

CODE LIST OF M COMMANDS      ○-STANDARD    ☆-OPTION

| M<br>CODE | FUNCTION                   | ZL-15S |     | ZL-15SH |     | ZL-15SHC |     |
|-----------|----------------------------|--------|-----|---------|-----|----------|-----|
|           |                            | MAIN   | SUB | MAIN    | SUB | MAIN     | SUB |
| M00       | PROGRAM STOP               | ○      | ○   | ○       | ○   | ○        | ○   |
| M01       | OPTIONAL STOP              | ○      | ○   | ○       | ○   | ○        | ○   |
| M02       | END OF PROGRAM             | ○      | ○   | ○       | ○   | ○        | ○   |
| M03       | NORMAL SPINDLE POSITION    | ○      | ○   | ○       | ○   | ○        | ○   |
| M04       | REVERSE SPINDLE POSITION   | ○      | ○   | ○       | ○   | ○        | ○   |
| M05       | SPINDLE STOP               | ○      | ○   | ○       | ○   | ○        | ○   |
| M06       | COOLANT PUMP ON            | ○      | ○   | ○       | ○   | ○        | ○   |
| M08       | COOLANT PUMP OFF           | ○      | ○   | ○       | ○   | ○        | ○   |
| M10       | ORICE CLAMP                | ○      | ○   | ○       | ○   | ○        | ○   |
| M11       | ORICE UNCLAMP              | ○      | ○   | ○       | ○   | ○        | ○   |
| M13       | NORMAL KILLING POSITION    |        |     | ○       |     | ○        |     |
| M14       | REVERSE KILLING POSITION   |        |     | ○       |     | ○        |     |
| M17       | NORMAL TIGHT POSITION      | ○      | ○   | ○       | ○   | ○        | ○   |
| M18       | REVERSE TIGHT POSITION     | ○      | ○   | ○       | ○   | ○        | ○   |
| M19       | SPINDLE ORIENTATION        | ☆      | ☆   | ○       | ☆   | ☆        | ☆   |
| M20       | SPINDLE ORIENTATION CANCEL | ○      | ○   | ○       | ○   | ○        | ○   |
| M23       | CHANGING IN                | ○      | ○   | ○       | ○   | ○        | ○   |
| M24       | CHANGING OFF               | ○      | ○   | ○       | ○   | ○        | ○   |
| M26       | ID-POSITION CHECK ON       | ○      | ○   | ○       | ○   | ○        | ○   |
| M28       | ID-POSITION CHECK OFF      | ○      | ○   | ○       | ○   | ○        | ○   |
| M30       | RESET & REWIND             | ○      | ○   | ○       | ○   | ○        | ○   |
| M31       | INTERLOCK ID-POS ON        | ○      | ○   | ○       | ○   | ○        | ○   |
| M32       | INTERLOCK ID-POS OFF       | ○      | ○   | ○       | ○   | ○        | ○   |
| M35       | SYNCHRONOUS OPERATION IN   |        | ○   |         | ○   |          | ○   |
| M36       | SYNCHRONOUS OPERATION OFF  |        | ○   |         | ○   |          | ○   |

|      |     |      |  |        |      |         |                                                                                                  |
|------|-----|------|--|--------|------|---------|--------------------------------------------------------------------------------------------------|
|      |     |      |  |        |      | TYPE    | ZL-15S, SH, SHC                                                                                  |
|      |     |      |  |        |      |         | OF S-O T T 80                                                                                    |
|      |     |      |  |        |      | DATE    | 20 12 98                                                                                         |
|      |     |      |  |        |      |         |                                                                                                  |
| DATE | SAT | DEAN |  | CHANGE | WFLY | APPROVE |  MARY SEARY |

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**Yicheng Fang**



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