

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 G21)	M61	SWITCHING LOW SPEED (N.J)	OR P10
M18	MACHINE LOCK CANCEL	(ONLY G21)	M62	SWITCHING HIGH SPEED (N.J)	OR 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

**Pawan Negi,Mangey Ram,Om Prakash
Yadav**

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Table of Contents M Codes For Fanuc Ot Control

1. Understanding the eBook M Codes For Fanuc Ot Control
 - The Rise of Digital Reading M Codes For Fanuc Ot Control
 - Advantages of eBooks Over Traditional Books
2. Identifying M Codes For Fanuc Ot Control
 - 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 M Codes For Fanuc Ot Control
 - User-Friendly Interface
4. Exploring eBook Recommendations from M Codes For Fanuc Ot Control
 - Personalized Recommendations
 - M Codes For Fanuc Ot Control User Reviews and Ratings
 - M Codes For Fanuc Ot Control and Bestseller Lists
5. Accessing M Codes For Fanuc Ot Control Free and Paid eBooks
 - M Codes For Fanuc Ot Control Public Domain eBooks

- M Codes For Fanuc Ot Control eBook Subscription Services
- M Codes For Fanuc Ot Control Budget-Friendly Options
- 6. Navigating M Codes For Fanuc Ot Control eBook Formats
 - ePub, PDF, MOBI, and More
 - M Codes For Fanuc Ot Control Compatibility with Devices
 - M Codes For Fanuc Ot Control Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of M Codes For Fanuc Ot Control
 - Highlighting and Note-Taking M Codes For Fanuc Ot Control
 - Interactive Elements M Codes For Fanuc Ot Control
- 8. Staying Engaged with M Codes For Fanuc Ot Control
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers M Codes For Fanuc Ot Control
- 9. Balancing eBooks and Physical Books M Codes For Fanuc Ot Control
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection M Codes For Fanuc Ot Control
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine M Codes For Fanuc Ot Control
 - Setting Reading Goals M Codes For Fanuc Ot Control
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of M Codes For Fanuc Ot Control
 - Fact-Checking eBook Content of M Codes For Fanuc Ot Control
 - 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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