

List of M-codes

Code	Description	Milling (M)	Turning (T)
M00	Compulsory stop	M	T
M01	Optional stop	M	T
M02	End of program	M	T
M03	Spindle on (clockwise rotation)	M	T
M04	Spindle on (counterclockwise rotation)	M	T
M05	Spindle stop	M	T
M06	Automatic tool change (ATC)	M	T (some-times)
M07	Coolant on (mist)	M	T
M08	Coolant on (flood)	M	T
M09	Coolant off	M	T
M13	Spindle on (clockwise rotation) and coolant on (flood)	M	
M19	Spindle orientation	M	T
M21	Mirror, X-axis	M	
M21	Tailstock forward		T
M22	Mirror, Y-axis	M	
M22	Tailstock backward		T
M23	Mirror OFF	M	
M23	Thread gradual pullout ON		T
M24	Thread gradual pullout OFF		T
M30	End of program, with return to program top	M	T
M41	Gear select – gear 1		T
M42	Gear select – gear 2		T
M43	Gear select – gear 3		T
M44	Gear select – gear 4		T
M48	Feedrate override allowed	M	T
M49	Feedrate override NOT allowed	M	T
M52	Unload Last tool from spindle	M	T
M60	Automatic pallet change (APC)	M	
M98	Subprogram call	M	T
M99	Subprogram end	M	T

Vtu Cim Lab Manual

Frederick A. Stearns



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