M - Code

M00	PROGRAM STOP	M55 CHUCK LOW PRESSURE *
M01	OPTIONAL PROGRAM STOP	M56 QUILL FORWARD
M02	PROGRAM END	M57 QUILL REVERS
M03.	SPINDLE CW	M58 TAILSTOCK FORWARD*
M04	SPINDLE CCW	M59 TAILSTOCK REVERS*
M05	SPINDLE STOP	M60 BAR FEEDER*
M06	TOOL CHANGE AT HOME POSITION (FOR SIEMENS)	M61 PART CATCHER UP*
M07	CTS(HIGH PRESSURE COOL) ON'	M62 - PART CATCHER DOWN'
* M08	COOLANT ON	M63 AUTO DOOR OPEN*
M09	ALL COOL OFF	M64 AUTO DOOR CLOSE*
M10	SPAN FILTER ON*	M65 QUILL/TAILSTOCK IN USE
M11	SPAN FILTER OFF*	M66 QUILL/TAILSTOCK NOT IN USE
M14	AIR/OIL MIST ON	M68 AXIS MOVEMENT POSSIBLE WITH CHUCK DECLAMP ON
M15	AIRIOIL MIST OFF*	M69 AXIS MOVEMENT POSSIBLE WITH CHUCK DECLAMP OFF
M16	TOOL CHANGE AT ANY POSITION (FOR SIEMENS)	M71 SPINDLE BRAKE CLOSE (FOR TMC)*
M17	, SUB PROGRAM END	M72 SPINDLE BRAKE OPEN (FOR TMC)*
M19	MAIN SPINDLE ORIENTATION	M73 AIR SEAT CONFIRMATION ON*
M20	LIVE TOOL ORIENTATION (FOR TMC)*	M74 AIR SEAT CONFIRMATION OFF*
M30	PROGRAM END	M81 STEADY REST CLAMP*
M32	SHOPTURN PROGRAM END	M82 STEADY REST DECLAMP*
M33	TOOL PROBE DOWN*	M83 JOB PROBE ON:
M34	TOOL PROBE UP'	M84 JOB PROBE OFF*
M41	SPINDLE GEAR STAGE 1*	M91 2nd STEADY REST CLAMP*
	SPINDLE GEAR STAGE 2*	M92 2nd STEADY REST DECLAMP*
M42		M94 Steady Rest Engage/Unlock*
M50	CHUCK CLAMP	M95 Steady Rest Disengage/lock*
M51	CHUCK DECLAMP	M96 Tailstock Engage/Unlock*
M52	CHIP CONVEYOR ON	M97 Talistock Disengage/lock*
M53	CHIP CONVEYOR OFF	* OPTIONAL
M54	CHUCK HIGH PRESSURE *	

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