#### 5.12 M CODES

Table 5-2: M code list

CODE	FUNCTION	NOTES
M0	Unconditional N C stop	
M1	Conditional NC stop	
M(2	NC program end	
M3	Spindle CW	
M4	Spindle CCW	
MIS	Spindle Stop	
M16	Execute tool change	
M7	Activate Coolant 1	7
MS	Activate Coolant 2	
M9	5 top all coolant	
M11	Set current tool pocket number to 1	Used to re-synchronize tool magazine
M19	O rient tool and lock	
M31	Exchange pallet	Reserved
M32	C all pallet A	Reserved
M33	C all parlet 8	Reserved
M34	U rioad pallet	Reserved
M40	Spindle auto gear range change	
M41	Spindle change to low gear	
M42	Spindle change to high gear	
M52	Air;Oil oil Priming	Air/Oil oil pump cycled once
M60	Set M60,M 61 output	Misc. M. Function. Apply A axis brake.
M61	R es et M60,M61 output	Misc. M Function. Release A axis brake
M62	Set M62,M 63 output	Misc. M Function. Apply B axis brake.
M63	R es et M62/M63 output	Misc. M Function. Release B axis brake
M64	Set M64,M65 output	Misc. M Function. Also probe 1
M65	R es et M64,M65 output	Misc. M Function. Also probe 2
M66	Set M66,M 67 output	Misc. M Function
M67	R es et M66/M67 output	Misc. M Function

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**Thomas C. Scanlan** 



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