M05	Spindle Stop
M06	Tool Change
M07	Mist Coolant On
80M	Flood Coolant On
M09	Coolant Off
M19	Spindle Orientation On
M20	Spindle Orientation Off
M21	Tool Magazine Right
M22	Tool Magazine Left
M23	Tool Magazine Up
M24	Tool Magazine Down
M25	Tool Clamp
M26	Tool Unclamp
M27	Clutch Neutral On
M28	Clutch Neutral Off
M30	End Program, Stop and Rewind
M98	Call Sub Program
M99	End Sub Program

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