

## 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<br>G21) | M61    | SWITCHING LOW SPEED (N.J)      | GE P10 |
| M18    | MACHINE LOCK CANCEL           | (ONLY<br>G21) | M62    | SWITCHING HIGH SPEED (N.J)     | GE P10 |
| 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) | 1 AXIS        | M68    | MAIN-CHUCK CLAMP               |        |
| M33    | REV-TOOL-SPINDLE FORWARD      | 1 AXIS        | M69    | MAIN-CHUCK UNCLAMP             |        |
| M34    | REV-TOOL-SPINDLE REVERSE      |               | M70    | DUAL TAILSTOCK LOW ADVANCE     | OPTION |
| M35    | REV-TOOL-SPINDLE STOP         |               | M74    | ERROR DETECT ON                |        |
| M38    |                               | OPTION        | M75    | ERROR DETECT OFF               |        |

# M Codes For Fanuc Ot Control

**T. Takamori, K. Tsuchiya**



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