-99999	Calling subprogram number
	Circular moving distance in X direction in G74, G75	
	Thread cutting parameter in G76	
	Initial block number of finishing in the compound cycle instruction	
L	1~9999	Cycle times
	1~9999	Cycle times of calling subprogram
	1-99	Heads of multi-head thread
T	0000-9999	Tool function
M	00-99	Auxiliary function output, program executed flow, subprogram call
	880-889	User-defined M Macro Function
/	Program skip	

Block: a group of commands at each step of the sequence.

The program consists of a group of blocks for a series of machining. The number for discriminating each block is called the sequence number, and the number for discriminating each program is called the program number.

The block and the program have the following configurations.