

## 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>M0 | M61    | SWITCHING LOW SPEED (N.J)      | Cl P60 |
| M18    | MACHINE LOCK CANCEL            | (ONLY)<br>M0 | M62    | SWITCHING HIGH SPEED (N.J)     | Cl P60 |
| M19    | MAIN-SPINDLE ORIENTAION        | 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(S/SPDL &T/S) |              | M67    | DUAL CHUCK HIGH CLAMP          | OPTION |
| M32    | INTERLOCK BY-PASS(S/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               |        |

# M Code List For Mazak Lathe

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