

NC LATHE M-CODE LIST

M-CODE	DESCRIPTION	REMARK	M-CODE	DESCRIPTION	REMARK
M00	PROGRAM STOP		M20	STEADY REST 1 UNCLAMP	OPTION
M01	OPTIONAL STOP		M40	GEAR CHANGE RETURN	
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 & TRACTOR ADV	OPTION
M07	HIGH PRESSURE COOLANT ON	OPTION	M47	PTS BODY CL & TRACTOR 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	OPTION NO	M61	SWITCHING LOW SPEED (N.L)	OR RS
M18	MACHINE LOCK CANCEL	OPTION N.L	M62	SWITCHING HIGH SPEED (N.L)	OR RS
M19	MAIN SPINDLE ORIENTATION	OPTION	M63	MAIN SPID ON & COOLANT ON	
M24	CHIP CONVEYOR RUN	OPTION	M64	MAIN SPID OFF & COOLANT OFF	
M25	CHIP CONVEYOR STOP	OPTION	M65	MAIN SPID & COOLANT OFF	
M30	PROGRAM END & REWIND		M68	DUAL CHUCKING LOW CLAMP	OPTION
M31	INTERLOCK BY PASS SPID & T.S		M67	DUAL CHUCK HIGH CLAMP	OPTION
M32	INTERLOCK BY PASS SPID & BAR	1443	M68	MAIN CHUCK CLAMP	
M33	MAIN TOOL SPINDLE FORWARD	1443	M69	MAIN CHUCK UNCLAMP	

Use All
M-CODES
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Decoding **M Codes In Cnc Machines**: Revealing the Captivating Potential of Verbal Expression

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