

3.1

M-CODE

As the code for ON/OFF of auxiliary functions, they are classified by function as follows and differ from each other machine because of its specifications.

NOTICE

1. Function continue A : function valid until cancel or change in other block
2. Function continue B : Function valid only in the block

M-CODE	FUNCTION	Function start		REMARK
		A	B	
M00	PROGRAM STOP		O	
M01	OPTIONAL BLOCK STOP		O	
M02	PROGRAM END		O	
M03	SPINDLE CLOCKWISE ROTATION(CW)	O		
M04	SPINDLE COUNTER CLOCKWISE ROTATION (CCW)	O		
M05	SPINDLE ROTATION STOP		O	
M06	AUTOMATIC TOOL CHANGE		O	
M07	THROUGH THE SPINDLE COOLANT ON	O		TSC/TTC
M08	FLOOD COOLANT ON	O		
M09	COOLANT OFF		O	
M10	TABLE(B-AXIS) CLAMP	O		4-Axis (TABLE)
M11	TADLE(D-AXIS) UNCLAMP	O		4-Axis (TABLE)
M12	SHOWER COOLANT	O		
M13				
M14	AIR BLOWING ON	O		
M15	AIR BLOWING OFF	O		
M16				
M17				
M18				
M19	SPINDLE ORIENTATION	O		
M20				
M21				
M22				
M23				
M24	CHIP CONVEYOR RUN	O		
M25	CHIP CONVEYOR STOP	O		
M26				
M27				

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