

NC LATHE M-CODE LIST

M-CODE	DESCRIPTION	REMARK	M-CODE	DESCRIPTION	REMARK
M00	PROGRAM STOP		M39	STEADY REST 1 UNCLAMP	OPTION
M01	OPTIONAL STOP		M40	GEAR CHANGE NETURAL	
M02	PROGRAM END		M41	GEAR CHANGE LOW	
M03	MAIN-SPINDLE FORWARD		M42	GEAR CHANGE MIDDLE	
M04	MAIN-SPINDLE REVERSE		M43	GEAR CHANGE HIGH	
M05	MAIN-SPINDLE STOP		M46	PTS BODY UNCL & TRACT-BAR ADV.	OPTION
M07	HIGH PRESSURE COOLANT ON	OPTION	M47	PTS BODY CL & TRACT-BAR RET.	OPTION
M08	COOLANT ON		M50	BAR FEEDER COMMAND 1	OPTION
M09	COOLANT OFF		M51	BAR FEEDER COMMAND 2	OPTION
M10	PARTS CATCHER ADVANCE	OPTION	M52	SPLASH GUARD DOOR OPEN	OPTION
M11	PARTS CATCHER RETRACT	OPTION	M53	SPLASH GUARD DOOR CLOSE	OPTION
M13	TURRET AIR BLOW	OPTION	M54	PARTS COUNT	OPTION
M14	MAIN-SPINDLE AIR BLOW	OPTION	M58	STEADY REST 2 CLAMP	OPTION
M15	AIR BLOW OFF	OPTION	M59	STEADY REST 2 UNCLAMP	OPTION
M17	MACHINE LOCK ACT	(ONLY) M0	M61	SWITCHING LOW SPEED (N.J)	CL P60
M18	MACHINE LOCK CANCEL	(ONLY) M0	M62	SWITCHING HIGH SPEED (N.J)	CL P60
M19	MAIN-SPINDLE ORIENTATION	OPTION	M63	MAIN-SPDL CW & COOLANT ON	
M24	CHIP CONVEYOR RUN	OPTION	M64	MAIN-SPDL CCW & COOLANT OFF	
M25	CHIP CONVEYOR STOP	OPTION	M65	MAIN-SPDL & COOLANT OFF	
M30	PROGRAM END & REWIND		M66	DUAL CHUCKING LOW CLAMP	OPTION
M31	INTERLOCK BY-PASS(SPDL &T/S)		M67	DUAL CHUCK HIGH CLAMP	OPTION
M32	INTERLOCK BY-PASS(SPDL &S/R)	3 AXIS	M68	MAIN-CHUCK CLAMP	
M33	REV-TOOL-SPINDLE FORWARD	3 AXIS	M69	MAIN-CHUCK UNCLAMP	
M34	REV-TOOL-SPINDLE REVERSE		M70	DUAL TAIL STOCK LOW ADVANCE	OPTION
M35	REV-TOOL-SPINDLE STOP		M74	ERROR DETECT ON	
M38		OPTION	M75	ERROR DETECT OFF	

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Rachel Sandford



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Industrial Development CIDESI in Queretaro Mexico He now researches the new product design and development for military application machinery robotics and medical devices in the Faculty of Medicine at the Autonomous University of Mexico State UAEMex and the Faculty of Engineering at UAEMex as part of the Researchers for Mexico program CONACYT

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Byoung Kyu Choi, DongHun Kang, 2013-09-30
Computer modeling and simulation M S allows engineers to study and analyze complex systems Discrete event system DES M S is used in modern management industrial engineering computer science and the military As computer speeds and memory capacity increase so DES M S tools become more powerful and more widely used in solving real life problems Based on over 20 years of evolution within a classroom environment as well as on decades long experience in developing simulation based solutions for high tech industries Modeling and Simulation of Discrete Event Systems is the only book on DES M S in which all the major DES modeling formalisms activity based process oriented state based and event based are covered in a unified manner A well defined procedure for building a formal model in the form of event graph ACD or state graph Diverse types of modeling templates and examples that can be used as building blocks for a complex real life model A systematic easy to follow procedure combined with sample C codes for developing simulators in various modeling formalisms Simple tutorials as well as sample model files for using popular off the shelf simulators such as SIGMA ACE and Arena Up to date research results as well as research issues and directions in DES M S Modeling and Simulation of Discrete Event Systems is an ideal textbook for undergraduate and graduate students of simulation industrial engineering and computer science as well as for simulation practitioners and researchers **G & M Codes**, 2002

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1. Understanding the eBook Mazatrol M Codes
 - The Rise of Digital Reading Mazatrol M Codes
 - Advantages of eBooks Over Traditional Books
2. Identifying Mazatrol M Codes
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Mazatrol M Codes
 - User-Friendly Interface
4. Exploring eBook Recommendations from Mazatrol M Codes
 - Personalized Recommendations
 - Mazatrol M Codes User Reviews and Ratings
 - Mazatrol M Codes and Bestseller Lists
5. Accessing Mazatrol M Codes Free and Paid eBooks
 - Mazatrol M Codes Public Domain eBooks
 - Mazatrol M Codes eBook Subscription Services
 - Mazatrol M Codes Budget-Friendly Options
6. Navigating Mazatrol M Codes eBook Formats

- ePub, PDF, MOBI, and More
- Mazatrol M Codes Compatibility with Devices
- Mazatrol M Codes Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Mazatrol M Codes
 - Highlighting and Note-Taking Mazatrol M Codes
 - Interactive Elements Mazatrol M Codes
- 8. Staying Engaged with Mazatrol M Codes
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Mazatrol M Codes
- 9. Balancing eBooks and Physical Books Mazatrol M Codes
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Mazatrol M Codes
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Mazatrol M Codes
 - Setting Reading Goals Mazatrol M Codes
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Mazatrol M Codes
 - Fact-Checking eBook Content of Mazatrol M Codes
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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