

# Lathe M-code

Ref	new codes since last release		released: Oct 13	
Man	Code	Functional explanation	Option Specification	
p	pgm	M0000	Program Stop	standard
p	pgm	M0001	Optional Stop	standard
p	pgm	M0002	End of Program	standard
p	pgm	M0003	Spindle CW	standard
p	pgm	M0004	Spindle CCW	standard
p	pgm	M0005	Spindle Stop	standard
p	mult	M0006	Tool Change	ATC specification
		M0007		
p	cool	M0008	Coolant 1 ON	standard
p	cool	M0009	Coolant 1 OFF	standard
p	list	M0010	Spindle jog OFF	standard
p	list	M0011	Spindle jog ON	standard
p	pgm	M0012	M-tool spindle Stop	Multiple machine
p	pgm	M0013	M-tool spindle CW	Multiple machine
p	pgm	M0014	M-tool spindle CCW	Multiple machine
p	pgm	M0015	C-axis positioning (positive direction)	Multiple machine
p	pgm	M0016	C-axis positioning (negative direction)	Multiple machine
p	gag	M0017	Request for data transfer	Post-process guaging (RS232C/CEJ MATIC)
p	list	M0018	Oriented spindle stop Cancel	Spindle orientation
p	spc	M0019	Oriented spindle position 1	Spindle orientation
	2spH	M0020	Oriented spindle position 2	OGL
p	pgm	M0020	Tailstock barrier or Spindle interference monitoring OFF	standard
p	pgm	M0021	Tailstock barrier or Spindle interference monitoring ON	standard
p	pgm	M0022	Chamfering OFF	standard
p	pgm	M0023	Chamfering ON	standard
p	pgm	M0024	Chuck barrier OFF, Tool interference OFF	standard
p	pgm	M0025	Chuck barrier ON, Tool interference ON	standard
p	spc	M0026	Thread lead along Z-axis	Arc thread cutting
p	spc	M0027	Thread lead along X-axis	Arc thread cutting
p	2452	M0028	Tool interference check function OFF	standard
p	2452	M0029	Tool interference check function ON	standard
p	pgm	M0030	End of Program	standard
		M0031		
p	pgm	M0032	Straight infeed along thread face mode (on left face)	standard
p	pgm	M0033	Zig-zag infeed in thread cutting	standard
p	pgm	M0034	Straight infeed along thread face mode (on right face)	standard
p	3816	M0035	Loader gripper Z-slide Retract	OSL-2 Okuma Simple Loader (7000)
p	3816	M0036	Loader gripper Z-slide Advance	OSL-2 Okuma Simple Loader (7000)
p	3816	M0037	Loader arm Retract	OSL-2 Okuma Simple Loader (7000)
p	3816	M0038	Loader arm Advance to unloading position	OSL-2 Okuma Simple Loader (7000)
p	3816	M0039	Loader arm Advance to chuck position	OSL-2 Okuma Simple Loader (7000)
p	pgm	M0040	Spindle gear range Neutral	standard
p	pgm	M0041	Spindle gear range 1 or low-speed coil selection	standard
p	pgm	M0042	Spindle gear range 2 or high-speed coil selection	standard
p	pgm	M0043	Spindle gear range 3	Spindle gear more than 2 ranges
p	pgm	M0044	Spindle gear range 4	Spindle gear more than 3 ranges
p	list	M0045	OSL Unloading gripper Retract	
p	list	M0046	OSL Unloading gripper Advance	
		M0047		
p	pgm	M0048	Spindle Override ignore cancel	standard
p	pgm	M0049	Spindle Override ignore	standard
p	air	M0050	Airblow B OFF	Additional Air
p	air	M0051	Airblow B ON	Additional Air
		M0052		
		M0053		
p	spc	M0054	Index Chuck Auto Index	Index chuck
p	pgm	M0055	Tailstock spindle Retract	Center work
p	pgm	M0056	Tailstock spindle Advance	Center work
p	oper	M0057	Cancel of M63	Cycle time reduction
p	spc	M0058	Chucking pressure LOW	Chuck high/low pressure selection by M codes
p	spc	M0059	Chucking pressure HIGH	Chuck high/low pressure selection by M codes
p	pgm	M0060	Cancel of M61	Cycle time reduction
p	pgm	M0061	Ignoring fixed speed arrival in constant speed cutting	Cycle time reduction
p	oper	M0062	Cancel of M64	Cycle time reduction
p	oper	M0063	Ignoring spindle rotation M-code Answer	Cycle time reduction
p	oper	M0064	Ignoring general M-code Answer	Cycle time reduction
p	oper	M0065	Ignoring T-code Answer	Cycle time reduction
p	oper	M0066	Turret indexing position free	Cycle time reduction
p	cam	M0067	Synchronized mode cancel in cam turning cycle	Cam turning

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Man	Code	Functional explanation	Option Specification	
p	cam	M0068	Synchronized mode A ON	Cam turning
p	cam	M0069	Synchronized mode B ON	Cam turning
p	list	M0070	Manual tool change command (7000)	ATC specification
		M0071		
	4795	M0072	ATC unit positioning at approach position (7000)	ATC specification
p	pgm	M0073	Thread cutting pattern 1	standard
p	pgm	M0074	Thread cutting pattern 2	standard
p	pgm	M0075	Thread cutting pattern 3	standard
p	spc	M0076	Parts Catcher Retract	Parts catcher
p	spc	M0077	Parts Catcher Advance	Parts catcher
p	spc	M0078	Steady Rest Unclamp	Steady rest
p	spc	M0079	Steady Rest Clamp	Steady rest
p	list	M0080	Overcut advance	
p	list	M0081	Overcut retract	
p	list	M0082	Chip discharge Monitoring ON	
p	pgm	M0083	Chuck Clamp	standard
p	pgm	M0084	Chuck Unclamp	standard
p	pgm	M0085	No return to the cutting start point after the rough turn cycle	LAP
p	pgm	M0086	Turret indexing direction reverse	standard
p	pgm	M0087	Cancel of M86	standard
p	air	M0088	Airblow A OFF	standard
p	air	M0089	Airblow A ON	standard
p	spc	M0090	Front Door OR Cover Close	Automatic cover open/close
p	spc	M0091	Front Door OR Cover Open	Automatic cover open/close
p	4193	M0092	Bar feeder retract	Bar feeder
p	spc	M0093	Bar feeder advance	Bar feeder
p	2538	M0094	Loader loading	Loader Interlock function
p	2538	M0095	Loader unloading	Loader Interlock function
p	AB11	M0096	Parts catcher for sub spindle retract	Parts catcher
p	AB11	M0097	Parts catcher for sub spindle advance	Parts catcher
p	spc	M0098	Tailstock spindle thrust low	Tailstock spindle high/low thrust selection by M code
p	spc	M0099	Tailstock spindle thrust high	Tailstock spindle high/low thrust selection by M code
p	pgm	M0100	Waiting synchronization command	standard
p	spc	M0101	External M code	External M codes
p	spc	M0102	External M code	External M codes
p	spc	M0103	External M code	External M codes
p	spc	M0104	External M code	External M codes
p	spc	M0105	External M code	External M codes
p	spc	M0106	External M code	External M codes
p	spc	M0107	External M code	External M codes
p	spc	M0108	External M code	External M codes
p	pgm	M0109	Cancel of M110	Multiple turning
p	pgm	M0110	C-axis joint	Multiple turning
p	list	M0111	Automatic zero point setting for pick-off spindle	
p	list	M0112	M-tool spindle on the 3rd turret stop	
p	list	M0113	M-tool spindle on the 3rd turret forward rotation	
p	list	M0114	M-tool spindle on the 3rd turret reverse rotation	
p	list	M0115	Unloader open	Unloader
p	list	M0116	Unloader close	Unloader
p	gag	M0117	Sensor head advance	Touch setter
p	gag	M0118	Sensor head retract	Touch setter
p	spc	M0119	Work count special	Special specification
p	3816	M0120	No Work confirmation	No Work Monitoring
p	6119	M0121	Steady rest close end	Steady rest
p	spc	M0122	Steady rest retract	Steady rest
p	spc	M0123	Steady rest advance	Steady rest
p	pgm	M0124	STM time over check ON	STM time over check
p	pgm	M0125	STM time over check OFF	STM time over check
p	air	M0126	Airblow D OFF	Additional Air
p	air	M0127	Airblow D ON	Additional Air
p	list	M0128	Tailstock swing retract	Special specification
p	list	M0129	Tailstock swing advance	Special specification
p	spc	M0130	Chucking error detecting air OFF	Chucking error detection
p	spc	M0131	Chucking error detecting air ON	Chucking error detection
p	spc	M0132	Chucking error detection OFF	Chucking error detection
p	spc	M0133	Chucking error detection ON	Chucking error detection
p	3816	M0134	Z-axis thrust monitoring OFF	Overload monitor
p	3816	M0135	Z-axis thrust monitoring ON	Overload monitor
p	pgm	M0136	Designation of multiple fixed cycle configuration (not modal)	Multiple turning

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Man	Code	Functional explanation	Option Specification	
p	gag	M0137	Touch setter interlock release ON	Touch setter
p	gag	M0138	Touch setter interlock release OFF	Touch setter
p	cam	M0139	Lead machining function - learning operation	Cam turning
p	pgm	M0140	Tapping cycle M-tool constant rotation answer ignored	Multiple turning
p	pgm	M0141	C-axis clamp or not selection (not modal)	Multiple turning
p	spc	M0142	Coolant pressure low	Coolant high/low pressure <b>Select</b> by M codes
p	spc	M0143	Coolant pressure high	Coolant high/low pressure <b>Select</b> by M codes
p	cool	M0144	Additional Coolant 1 OFF	Additional coolant
p	cool	M0145	Additional Coolant 1 ON	Additional coolant
p	pgm	M0146	C-axis unclamp	Multiple turning
p	pgm	M0147	C-axis clamp	Multiple turning
h	lst2	M0148	Steady rest Barrier OFF (NC-B)	
h	lst2	M0148	Tailstock index pin OUT (PLC-B)	Tailstock Index pin control
h	lst2	M0149	Steady rest Barrier ON (NC-B)	
h	lst2	M0149	Tailstock index pin IN (PLC-B)	Tailstock Index pin control
p	sub	M0150	Synchronized rotation OFF	Opposing two-spindle
p	sub	M0151	Synchronized rotation ON	Opposing two-spindle
p	pgm	M0152	M-tool spindle interlock ON	Multiple turning
p	pgm	M0153	M-tool spindle interlock OFF	Multiple turning
p	air	M0154	Airblow C OFF	Additional Air
p	air	M0155	Airblow C ON	Additional Air
p	pgm	M0156	Center work interlock ON	Center work
p	pgm	M0157	Center work interlock OFF	Center work
p	list	M0158	Lead machining function - synchronized operation OFF	Special specification
p	list	M0159	Lead machining function - synchronized operation ON	Special specification
p	pgm	M0160	Cancel of M161	standard
p	pgm	M0161	Feedrate override fix (100%)	standard
p	pgm	M0162	Cancel of M163	Multiple turning
p	pgm	M0163	M-tool spindle speed override fix (100%)	Multiple turning
p	pgm	M0164	Cancel of M165	standard
p	pgm	M0165	Ignoring slide hold and single block	standard
p	pgm	M0166	Ignoring tailstock spindle advance/retract interlock OFF	Center work
p	pgm	M0167	Ignoring tailstock spindle advance/retract interlock ON	Center work
p	list	M0168	Loading Mode OFF (Dust Collecting duct Up)	
p	lvt	M0168	Transfer mode OFF	Vertical lathe machine(LVT)
p	list	M0169	Loading Mode ON (Dust Collecting duct Down)	
p	lvt	M0169	Transfer mode ON	Vertical lathe machine(LVT)
p	vtr	M0170	C-Axis brake release mode ON	C-axis brake release function
p	vtr	M0171	C-Axis brake release mode OFF	C-axis brake release function
p	list	M0172	Robot inside the lathe interlock release OFF	NC robot
p	list	M0173	Robot inside the lathe interlock release ON	NC robot
p	cool	M0174	Additional Coolant 2 OFF (H1 turret Thru spindle)	Additional coolant
p	cool	M0175	Additional Coolant 2 ON (H1 turret Thru spindle)	Additional coolant
p	list	M0176	Y-axis unclamp	Y-axis
		M0176		
p	list	M0177	Y-axis clamp	Y-axis
		M0177		
p	5083	M0178	Stopper advance, Damping Rest Advance	Double Cylinder Chuck spec
	lstE	M0178	Tailstock Chuck Clamp, Damping Rest Retract	
p	5083	M0179	Stopper retract	Double Cylinder Chuck spec
	lstE	M0179	Tailstock Chuck Unclamp	
p	spc	M0180	Robot/loader request 1	NC robot/loader, robot/loader interface type B/C/D/E
p	spc	M0181	Robot/loader request 2	NC robot/loader, robot/loader interface type B/C/D/E
p	spc	M0182	Robot/loader request 3	NC robot/loader, robot/loader interface type B/C/D/E
p	spc	M0183	Robot/loader request 4	NC robot/loader, robot/loader interface type B/C/D/E
p	pgm	M0184	Chuck internal interlock release OFF	Chuck open/close interlock by M codes
p	pgm	M0185	Chuck internal interlock release ON	Chuck open/close interlock by M codes
p	air	M0186	Airblow F OFF	Additional Air
p	air	M0187	Airblow F ON	Additional Air
p	spc	M0188	Tailstock joint OFF	Tow-along programmable tailstock
p	spc	M0189	Tailstock joint ON	Tow-along programmable tailstock
p	spc	M0190	Designation of G00 possible with tailstock joint	Tow-along programmable tailstock
p	3810	M0191	M-tool spindle orientation direction specified CW	Multiple turning
p	3810	M0192	M-tool spindle orientation direction specified CCW	Multiple turning
p	spc	M0193	Cancel of M194	Phase matching function for thread cutting
p	spc	M0194	Phasing for thread cutting	Phase matching function for thread cutting
p	spc	M0195	Cancel of M196	Phase matching function for thread cutting
p	spc	M0196	Thread cutting phasing stroke effective	Phase matching function for thread cutting
p	spc	M0197	Thread cutting phasing stroke clear	Phase matching function for thread cutting

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Man	Code	Functional explanation	Option Specification	
p	list	M0198	STM Cycle Over ON	
p	list	M0199	STM Cycle Over OFF	
p	4373	M0200	Z-axis synchronized feeding cancel	Z-axis synchronized feeding
p	4373	M0201	Z-axis synchronized feeding G13	Z-axis synchronized feeding
p	list	M0202	Z-axis synchronized feeding G14	Z-axis synchronized feeding
p	pgm	M0203	Turret unclamp	NC turret
p	mult	M0204	Magazine shutter close	ATC specification
p	mult	M0205	Magazine shutter open	ATC specification
p	spc	M0206	Turret Synchronous Feed Mode OFF	Allow symmetrical movement with lower turret
p	spc	M0207	Turret Synchronous Feed Mode ON	Allow symmetrical movement with lower turret
p	4209	M0208	Door interlock C,D ON	Robot-loader
p	4209	M0209	Door interlock C,D OFF	Robot-loader
p	AB199	M0210	Spindle Orientation Ignore (Use with M151)	Opposing two-spindle
p	pgm	M0211	Keyway cutting cycle: Minus direction	Multiple turning
p	pgm	M0212	Keyway cutting cycle: Zigzag	Multiple turning
p	pgm	M0213	Keyway cutting cycle: Designated depth infeed	Multiple turning
p	pgm	M0214	Keyway cutting cycle: Equal depth infeed	Multiple turning
p	spc	M0215	Load monitor G00 ignore OFF	Load monitor
p	spc	M0216	Load monitor G00 ignore ON	Load monitor
p	list	M0217	Rotary tool Stop with Tool Orientation	
p	air	M0218	Airblow E OFF	(VTR- in machine camera air)
p	air	M0219	Airblow E ON	(VTR- in machine camera air)
p	spc	M0220	Flat turning OFF	Flat turning
p	spc	M0221	Flat turning OFF (1:1)	Flat turning
p	spc	M0222	Flat turning OFF (1:2)	Flat turning
p	spc	M0223	Flat turning OFF (1:3)	Flat turning
p	spc	M0224	Flat turning OFF (1:4)	Flat turning
p	spc	M0225	Flat turning OFF (1:5)	Flat turning
p	spc	M0226	Flat turning OFF (1:6)	Flat turning
p	mult	M0227	ATC operation completion waiting command	ATC specification
p	mult	M0228	ATC next tool return command	ATC specification
p	list	M0229	ATC M-tool spindle orientation (CB=nn)	ATC specification
p	spc	M0230	Universal M code	Universal M codes
p	spc	M0231	Universal M code	Universal M codes
p	spc	M0232	Universal M code	Universal M codes
p	spc	M0233	Universal M code	Universal M codes
p	spc	M0234	Universal M code	Universal M codes
p	spc	M0235	Universal M code	Universal M codes
p	spc	M0236	Universal M code	Universal M codes
p	spc	M0237	Universal M code	Universal M codes
p	list	M0238	M-spindle phase variation, Flat Turning	Flat turning
p	list	M0239	Sub spindle orientation	Opposing two-spindle
p	4787	M0240	Steady rest 2 close end	Steady rest 2
p	pgm	M0241	M-tool spindle gear range 1 or low-speed coil selection	M-tool spindle gear change
p	pgm	M0242	M-tool spindle gear range 2 or high-speed coil selection	M-tool spindle gear change
p	list	M0243	Chip conveyer stop	Automatic chip conveyer operation
p	list	M0244	Chip conveyer start	Automatic chip conveyer operation
p	list	M0245	X-axis Rapid Traverse Increment Change	
p	sub	M0246	Sub spindle chuck interlock release OFF	Opposing two-spindle
p	sub	M0247	Sub spindle chuck interlock release ON	Opposing two-spindle
p	sub	M0248	Sub spindle chuck clamp	Opposing two-spindle
p	sub	M0249	Sub spindle chuck unclamp	Opposing two-spindle
p	5033	M0250	Work Ejector retract	Work Ejector
p	5033	M0251	Work Ejector advance	Work Ejector
p	list	M0252	Laser interferometer data write	Inductosyn pitch error compensation
p	list	M0253	Laser interferometer data verify	Inductosyn pitch error compensation
p	list	M0254	Work Ejector Unit Advance	
p	list	M0255	Work Ejector Unit Retract	
p	list	M0256	Robot/loader request 5	Special specification
p	list	M0257	Robot/loader request 6	Special specification
p	list	M0258	Robot/loader request 7	Special specification
p	list	M0259	Robot/loader request 8	Special specification
p	6006	M0260	Turning Step Feed OFF	
p	6006	M0261	Turning Step Feed ON	
p	cool	M0262	Additional Coolant 3 OFF, H1 turret Face coolant	Additional coolant
p	cool	M0263	Additional Coolant 3 ON, H1 turret Face coolant	Additional coolant
p	4373	M0264	Restriction on overlap mode rapid feed release OFF	LT-10/15/25 models
p	4373	M0265	Restriction on overlap mode rapid feed release ON	LT-10/15/25 models
p		M0266		

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p	list	M0266 R-spindle Collet chuck Close command	
		M0267	
p	list	M0267 R-spindle Collet chuck Open command	
p	list	M0268 Tailstock Advance Disable mode ON	
h	lst2	M0268 Notice of program end	
p	list	M0269 Optical Sensor OFF	
p	gag	M0270 Optical sensor start/stop / Fixed Sensor power on	Gauging
p	spc	M0271 Extreme low speed cutting ON	Low Speed cutting
p	spc	M0272 Extreme low speed cutting OFF	Low Speed cutting
p	yax	M0273 Home Position (G20) Effect Over Variable Limit ON	Home Position
p	yax	M0274 Home Position (G20) Effect Over Variable Limit OFF	Home Position
p	list	M0275 ATC Optional Sequence	ATC specification
p	list	M0276 ATC 1st shutter close	ATC specification
p	list	M0277 ATC 1st shutter open	ATC specification
p	5113	M0278 Steady rest 2 unclamp	Twin Relieving Steady
p	5113	M0279 Steady rest 2 clamp	Twin Relieving Steady
p	list	M0280 M280 Cancel (Fuso Parting line detection type)	
p	list	M0281 Laser Sensor Enable (Fuso Parting line detection type)	
p	list	M0282 Slide step retract	Slide step
p	list	M0283 Slide step advance	Slide step
	762-025	M0284 Turret clamp ignore	NC turret
p	list	M0284 Chuck Interior Air blow Execution	
p	list	M0285 Workpiece Count	
h	lst2	M0286 Face driver advance	
p	list	M0286 Collet Chuck clamp	
h	lst2	M0287 Face driver retract	
p	list	M0287 Collet Chuck unclamp	
p	air	M0288 Sub spindle air blower OFF	Opposing two-spindle
p	air	M0289 Sub spindle air blower ON	Opposing two-spindle
p	spc	M0290 Ceiling door close	Ceiling door
p	spc	M0291 Ceiling door open	Ceiling door
p	5629	M0292 Unloader retract	
p	5629	M0293 Unloader advance	
p	spc	M0294 Prohibit Thermal Compensation Value Updates	TAS-S/TAS-C
p	spc	M0295 Allow Thermal Compensation Value Updates	TAS-S/TAS-C
p	list	M0296 SVP time constant switching mode ON	Wheel machine
p	list	M0297 SVP time constant switching mode OFF	Wheel machine
p	cam	M0298 Cancel of M299	Cam turning
		M0298	
p	cam	M0299 Repeat mode cancel	Cam turning
		M0299	
p	2spH	M0300 Hand A close	NC robot, NC loader
p	2spH	M0301 Hand A open	NC robot, NC loader
p	list	M0302 Hand index A position	
p	list	M0303 Hand index B position	
		M0304	
		M0305	
p	2spH	M0306 Workpiece pusher A advance	NC robot, NC loader
p	2spH	M0307 Workpiece pusher A retract	NC robot, NC loader
p	2spH	M0308 Swing hand A	NC robot, NC loader
	spc	M0308 Robot Door Interlock ON	NC robot, NC loader
p	2spH	M0309 Swing hand B	NC robot, NC loader
	spc	M0309 Robot Door Interlock OFF	NC robot, NC loader
p	2spH	M0310 Hand B close	NC robot, NC loader
p	2spH	M0311 Hand B open	NC robot, NC loader
p	list	M0312 Tandem Loader Turnover Delivery command	
p	list	M0313 Hand clamp miss check effective	
p	list	M0314 Hand clamp miss check ineffective	
p	4721	M0315 Wrist Rotation 90deg	OR Robot
p	2spH	M0316 Workpiece pusher B advance	NC robot, NC loader
p	2spH	M0317 Workpiece pusher B retract	NC robot, NC loader
p	2spH	M0318 Robot/loader air blower ON	NC robot, NC loader
p	2spH	M0319 Robot/loader air blower OFF	NC robot, NC loader
p	2spH	M0320 Robot/loader general M code 1	NC robot, NC loader
p	2spH	M0321 Robot/loader general M code 2	NC robot, NC loader
	mult	M0321 ATC Tool change Macro (opt. par. #42 or bit 11 #2)	ATC specification
p	2spH	M0322 Robot/loader general M code 3	NC robot, NC loader
p	2spH	M0323 Robot/loader general M code 4	NC robot, NC loader
		M0323 VTR- Spindle Return Move for Cover (msb)	(opt.par choice)

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Man	Code	Functional explanation	Option Specification
mult	M0323	TD ATC Tool change Macro (opt. par. #42 or bit 11 #2 )	ATC specification, P300
p	2spH	M0324 Robot/loader general M code 5	NC robot, NC loader
		M0324 VTR- Spindle Clear Move for Cover (msb)	(opt.par choice)
p	2spH	M0325 Robot/loader general M code 6	NC robot, NC loader
p	2spH	M0326 Robot/loader general M code 7	NC robot, NC loader
p	2spH	M0327 Robot/loader general M code 8	NC robot, NC loader
p	2spH	M0328 Request home position valid	NC robot, NC loader
p	2spH	M0329 Request home position invalid	NC robot, NC loader
p	2spH	M0330 NC start	NC robot, NC loader
p	2spH	M0331 Buffering prohibit	NC robot, NC loader, E-control standard
p	list	M0332 Clamp Check Enable	
p	list	M0333 Clamp Check Disable	
p	2spH	M0334 Interference with NC lathe OFF	NC robot, NC loader
p	2spH	M0335 Interference with NC lathe ON	NC robot, NC loader
p	2spH	M0336 External start	NC robot, NC loader
	4193	M0336 Bar Stock change	Bar feeder
p	2spH	M0337 Work count	Special specification
p	2spH	M0338 A-workpiece designation	Special specification
p	2spH	M0339 B-workpiece designation	Special specification
p	2spH	M0340 Robot/loader general M code 9	NC robot, NC loader
p	2spH	M0341 Robot/loader general M code 10	NC robot, NC loader
p	2spH	M0342 Robot/loader general M code 11	NC robot, NC loader
p	2spH	M0343 Robot/loader general M code 12	NC robot, NC loader
p	2spH	M0344 Robot/loader general M code 13	NC robot, NC loader
p	2spH	M0345 Robot/loader general M code 14	NC robot, NC loader
p	2spH	M0346 Robot/loader general M code 15	NC robot, NC loader
p	2spH	M0347 Robot/loader general M code 16	NC robot, NC loader
p	2spH	M0348 External program selection (BCD)	NC robot, NC loader
p	2spH	M0349 Lot completion (external device)	NC robot, NC loader
p	2spH	M0350 NC lathe selection 1 (LFS-2SP: R machine)	NC loader (2M1L or 3M1L specification)
p	2spH	M0351 NC lathe selection 2 (LFS-2SP: L machine)	NC loader (2M1L or 3M1L specification)
p	2spH	M0352 NC lathe selection 3	NC loader (3M1L specification)
p	5691	M0353 Work pusher retract	Work pusher
p	5691	M0354 Work pusher advance	Work pusher
p	2spH	M0355 Tailstock spindle retract 2	
h	cool	M0355 2nd Coolant 2 OFF	Additional coolant
p	2spH	M0356 Tailstock spindle advance 2	
h	cool	M0356 2nd Coolant 2 ON	Additional coolant
p	list	M0357 Work Kind Data Change	
h	cool	M0357 2nd Coolant 3 OFF	Additional coolant
p	list	M0358 NG chute full work	
h	cool	M0358 2nd Coolant 3 ON	Additional coolant
p	list	M0359 Spindle orientation 2nd position	NC robot, NC loader or LOC-650
p	2spH	M0360 2nd chucking error detection air OFF	NC loader, opposing two-spindle & chucking error det.
p	2spH	M0361 2nd chucking error detection air ON	NC loader, opposing two-spindle & chucking error det.
p	2spH	M0362 R-side turnover hand close	NC loader
h	lst2	M0362 2nd Chuck Clamp	Opposing two-spindle
p	2spH	M0363 R-side turnover hand open	NC loader
h	lst2	M0363 2nd Chuck Unclamp	Opposing two-spindle
p	2spH	M0364 R-side turnover retract	NC loader
h	cool	M0364 2nd Coolant 1 OFF	Additional coolant
p	2spH	M0365 R-side turnover advance	NC loader
h	cool	M0365 2nd Coolant 1 ON	Additional coolant
p	list	M0366 NC lathe home position move command 1	NC loader & home position movement
p	list	M0367 NC lathe home position move command 2	NC loader & home position movement
p	list	M0368 NC lathe home position move command 3	NC loader & home position movement
p	list	M0369 NC lathe home position move command 4	NC loader & home position movement
p	2spH	M0370 Robot/loader general M code 17	NC robot, NC loader
p	2spH	M0371 Robot/loader general M code 18	NC robot, NC loader
p	2spH	M0372 Robot/loader general M code 19	NC robot, NC loader
	spc	M0372 Steady rest interlock cancel OFF (or M472)	Steady rest
p	2spH	M0373 Robot/loader general M code 20	NC robot, NC loader
	spc	M0373 Steady rest interlock cancel ON (or M473)	Steady rest
p	2spH	M0374 Robot/loader general M code 21	NC robot, NC loader
p	2spH	M0375 Robot/loader general M code 22	NC robot, NC loader
p	2spH	M0376 Robot/loader general M code 23	NC robot, NC loader
		M0376	
p	2spH	M0377 Robot/loader general M code 24	NC robot, NC loader
		M0377	

Ref	new codes since last release		released: Oct 13
Man	Code	Functional explanation	Option Specification
p	list	M0378	Swing V-hand A
p	5542	M0379	Swing V-hand B
p	list	M0380	NC lathe power saving OFF
p	list	M0381	NC lathe power saving ON
p	list	M0382	NC lathe home position move command 5
p	list	M0383	NC lathe home position move command 6
	2spH	M0383	2nd Chuck Close
p	list	M0384	NC lathe home position move command 7
	2spH	M0384	2nd Chuck Open
p	list	M0385	NC lathe home position move command 8
p	2spH	M0386	Workpiece Return from Turning Over
p	2spH	M0387	Workpiece Turn Over
p	air	M0388	2nd Airblow A OFF
p	air	M0389	2nd Airblow A ON
p	2spH	M0390	2nd door close
p	2spH	M0391	2nd door open
p	5081	M0392	Spindle oscillation
	2spH	M0392	L-turnover hand Close
p	4436	M0393	Second headstock down
	2spH	M0393	L-turnover hand Open
p	4436	M0394	Second headstock up
	2spH	M0394	L-turnover Retract
p	4436	M0395	Disable axis movement when the second headstock is not located either in the upper end position or in the lower end position
	2spH	M0395	L-turnover Advance
p	4436	M0396	Enables axis movement even when the second headstock is not located either in the upper end position or in the lower end position
	2spH	M0396	NC lathe No.2 home position move command 1
		M0396	OGL- OP 1 End of cycle signal (VDIN[265])
p	list	M0397	T-No. for loader in permission pot
	2spH	M0397	NC lathe No.2 home position move command 2
		M0397	OGL- OP 2 End of cycle signal answer
	2spH	M0398	NC lathe No.2 home position move command 3
p	list	M0398	Measure unit on Machine Measurement Start
p	2spH	M0399	NC lathe No.2 home position move command 4
p	list	M0400	Stopper lock OFF
p	list	M0401	Stopper lock ON
p	list	M0402	Notice of program end
p	mult	M0403	B-axis unclamp (brake)
p	mult	M0404	B-axis clamp (curvic)
p	list	M0405	Ignoring loader feed hold
p	5068	M0406	Steady rest joint OFF (clamp)
p	5068	M0407	Steady rest joint ON (unclamp)
p	spc	M0408	Robot/loader interface interlock release OFF
p	spc	M0409	Robot/loader interface interlock release ON
p	list	M0410	Tailstock spindle thrust 1
h	lst2	M0410	Touch Sensor Cover Retract
p	list	M0411	Tailstock spindle thrust 2
h	lst2	M0411	Touch Sensor Cover Advance
p	list	M0412	Robot/loader request 9
p	list	M0413	Robot/loader request 10
p	list	M0414	Robot/loader request 11
p	list	M0415	Robot/loader request 12
p	list	M0416	Robot/loader request 13
p	list	M0417	Robot/loader request 14
p	list	M0418	Robot/loader request 15
p	list	M0419	2nd Spindle Home positioning (sub-spindle)
p	list	M0420	M code macro function CALL (fixed sub-program)
p	list	M0421	M code macro function CALL (fixed sub-program)
	mult	M0421	ATC tool change macro (Can be M321)
p	list	M0422	M code macro function CALL (fixed sub-program)
	mult	M0422	ATC tool change macro (Can be M322)
p	list	M0423	M code macro function CALL (fixed sub-program)
	mult	M0423	TD ATC Tool change Macro (opt. par.)
p	list	M0424	M code macro function CALL (fixed sub-program)
p	list	M0425	M code macro function CALL (fixed sub-program)
p	list	M0426	Ring sensor selection cancel

Ref	new codes since last release		released: Oct 13	
Man	Code	Functional explanation	Option Specification	
p	list	M0427	Ring sensor selection ON	Special specification
p	list	M0428	Tailstock position data request	
p	6076	M0429	Chuck pressure select (CHP=x, 1-6)	
p	loc	M0430	Tailstock chuck miss detect Air OFF	Tailstock Air miss detect (used on LOC)
p	loc	M0431	Tailstock chuck miss detect Air ON (SGE-2911)	Tailstock Air miss detect (used on LOC)
p	list	M0432	Tailstock chuck miss detect OFF	Tailstock Air miss detect (used on LOC)
h	lst2	M0432	Spindle Vibration Detect OFF	
p	list	M0433	Tailstock chuck miss detect ON	Tailstock Air miss detect (used on LOC)
h	lst2	M0433	Spindle Vibration Detect ON	
p	list	M0434	Machine Interference OFF	
p	list	M0435	Machine Interference ON	
p	list	M0436	Barfeed command- Bar Change	Barfeed (used on LOC-650)
p	list	M0437	Ring Sensor Low Sensitivity level	
p	list	M0438	Ring Sensor High Sensitivity level	
p	cool	M0439	Coolant 4 OFF	Additional coolant
p	cool	M0440	Coolant 4 ON	Additional coolant
p	spc	M0441	M code macro function CALL	M code macro function
p	spc	M0442	M code macro function CALL	M code macro function
p	spc	M0443	M code macro function CALL	M code macro function
p	spc	M0444	M code macro function CALL	M code macro function
p	spc	M0445	M code macro function CALL	M code macro function
p	spc	M0446	M code macro function CALL	M code macro function
p	spc	M0447	M code macro function CALL	M code macro function
p	spc	M0448	M code macro function CALL	M code macro function
p	spc	M0449	M code macro function CALL	M code macro function
p	spc	M0450	M code macro function CALL	M code macro function
p	spc	M0451	M code macro function CALL	M code macro function
p	spc	M0452	M code macro function CALL	M code macro function
p	spc	M0453	M code macro function CALL	M code macro function
p	spc	M0454	M code macro function CALL	M code macro function
p	spc	M0455	M code macro function CALL	M code macro function
p	spc	M0456	M code macro function CALL	M code macro function
p	spc	M0457	M code macro function CALL	M code macro function
p	spc	M0458	M code macro function CALL	M code macro function
p	spc	M0459	M code macro function CALL	M code macro function
p	spc	M0460	M code macro function CALL	M code macro function
p	list	M0461	Work stopper retract	Work stopper
p	list	M0462	Work stopper advance	Work stopper
p	list	M0463	Turnover Device in Machine Unclamp	
p	list	M0464	Turnover Device in Machine Clamp	
p	list	M0465	Turnover Device in Machine Return	
p	list	M0466	Turnover Device in Machine Turn	
p	list	M0467	High/Low pressure Selection coolant group rules command	
p	list	M0468	Cut Finish notice	
p	list	M0468	Spindle in Center Advance solenoid 1 OFF	In-Spindle Center spec.
p	list	M0469	Spindle in Center Advance solenoid 1 ON	In-Spindle Center spec.
p	list	M0470	Work Ejector unit Down	
p	list	M0470	Spindle in Center solenoid 2 OFF	In-Spindle Center spec.
p	list	M0471	Work Ejector unit Up	
p	list	M0471	Spindle in Center solenoid 2 ON	In-Spindle Center spec.
p	5113	M0472	Steady rest interlock ON (or M372)	Steady rest
p	list	M0472	Spindle in Center solenoid 3 OFF	
p	5113	M0473	Steady rest interlock OFF (or M373)	Steady rest
p	list	M0473	Spindle in Center solenoid 3 ON	
p	cool	M0474	Coolant 5 OFF	Additional coolant
p	list	M0474	Center Advance confirmation solenoid OFF	
p	cool	M0475	Coolant 5 ON	Additional coolant
p	list	M0475	Center Advance confirmation solenoid ON	
p	5542	M0476	Unloader shutter interlock OFF	Work Unloader
p	5542	M0477	Unloader shutter interlock ON	Work Unloader
p	6193	M0478	Unloader Hand Swing- Advance	Work Unloader
p	AB199	M0479	ZB Extension of minus variable limit	LT10 Cycle time reduction
p	5542	M0479	Unloader Hand Swing- Retract	Work Unloader
p	list	M0480	Turnover Device command on Passing side	
p	list	M0481	Turnover Device command on Receiving side	
p	list	M0482	Tailstock advance to work support position	
p	5219	M0483	Chuck B clamp	Double Cylinder Chuck spec
p	5219	M0484	Chuck B unclamp	Double Cylinder Chuck spec
p	list	M0485	Natural clamp Clamp	



Ref	new codes since last release		released: Oct 13	
Man	Code	Functional explanation	Option Specification	
p	list	M0486	Natural clamp Unclamp	
p	loc	M0487	Front Chuck Compensating Clamp	Compensating clamp (used on LOC)
	5542	M0487	Unloader Call Confirmation	Work Unloader
p	list	M0488	Compensating chuck Unclamp	
p	list	M0489	Lubrication Oil discharge OFF	customer spec
p	list	M0490	Lubrication Oil discharge ON	customer spec
p	5542	M0491	Unloader Shutter Open	Work Unloader
p	5542	M0492	Unloader Shutter Close	Work Unloader
p	5542	M0493	Unloader carrier 1 Advance	Work Unloader
p	5542	M0494	Unloader carrier 1 Retract	Work Unloader
p	6193	M0495	Hand Open	Work Unloader
p	6193	M0496	Hand Close	Work Unloader
p	6193	M0497	Arm swing A-side (Hand shift retract)	Work Unloader
p	6193	M0498	Arm swing B-side (Hand shift advance)	Work Unloader
p	list	M0499	Index chuck interlock release	Index Chuck
p	5542	M0500	Unloader Fixed cycle	Work Unloader
p	list	M0501	Tool Count 1	
p	list	M0502	Tool Count 2	
p	list	M0503	Tool Count 3	
p	list	M0504	Tool Count 4	
p	list	M0505	Tool Count 5	
p	list	M0506	Tool Count 6	
p	list	M0507	Tool Count 7	
p	list	M0508	Tool Count 8	
p	list	M0509	Tow-along Interlock OFF	
p	list	M0510	Tow-along Interlock ON	
p	5674	M0511	Rear air chuck clamp	LOC-650
p	5674	M0512	Rear air chuck unclamp	LOC-650
p	list	M0513	X-axis plus variable limit check ON	Programmable tailstock/Steady rest
p	list	M0514	X-axis plus variable limit check OFF	Programmable tailstock/Steady rest
p	list	M0515	1st Product gauged Data Output Start	
p	list	M0516	Product gauged Data Output Start	
p	list	M0517	Centrifugal Separator cleaning Start (headstock at any position)	
p	list	M0518	Measure Finish	
h	vtr	M0519	M-spindle Extreme Low Speed ON	VTR
h	vtr	M0520	M-spindle Extreme Low Speed OFF	VTR
p	list	M0521	Status Indicator lamp Green ON	
p	list	M0522	Status Indicator lamp Green OFF	
p	list	M0523	Status Indicator lamp Yellow ON	
p	list	M0524	Status Indicator lamp Yellow OFF	
p	list	M0525	Status Indicator lamp Red ON	
p	list	M0526	Status Indicator lamp Red OFF	
p	4981	M0527	Oil mist Off	Oil Mist coolant spec.
p	4981	M0528	Oil mist On	Oil Mist coolant spec.
p	list	M0529	Tailstock Advance Output OFF	
p	list	M0530	Oil Supply OFF	
p	list	M0531	Oil level Max	
p	list	M0532	Oil level Std	
p	list	M0533	Oil level Min	
p	list	M0534	Backup Roller Retract	
p	list	M0535	Backup Roller Advance	
p	list	M0536	Loader Request Signal (Exclusively for B)	
		M0537		
p	5961	M0537	Work Pusher Interlock Release Cancel	
		M0538		
p	5691	M0538	Work Pusher Interlock Release	
p	list	M0539	Workpiece Pull out Device Retract	
p	list	M0540	Workpiece Pull out Device Advance	
		M0541		
		M0542		
p	list	M0543	W.stand movement upper to middle	Swing type Work Rest
p	list	M0544	W.stand movement middle to upper	Swing type Work Rest
p	list	M0545	W.stand movement lower to middle	Swing type Work Rest
p	list	M0546	W.stand movement middle to lower	Swing type Work Rest
p	list	M0547	Work rest Pull position	Swing type Work Rest
p	list	M0548	Work rest Insert position	Swing type Work Rest
p	list	M0549	Longitude Positioning Device Retract	
p	list	M0550	Longitude Positioning Device Advance	
		M0551		

Ref	new codes since last release		released: Oct 13	
Man	Code	Functional explanation	Option Specification	
p	5644	M0552	Door Open Middle position	NC/ballscrew door
		M0553		
		M0554		
p	spc	M0555	HOB cutting synchronized rotation OFF	Hob cutting
p	spc	M0556	HOB cutting synchronized rotation ON	Hob cutting
p	spc	M0557	Move to Z-axis direction by slide hold during HOB cutting	Hob cutting
p	spc	M0558	Move to X-axis direction by slide hold during HOB cutting	Hob cutting
p	cam	M0559	Zero return of asynchronous axis	CAM turning (E100)
p	list	M0560	Chip Scraper grip Close, Tailstock-side Deburring Device Retract	
p	list	M0561	Chip Scraper grip Open, Tailstock-side Deburring Device Advance	
p	list	M0562	Snap Gauging Probe Close, Chuck-side Deburring Device Retract	
p	list	M0563	Snap Gauging Probe Open, Chuck-side Deburring Device Advance	
p	list	M0564	C-axis Positioning Pin OUT (reserved for Macturn)	
p	list	M0565	C-axis Positioning Pin IN (reserved for Macturn)	
p	list	M0566	Vibration Cutting tool ON	
p	list	M0567	Vibration Cutting tool OFF	
p	list	M0568	B-turret optional index control OFF	
p	list	M0569	B-turret optional index control ON	
p	5052	M0570	External M code 9	External M codes
p	5052	M0571	External M code 9	External M codes
p	5052	M0572	External M code 10	External M codes
p	5052	M0573	External M code 10	External M codes
p	5052	M0574	External M code 11	External M codes
p	5052	M0575	External M code 11	External M codes
p	5052	M0576	External M code 12	External M codes
p	5052	M0577	External M code 12	External M codes
p	list	M0578	Main Spindle brake OFF	Spindle brake
p	list	M0579	Main Spindle brake ON	Spindle brake
p	list	M0580	X/Z acc/dec time constant (default)	Special thread cutting spec.
p	list	M0581	X/Z acc/dec time constant (pattern1)	Special thread cutting spec.
p	list	M0582	X/Z acc/dec time constant (pattern2)	Special thread cutting spec.
p	list	M0583	X/Z acc/dec time constant (pattern3)	Special thread cutting spec.
p	list	M0584	Quality Check request, Gauging Start, Collet Chuck unclamp	
p	list	M0585	No Work piece Cutting mode OFF	
h	lst2	M0585	Collet Chuck Advance	
p	list	M0586	No Work piece Cutting mode ON	
h	lst2	M0586	Collet Chuck Retract	
p	4436	M0587	2nd Spindle head brake (Mac 30/50)	ATC+Sub spindle+H1turret+W-axis specification
	spc	M0587	W-axis Un-clamp command (2nd spindle head clamp)	W-axis Clamp, Counter Spindle
p	4436	M0588	2nd Spindle head clamp (Mac 30/50)	ATC+Sub spindle+H1turret+W-axis specification
	spc	M0588	W-axis Clamp command (2nd spindle head clamp)	W-axis Clamp, Counter Spindle
p	list	M0589	Discharge command	
p	list	M0590	Cycle Time Measuring Stop	
p	list	M0591	Cycle Time Measuring Start	
p	5052	M0592	External M code 13	External M codes
p	5052	M0593	External M code 13	External M codes
p	5052	M0594	External M code 14	External M codes
p	5052	M0595	External M code 14	External M codes
p	5052	M0596	External M code 15	External M codes
p	5052	M0597	External M code 15	External M codes
p	5052	M0598	External M code 16	External M codes
p	5052	M0599	External M code 16	External M codes
p	5499	M0600	M-tool spindle clamp angle 90	Millac-33T
		M0600		
p	5499	M0601	M-tool spindle clamp angle 270	Millac-33T
		M0601		
p	mult	M0602	M-tool spindle clamp angle 0	L-tool index, TL mode
p	mult	M0603	M-tool spindle clamp angle 180	L-tool index, TL mode
p	list	M0604	B-axis one side positioning mode OFF	H1 turret
p	list	M0605	B-axis one side positioning mode ON	H1 turret
p	list	M0606	Y-axis barrier function Cancel	
p	list	M0607	Y-axis barrier function ON	
p	cool	M0608	2nd Coolant 1 ON	(VTR below Right saddle)
p	cool	M0609	2nd Coolant 1 OFF	(VTR below Right saddle)

# Lathe M-code

Ref	new codes since last release		released: Oct 13
Man	Code	Functional explanation	Option Specification
p	list	M0610	2nd Spindle Inching OFF
p	list	M0611	2nd Spindle Inching ON
p	spc	M0612	Move to Y-axis direction by slide hold during HOB cutting Hob cutting
p	list	M0613	Work Push-out Confirmation Air OFF
p	list	M0614	Work Push-out Confirmation Air ON
p	list	M0615	Monitor part Read-in Start
p	6303	M0616	Shutter close In-process gage spec
p	6303	M0617	Shutter open In-process gage spec
p	list	M0618	2nd Spindle Orientation Cancel
p	list	M0619	2nd Spindle Orientation
p	list	M0620	2nd Spindle Orientation 2
p	list	M0621	First spindle Stop after zero point Return (at power chuck pos.)
p	list	M0622	Y-axis Retraction to Negative direction of program coordinate system during synchronized operation for Hob cutting
p	list	M0623	Y-axis Retraction to Positive direction of program coordinate system during synchronized operation for Hob cutting
p	list	M0624	Inching Confirmation Lamp light command
p	mult	M0625	B-axis unclamp Full B-axis, Macturn
p	air	M0626	2nd Additional Air Blow D OFF
p	air	M0627	2nd Additional Air Blow D ON
p	air	M0628	2nd Additional Air Blow E OFF
p	air	M0629	2nd Additional Air Blow E ON
p	list	M0630	2nd Chucking Error Detection Air OFF
p	list	M0631	2nd Chucking Error Detection Air ON
h	lst2	M0632	2nd Chucking Error Detection OFF
p	list	M0632	Receiver OFF
h	lst2	M0633	2nd Chucking Error Detection ON
p	list	M0633	Receiver ON
p	5924	M0634	LF R-spindle interference check OFF Roof Door (CE spec)
p	5924	M0635	LF R-spindle interference check ON Roof Door (CE spec)
p	list	M0636	Chuck index 0 deg. Spec. Index Control chuck
p	list	M0637	Chuck index 45 deg. Spec. Index Control chuck
p	list	M0638	Chuck index 90 deg. Spec. Index Control chuck
p	list	M0639	Chuck index 135 deg. Spec. Index Control chuck
p	list	M0640	Chuck index 180 deg. Spec. Index Control chuck
p	list	M0641	Chuck index 225 deg. Spec. Index Control chuck
p	list	M0642	Chuck index 270 deg. Spec. Index Control chuck
p	list	M0643	Chuck index 315 deg. Spec. Index Control chuck
p	cool	M0644	2nd Coolant 2 OFF (VTR below Left saddle)
p	cool	M0645	2nd Coolant 2 ON (VTR below Left saddle)
p	list	M0646	Magnet level 1, Chucking
p	list	M0647	Magnet level 2, Chucking
p	list	M0648	Magnet level 3, Chucking
p	list	M0649	Headstock Rotation command
p	air	M0650	2nd Additional Air Blow B OFF
p	air	M0651	2nd Additional Air Blow B ON
p	6226	M0652	Canceling the designation of "MAIN-MG TOOL" ATC with Sub-magazine
p	lawV	M0653	ACC Spindle orientation LAW-V ACC function
p	air	M0654	2nd Additional Air Blow C OFF
p	air	M0655	2nd Additional Air Blow C ON
p	list	M0656	Low load check OFF
p	list	M0657	Low load check ON
p	list	M0658	2nd Chucking Pressure LOW
p	list	M0659	2nd Chucking Pressure HIGH
p	lawV	M0660	ACC airblow LAW-V ACC function
p	lawV	M0661	A-Chuck index (Machining station) LAW-V ACC function
p	lawV	M0662	B-Chuck index (Machining station) LAW-V ACC function
p	lawV	M0663	ACC chuck interlock release OFF LAW-V ACC function
p	lawV	M0664	ACC chuck interlock release ON LAW-V ACC function
p	list	M0665	Loader Chucking Error Air OFF
p	list	M0666	Loader Chucking Error Air ON
p	list	M0667	Main drive jig unit retract
p	list	M0668	Main drive jig unit forward
p	list	M0669	Main drive jig unit oscillation
p	list	M0670	Sub drive jig unit oscillation Sub-spindle Drive Jig
p	list	M0671	Low spindle Acceleration mode ON
p	list	M0672	Low spindle Acceleration mode OFF
p	list	M0673	Quality Check mode OFF
p	cool	M0674	2nd Additional Coolant 3 OFF

# Lathe M-code

Ref	new codes since last release		released: Oct 13	
Man	Code	Functional explanation	Option Specification	
p	cool	M0675	2nd Additional Coolant 3 ON	
p	list	M0676	Loader request answer	
p	list	M0677	Time over check ON	
p	list	M0678	Time over check OFF	
p	list	M0679	Work cover downturn	Work Cover
p	list	M0680	Work cover upturn	Work Cover
p	list	M0681	Rolling-head close	
p	list	M0682	Rolling-head open	
p	lawV	M0683	ACC chuck Clamp	LAW-V ACC function
p	lawV	M0684	ACC chuck Unclamp	LAW-V ACC function
p	lawV	M0685	Setup finish	LAW-V ACC function
p	list	M0686	Status indication lamp OFF	Status Lamp Control
p	list	M0687	Status indication lamp ON	Status Lamp Control
p	air	M0688	2nd Air Blow OFF	
p	air	M0689	2nd Air Blow ON	
p	5715	M0690	LF Right Moon door Close	Roof Door (CE spec)
p	5715	M0691	LF Right Moon door Open	Roof Door (CE spec)
p	6303	M0692	Tool breakage detection interlock release ON	Tool Breakage Detection- Macturn
	5650	M0692	Fixed-type Touch setter Interlock Release ON	Fixed-type Touch Setter
p	6303	M0693	Tool breakage detection interlock release OFF	Tool Breakage Detection- Macturn
	5650	M0693	Fixed-type Touch setter Interlock Release OFF	Fixed-type Touch Setter
p	pgm	M0694	Spindle revolution speed change control OFF (HSSC OFF)	Harmonic Spindle Speed Control
p	pgm	M0695	Spindle revolution speed change control ON (HSSC ON)	Harmonic Spindle Speed Control
p	4871	M0696	Spindle phase synchronous mode OFF	Spindle Phase Synchronous function
p	4871	M0697	Spindle phase synchronous mode ON	Spindle Phase Synchronous function
p	4943	M0698	Tool breakage detection sensor advance	Tool Breakage Detection- Macturn
p	4943	M0699	Tool breakage detection sensor retract	Tool Breakage Detection- Macturn
p	list	M0700	Mist Collector OFF	
p	list	M0701	Mist Collector ON	
p	list	M0702	Mist Collector Retract	
p	list	M0703	Mist Collector Advance	
p	list	M0704	Work Support Retract	
p	list	M0705	Work Support Advance	
p	list	M0706	Centering unit middle advance	
p	list	M0707	Centering unit advance	
p	list	M0708	Centering unit middle retract	
p	list	M0709	Centering unit retract	
p	list	M0710	Centering unit unclamp	
p	list	M0711	Centering unit clamp	
p	6303	M0712	Tool breakage detection ON	Tool Breakage Detection- Macturn
	5650	M0712	Fixed-type Touch setter Activated	Fixed-type Touch Setter
p	6303	M0713	Tool breakage detection OFF	Tool Breakage Detection- Macturn
	5650	M0713	Arm-type Touch setter Activated	Fixed-type Touch Setter
p	list	M0714	Work change request	
p	list	M0715	Work out request	
p	list	M0716	Tool load request	
p	list	M0717	Tool unload request	
p	list	M0718	Loader cycle start	
p	list	M0719	Loader cycle stop	
p	list	M0720	Designated Alarm-C Enable	
p	list	M0721	Designated Alarm-C Disable	
p	list	M0722	Tool Life Check	
p	list	M0723	Tailstock advance limit switch effective	
p	list	M0724	Tailstock advance limit switch ineffective (TS limit)	(B-spec, sge0570)
p	list	M0725	Loader time over check start	
p	list	M0726	Loader time over check stop	
p	list	M0727	Loader axis interlock ON	
p	list	M0728	Loader axis interlock OFF	
p	list	M0729	Workpiece stand downturn	Tow-along Work rest spec.
p	list	M0730	Workpiece stand upturn	Tow-along Work rest spec.
p	list	M0731	Work Counter A	
p	list	M0732	Work Counter B	
p	list	M0733	Work Counter C	
p	list	M0734	Work Counter D	
p	list	M0735	Work Counter E	
p	list	M0736	Work Counter F	
p	list	M0737	Work Counter G	
p	list	M0738	M739 Cancel	
p	list	M0739	Temporary Workpiece Stand position fixture Pin OUT	

Ref	new codes since last release		released: Oct 13	
Man	Code	Functional explanation	Option Specification	
p	list	M0740	W.stand movement interlock ON	
p	list	M0741	W.stand movement interlock OFF	
p	list	M0742	Steady rest XB-axis travel Interlock cancel OFF	
p	list	M0743	Steady rest XB-axis travel Interlock cancel ON	
p	list	M0744	Spindle Orientation Speed Override Limit OFF	
p	list	M0745	Spindle Orientation Speed Override Limit ON	
p	list	M0746	Ball valve open	
p	list	M0747	Ball valve close	
p	4700	M0748	Tailstock brake OFF	
p	4700	M0749	Tailstock brake ON	
p	list	M0750	Centering unit machining cycle	
p	4700	M0751	Work conveyor Advance	
p	4700	M0752	Work conveyor Retract	
p	6193	M0753	Work conveyer start (CW)	Work Unloader
p	4700	M0754	Work conveyer start (rearward)	
p	list	M0755	Work conveyer stop	
p	4700	M0756	Turret speed reducer OFF	
p	4700	M0757	Turret speed reducer ON	
p	4700	M0758	Pick-off chuck Close	
p	4700	M0759	Pick-off chuck Open	
	loc	M0759	Rear chuck Compensating clamp	Compensating clamp (used on LOC)
p	list	M0760	Water coolant select	Hybrid coolant option
p	list	M0761	Oil coolant select	Hybrid coolant option
p	list	M0762	Coolant reverse pump OFF	Hybrid coolant option
p	list	M0763	Coolant reverse pump ON	Hybrid coolant option
p	5219	M0764	Chuck B interlock OFF	Double Cylinder Chuck spec
p	5219	M0765	Chuck B interlock ON	Double Cylinder Chuck spec
p	4700	M0766	Work Conveyor Interlock ON	
p	4700	M0767	Work Conveyor Interlock OFF	
p	loc	M0768	Tailstock or Vacuum chuck Interlock ON	Tailstock chuck (used on LOC-650)
p	loc	M0769	Tailstock or Vacuum chuck Interlock OFF	Tailstock chuck (used on LOC-650)
p	4700	M0770	Pick-off chuck Airblow OFF	
p	4700	M0771	Pick-off chuck Airblow ON	
p	5113	M0772	Steadyrest 2 Retract	Twin Relieving Steady
p	5113	M0773	Steadyrest 2 Advance	Twin Relieving Steady
p	list	M0774	Steadyrest 3 Open	
p	list	M0775	Steadyrest 3 Close	
p	list	M0776	Steadyrest 3 Retract	
p	list	M0777	Steadyrest 3 Advance	
p	list	M0778	Steady rest pressure LOW	
p	list	M0779	Steady rest pressure HIGH	
p		M0780	Bar feeder Steady rest Open	
p		M0781	Bar feeder Steady rest Close	
p	list	M0782	Setup program button off	
p	list	M0783	Tailstock chuck clamp	Tailstock chuck (used on LOC-650)
p	list	M0784	Tailstock chuck unclamp	Tailstock chuck (used on LOC-650)
p	list	M0785	Unloader Stand-by at Middle point command ON	
p	list	M0786	Unloader Stand-by at Middle point command OFF	
p	list	M0787	Air drill OFF	
p	list	M0788	Air drill ON	
p	list	M0789	Spindle Orientation 3	
		M0790		
		M0791		
p	4709	M0792	Cutoff detector Retract	Barcenter-34
p	4709	M0793	Cutoff detector Advance	Barcenter-34
p	4709	M0794	Parts conveyor OFF	Barcenter-34
p	4709	M0795	Parts conveyor ON	Barcenter-34
p	4709	M0796	Tailstock Traverse function	Barcenter-34
		M0797		
		M0798		
		M0799		
p	air	M0800	Airblow H OFF	Additional Air
p	air	M0801	Airblow H ON	Additional Air
p	list	M0802	Cycle Airblow ON	
p	spc	M0803	High-pressure coolant level A	High pressure coolant
p	spc	M0804	High-pressure coolant level B	High pressure coolant
p	spc	M0805	High-pressure coolant level C	High pressure coolant
p	spc	M0806	High-pressure coolant level D	High pressure coolant
p	OEG	M0807	Cutting feed interlock release OFF	M-spindle function

Ref	new codes since last release		released: Oct 13	
Man	Code	Functional explanation	Option Specification	
p	OEG	M0808	Cutting feed interlock release ON	M-spindle function (O-067, 04)
p	5542	M0809	W-axis travel interlock OFF	Work Unloader
p	5542	M0810	W-axis travel interlock ON	Work Unloader
p	5753	M0811	Tool Unclamp (reservation only)	LU45 customer spec
p	5753	M0812	Tool Clamp	LU45 customer spec
p	5066	M0813	ATC shutter interlock release OFF	Macturn ATC
p	5066	M0814	ATC shutter interlock release ON	Macturn ATC
p	list	M0815	Spindle Stop Unclamp	
p	spc	M0816	Spindle override effective in threading	Variable Spindle Speed Threading, VSST
p	spc	M0817	Spindle override ineffective in threading	Variable Spindle Speed Threading, VSST
p	5173	M0818	Unloader carrier 2 Advance	Work Unloader
p	5173	M0819	Unloader carrier 2 Retract	Work Unloader
p	5584	M0820	Group Tool Move to Main	MG TOOL Re-positioning cycle, Macturn
p	list	M0821	Thermal Deviation offset function OFF	
p	list	M0822	Thermal Deviation offset function ON	
p	6290	M0823	2nd spindle CW	W-axis overlap control (O-058, 04)
p	6290	M0824	2nd spindle CCW	W-axis overlap control
p	6290	M0825	2nd spindle stop	W-axis overlap control
p	list	M0826	Loader axis Travel Interlock OFF	
p	list	M0827	Loader axis Travel Interlock ON	
p	list	M0828	Roller Varnishing OFF	
p	list	M0829	Roller Varnishing ON	
p	list	M0830	XB-W axis Interference Check OFF	
p	list	M0831	XB-W axis Interference Check ON	
p	mult	M0832	Interlock Release for M-tool index command	H1 M-tool I/L
p	mult	M0833	Interlock Release Cancel for M-tool index command	H1 M-tool I/L
p	list	M0834	Lube motor output fix OFF	
p	list	M0835	Lube motor output fix ON	
p	air	M0836	Airblow F OFF	Additional Air
p	air	M0837	Airblow F ON	Additional Air
p	2spH	M0838	Hand A Pusher push-in Confirmation	OGL-LFS
p	2spH	M0839	Hand B Pusher push-in Confirmation	OGL-LFS
p	list	M0840	ATC Shutter Simultaneous Open-Close	
p	6290	M0841	2nd spindle low-speed coil selection	W-axis overlap control (O-058, 04)
p	6290	M0842	2nd spindle high-speed coil selection	W-axis overlap control
p	list	M0843	ATC Tool End Face Air Blow OFF	
p	list	M0844	ATC Tool End Face Air Blow ON	
p	list	M0845	Oilmist Mode OFF	
p	list	M0846	Oilmist Mode ON	
p	spc	M0847	Tailstock Retract End	NC/Multus tailstock
p	list	M0848	Tailstock Measurement	
p	list	M0849	Sub-spindle 2 Chuck Interlock Release OFF	
p	list	M0850	Sub-spindle 2 Chuck Interlock Release ON	
p	list	M0851	Sub-spindle 2 Chuck Clamp	
p	list	M0852	Sub-spindle 2 Chuck Unclamp	
p	air	M0853	Airblow G OFF	Additional Air
p	air	M0854	Airblow G ON	Additional Air
p	cool	M0855	Coolant 7 OFF	
p	cool	M0856	Coolant 7 ON	
p	cool	M0857	Coolant 8 OFF	
p	cool	M0858	Coolant 8 ON	
p	list	M0859	Emergency Return Completion	
p	list	M0860	Tailstock Deburring Device Roller ON	
p	list	M0861	Tailstock Deburring Device Roller OFF	
p	list	M0862	Chuck Deburring Device Roller ON	
p	list	M0863	Chuck Deburring Device Roller OFF	
p	list	M0864	Grinding whetstone spindle unit retract	
p	list	M0865	Grinding whetstone spindle unit advance	
p	cas	M0866	Collision Avoidance function ON	CAS
p	cas	M0867	Collision Avoidance function OFF	CAS
p	air	M0868	Macturn M-spindle nose airblow OFF	Chip Removal cycle, added function
p	air	M0869	Macturn M-spindle nose airblow ON ( tool rotates)	Chip Removal cycle, added function
p	air	M0870	Airblow I OFF	Additional Air
p	air	M0871	Airblow I ON	Additional Air
p	5318	M0872	Touchsetter Shutter Open	Laser TS
p	5318	M0873	Touchsetter Shutter Close	Laser TS
p	list	M0874	Tool Retract- Straddle tool OFF	2SP- machine (IMTS)
p	list	M0875	Tool Retract- Straddle tool ON	2SP- machine
p	5318	M0876	Touchsetter Interlock Release OFF	

# Lathe M-code

Ref	new codes since last release		released: Oct 13	
Man	Code	Functional explanation	Option Specification	
p	5318	M0877	Touchsetter Interlock Release ON	
p	list	M0878	Data Hold	
p	list	M0879	Data Hold Cancel	
p	air	M0880	2nd Airblow H OFF	Additional Air
p	air	M0881	2nd Airblow H ON	Additional Air
p	5659	M0882	Chucking Error Detection Zero Shift	
p	OEG	M0883	Spindle Synchronous Rotation Both Chuck Clamp IL cancel	Synch Rotation with both chucks clamped (O-0151, 09)
p	list	M0884	Data Clear	
p	list	M0885	Data Clear 2	
p	air	M0886	2nd Airblow F OFF	Additional Air
p	air	M0887	2nd Airblow F ON	Additional Air
p	spc	M0888	C-axis Synchronous Control Mode OFF	C-axis Synchronous Control Function
p	spc	M0889	C-axis Synchronous Control Mode ON (A-turret)	C-axis Synchronous Control Function
p	spc	M0890	C-axis Synchronous Control Mode ON (B-turret)	C-axis Synchronous Control Function
p	spc	M0891	Sub-spindle C-axis joint OFF	C-axis Synchronous Control Function
p	spc	M0892	Sub-spindle C-axis joint ON	C-axis Synchronous Control Function
p	list	M0893	M-tool Spindle jog CW ON	
p	list	M0894	M-tool Spindle jog CCW ON	
p	list	M0895	M-tool Spindle jog OFF	
		M0896		
		M0897		
p	list	M0898	Parts turnover hand air blower OFF	
p	list	M0899	Parts turnover hand air blower ON	
p	list	M0900	Sub-spindle Oscillation	
p	list	M0901	Work Washer shutter Close	
p	list	M0902	Work Washer shutter Open	
p	list	M0903	Work Washer Fixed cycle	
p	pgm	M0904	Machining Mode interlock Cancel	
		M0905		
		M0906		
		M0907		
p	air	M0908	ATC Air Blow OFF	
h	lst2	M0908	Spindle Unclamp	
p	air	M0909	ATC Air Blow ON	
h	lst2	M0909	Spindle Clamp	
p	list	M0910	M-axis Unclamp	VTM
p	list	M0911	Chuck Grasp diameter 1	
p	list	M0912	Chuck Grasp diameter 2	
p	list	M0913	Chuck Grasp diameter 3	
p	list	M0914	Chuck Grasp diameter 4	
p	list	M0915	Chuck Grasp diameter 5	
p	vtr	M0916	No Tool Interlock Release OFF	VTR
p	vtr	M0917	No Tool Interlock Release ON	VTR
p	list	M0918	Chuck center LOW pressure	
p	list	M0919	Chuck center HIGH pressure	
p	list	M0920	Lamp OFF command	
p	list	M0921	Spindle jog CCW ON	
p	list	M0922	System link Output OFF	
p	list	M0923	System link Output ON	
p	list	M0924	Slider Retract	
p	list	M0925	Slider Advance	
p	list	M0926	Tool 1 gripper Close	
p	list	M0927	Tool 1 gripper Open	
p	list	M0928	Tool 2 gripper Close	
p	list	M0929	Tool 2 gripper Open	
p	vtr	M0930	M-axis Unclamp	
p	vtr	M0931	M-axis Clamp	
p	list	M0932	Long Tool Interlock Release OFF	
p	list	M0933	Long Tool Interlock Release ON	
p	5506**	M0934	Automatic Pallet Change cycle	VTM / VTR
p	list	M0935	Work Setup Complete	VTM / VTR
p	list	M0936	Tailstock Approach Position	
p	list	M0937	2nd hand A close (Y hand close)	
p	list	M0938	2nd hand A open (Y hand open)	
p	list	M0939	2nd Optional Stop	(B-spec, req second button)
p	5655	M0940	Interrupt Program Disable	TMAC Program Interrupt
p	5655	M0941	Interrupt Program Enable (O941)	TMAC Program Interrupt
p	5655	M0942	Interrupt Program Enable (O942)	TMAC Program Interrupt
p	5655	M0943	Interrupt Program Enable (O943)	TMAC Program Interrupt

# Lathe M-code

Ref	new codes since last release		released: Oct 13	
Man	Code	Functional explanation	Option Specification	
p	5655	M0944	Interrupt Program Enable (O944)	TMAC Program Interrupt
p	5655	M0945	Interrupt Program Enable (O945)	TMAC Program Interrupt
p	list	M0946	2nd hand B close (V hand close)	
p	list	M0947	2nd hand B open (V hand open)	
p	list	M0948	Steady Rest 3 Close End	
p	list	M0949	Work Judgement Air OFF	
p	list	M0950	Work Judgement Air ON	
p	list	M0951	Left Front Door Chuck Position	
p	list	M0952	Left Front Door Free Position	
		M0953		
p	YB	M0954	APC Clamp Interlock Release OFF	VTR
p	YB	M0955	APC Clamp Interlock Release ON	VTR
p	list	M0956	APC Interference Interlock Release OFF	
p	list	M0957	APC Interference Interlock Release ON	
p	cool	M0958	Tool Washer Coolant OFF (B750)	
p	cool	M0959	Tool Washer Coolant ON (B750)	
p	oprL	M0960	C-axis Positioning (near Direction, Shortest path)	
p	list	M0961	Chuck Clamp Miss Check Effective	
p	list	M0962	Finger Chuck Clamp Miss Check Ineffective	
p	list	M0963	Collet Chuck Clamp Miss Check Ineffective	
p	list	M0964	Return Level Multi-Machining cycle- Specified level	
p	list	M0965	Return Level Multi-Machining cycle- Standard level	
p	5633	M0966	Swing Hand Upright Position	
p	list	M0967	Chuck Eccentric Motion OFF	
p	list	M0968	Chuck Eccentric Motion ON	
p	list	M0969	Machining Emphasis the Time Constant OFF	
p	list	M0970	Machining Emphasis the Time Constant ON	
p	list	M0971	Manual Interrupt Impossible OFF	
p	list	M0972	Manual Interrupt Impossible ON	
p	list	M0973	Loader Hand Outside Diameter Gripping	
p	list	M0974	Loader Hand Inside Diameter Gripping	
p	list	M0975	W-axis Turret Interference Interlock Release OFF	
p	list	M0976	W-axis Turret Interference Interlock Release ON	
p	list	M0977	M-axis Synchronized Tap Torque Monitor OFF	
p	list	M0978	M-axis Synchronized Tap Torque Monitor ON	
p	list	M0979	Vibration Cutting Tool B ON	
p	list	M0980	Vibration Cutting Tool B OFF	
p	list	M0981	Vibration Cutting Tool C ON	
p	list	M0982	Vibration Cutting Tool C OFF	
p	list	M0983	Thermal Deformation Compensation X-C-axis Displacement Set	
p	list	M0984	Thermal Deformation Compensation X-C-axis OFF	
p	list	M0985	Thermal Deformation Compensation X-C-axis ON	
p	list	M0986	Auto Judgement	
p	list	M0987	Machining Mode	
p	list	M0988	Gauging Mode	
p	list	M0989	Thermal Deformation Compensation OFF	
p	list	M0990	Thermal Deformation Compensation ON	
p	lbb	M0991	Long Boring Bar Chucking Air OFF	Long Boring Bar spec
p	lbb	M0992	Long Boring Bar Chucking Air ON	Long Boring Bar spec
p	lbb	M0993	Stocker Shutter Close	Long Boring Bar spec
p	lbb	M0994	Stocker Shutter Open	Long Boring Bar spec
		M0995		
		M0996		
		M0997		
		M0998		
		M0999		
		M1000		
		M1001		
		M1002		
p	list	M1003	APC Door Close	
p	list	M1004	APC Door Open	
p	5714	M1005	Long Tool 1 Loading	Robot Long Tool Spec
p	5714	M1006	Long Tool 2 Loading	Robot Long Tool Spec
p	5714	M1007	Long Tool 3 Loading	Robot Long Tool Spec
p	5714	M1008	Long Tool 4 Loading	Robot Long Tool Spec
p	5714	M1009	Long Tool Unloading	Robot Long Tool Spec
p	spc	M1010	Tool Offset Zero Detection cancel OFF	
p	spc	M1011	Tool Offset Zero Detection cancel ON	
		M1012		



Ref	new codes since last release		released: Oct 13	
Man	Code	Functional explanation	Option Specification	
	M1013			
	M1014			
	M1015			
	M1016			
p	6119	M1017	Steady rest interlock release ZB-axis	Multus-B750
p	6119	M1018	1st NC steady rest saddle unclamp	Multus-B750
p	6119	M1019	1st NC steady rest saddle clamp	Multus-B750
p	list	M1020	2nd NC steady rest saddle unclamp	
p	list	M1021	2nd NC steady rest saddle clamp	
p	list	M1022	3rd NC steady rest saddle unclamp	
p	list	M1023	3rd NC steady rest saddle clamp	
	M1024			
	M1025			
p	list	M1026	Multi-Steady rest interlock release OFF	
p	list	M1027	Multi-Steady rest interlock release ON	
	M1028			
	M1029			
p	vtr	M1030	Crossrail auto positioning 1	VTR
p	vtr	M1031	Crossrail auto positioning 2	VTR
p	vtr	M1032	Crossrail auto positioning 3	VTR
p	vtr	M1033	Crossrail auto positioning 4	VTR
p	vtr	M1034	Crossrail auto positioning 5	VTR
p	vtr	M1035	Crossrail auto positioning 6	VTR
p	vtr	M1036	Crossrail auto positioning 7	VTR
p	vtr	M1037	Crossrail auto positioning 8	VTR
p	vtr	M1038	Crossrail auto positioning 9	VTR
p	vtr	M1039	Crossrail auto positioning 10	VTR
p	vtr	M1040	Crossrail Clamp	VTR
p	vtr	M1041	Crossrail Unclamp	VTR
p	5689	M1042	Attachment index command, front	VTR
p	5689	M1043	Attachment index command, left	VTR
p	5689	M1044	Attachment index command, rear	VTR
p	5689	M1045	Attachment index command, right	VTR
p	5689	M1046	Attachment index in CCW direction	VTR
p	5689	M1047	Attachment indexing (CW)	VTR
p	5689	M1048	Attachment indexing (CCW)	VTR
p	5689	M1049	NC-in-position ignoring for the attachment indexing	VTR
p	5689	M1050	AT clamp	VTR
p	5689	M1051	AT unclamp	VTR
p	5689	M1052	AT hook	VTR
p	5689	M1053	AT unhook	VTR
p	5689	M1054	AT unclamp preparation	VTR
p	5689	M1055	Attachment supporter OFF	VTR
p	5689	M1056	Attachment supporter ON	VTR
p	5689	M1057	Tool change command (horizontal)	VTR
p	5689	M1058	Tool change command (vertical)	VTR
p	vtr	M1059	No next tool	VTR
p	vtr	M1060	Manual tool change	VTR
	lbb	M1061	LBB Attachment change, AT=#	Multus-B750
p	5689	M1061	Attachment change	VTR
p	vtr	M1062	ATC cover tool attaching	VTR
p	vtr	M1063	ATC cover tool detaching	VTR
p	5689	M1064	Additional axis: A-axis clamp	VTR
p	5689	M1065	Additional axis: A-axis unclamp	VTR
p	5689	M1066	Additional axis: B-axis clamp	VTR
p	5689	M1067	Additional axis: B-axis unclamp	VTR
p	vtr	M1068	Additional axis: C-axis clamp	VTR
p	vtr	M1069	Additional axis: C-axis unclamp	VTR
	vtr	M1070	Chip Air blow ON (nozzle)	VTR
p	spc	M1070	Counter spindle Orientation Cancel	Counter Spindle Tailstock function
p	vtr	M1071	Through-the-tool coolant high pressure OFF	VTR
p	vtr	M1072	Through-the-tool coolant high pressure ON	VTR
p	5689	M1073	Preparation for vertical spindle tool change	VTR
p	5689	M1074	Continuous tool change between vertical and horizontal spindles	VTR
p	5689	M1075	Continuous different tool change between vertical and horizontal spindle	VTR
p	5689	M1076	Horizontal spindle tool unclamp	VTR
p	5689	M1077	Horizontal spindle tool clamp	VTR
p	5689	M1078	Horizontal spindle tool change	VTR
p	vtr	M1079	Oil mist injection	VTR

Ref	new codes since last release		released: Oct 13	
Man	Code	Functional explanation	Option Specification	
p	vtr	M1080	Oil mist cycle mode ON for vertical spindle	VTR
p	5689	M1081	Preparation for horizontal spindle tool change	VTR
p	5689	M1082	Through-spindle coolant middle pressure	VTR
p	vtr	M1083	M-spindle orientation by CCW rotation	VTR
p	vtr	M1084	M-spindle orientation by CW/CCW rotation	VTR
p	list	M1085	Ejector Drill Coolant High Pressure ON	
p	5689	M1086	Attachment air blow ON	VTR
p	vtr	M1087	Touch probe flush ON -- Probe ON/OFF	VTR (not M270)
	5689	M1088	M-spindle extremely low speed operation mode ON (tentative)	VTR
p	spc	M1088	Counter spindle C-axis Unclamp	Counter Spindle Tailstock function
	5689	M1089	M-spindle extremely low speed operation mode ON (tentative)	VTR
p	spc	M1089	Counter spindle C-axis Clamp	Counter Spindle Tailstock function
p	vtr	M1090	M-spindle overload detection invalid	VTR
p	vtr	M1091	M-spindle overload detection valid	VTR
p	vtr	M1092	Work clamping device air blow OFF	VTR
p	vtr	M1093	Work clamping device air blow ON	VTR
p	vtr	M1094	Work clamp	VTR
p	vtr	M1095	Work unclamp	VTR
p	vtr	M1096	Selecting coolant system for vertical spindle	VTR
p	vtr	M1097	Selecting coolant system for horizontal spindle	VTR
p	vtr	M1098	Sensor air blow OFF	VTR
p	vtr	M1099	Sensor air blow ON	VTR
p	vtr	M1100	ATC active tool return cycle command	VTR
p	vtr	M1101	ATC ready (writing active tool No.)	VTR
p	vtr	M1102	ATC air blow OFF	VTR
p	vtr	M1103	ATC air blow ON	VTR
p	vtr	M1104	M-spindle rotation reversal OFF	VTR
p	vtr	M1105	M-spindle rotation reversal ON	VTR
p	vtr	M1106	Cycle counter count up	VTR
p	5689	M1107	Fixture or chuck 2 clamp	VTR
p	5689	M1108	Fixture or chuck 2 unclamp	VTR
p	5689	M1109	Semi-dry MIN through	VTR
p	5689	M1110	Semi-dry MIN nozzle	VTR
p	5689	M1111	Semi-dry MAX through	VTR
p	5689	M1112	Semi-dry MAX nozzle	VTR
p	5689	M1113	Fixture 3 clamp	VTR
p	5689	M1114	Fixture 3 unclamp	VTR
p	5689	M1115	Judging pallet state	VTR
p	5689	M1116	Indexing B-axis attachment	VTR
p	vtr	M1117	2nd automatic door close- ATC Door	VTR
p	vtr	M1118	2nd automatic door open- ATC Door	VTR
	5689	M1119	Spindle Face Air blow	VTR
p	5689	M1120	Work seating monitor ON	VTR
p	5689	M1121	Work seating monitor OFF	VTR
p	5689	M1122	Work seated condition checking air ON	VTR
p	5689	M1123	Work seated condition checking air OFF	VTR
p	5689	M1124	Enable chuck PB during NC moving	VTR
p	5689	M1125	Retracting attachment above the magazine	VTR
p	5689	M1126	Retracting adaptor plug above the magazine	VTR
p	5689	M1127	M06 answer [ATC shutter close] ineffective	VTR
p	5689	M1128	Cancel of M1127	VTR
p	5689	M1129	Magazine pot swing to tool change position	VTR
p	5689	M1130	Pallet out request from stacker crane is not allowed	VTR
p	5689	M1131	Pallet out request from stacker crane is allowed	VTR
p	5689	M1132	Non-contact sensor ; laser OFF	VTR
p	5689	M1133	Non-contact sensor ; laser ON	VTR
p	5689	M1134	Hybrid coolant : oil select	VTR
p	5689	M1135	Hybrid coolant : water select	VTR
p	5689	M1136	Fixture 1 low-pressure clamp	VTR
p	vtr	M1137	Cancel disabling stroke limit	VTR
p	vtr	M1138	Disable stroke limit	VTR
p	vtr	M1139	M-spindle 1st gear selection in synchro-tapping mode	VTR
p	vtr	M1140	M-spindle 2st gear selection in synchro-tapping mode	VTR
p	vtr	M1141	M-spindle 3st gear selection in synchro-tapping mode	VTR
p	5689	M1142	Semi-dry MID through	VTR
p	5689	M1143	Semi-dry MID nozzle	VTR
p	5689	M1144	Jig washing OFF	VTR
p	5689	M1145	Jig washing ON	VTR
p	vtr	M1146	L-tool lock piston unclamp	VTR

Ref	new codes since last release		released: Oct 13	
Man	Code	Functional explanation	Option Specification	
p	vtr	M1147	L-tool lock piston clamp	VTR
p	vtr	M1148	L-tool unhook position (M-spindle 0 deg)	VTR
p	vtr	M1149	L-tool hook position (M-spindle 15 deg)	VTR
p	vtr	M1150	L-tool 180-deg unhook position (M-spindle 180 deg)	VTR
p	vtr	M1151	L-tool 180-deg hook position (M-spindle 195 deg)	VTR
p	spc	M1152	Sub-spindle Mode	Counter Spindle Tailstock function
p	spc	M1153	Tailstock Mode	Counter Spindle Tailstock function
p	vtr	M1154	Sensor air blow (inside diameter) OFF	VTR
p	vtr	M1155	Sensor air blow (inside diameter) ON	VTR
p	vtr	M1156	Touch setter (inside diameter) advance	VTR
p	vtr	M1157	Touch setter (inside diameter) retract	VTR
p	vtr	M1158	Magazine indexing actual tool (ATC Index to Turret head)	VTR
	5689	M1159	Touch Setter measurment travel limit Release OFF	VTR
p	list	M1159	W-axis Cutting Mode	
	5689	M1160	Touch Setter measurment travel limit Release ON	VTR
p	cool	M1160	2nd Steady rest coolant OFF	Multus-B750
p	cool	M1161	2nd Steady rest coolant ON	Multus-B750
p	cool	M1162	3rd Steady rest coolant OFF	Multus-B750
p	cool	M1163	3rd Steady rest coolant ON	Multus-B750
p	cool	M1164	2nd Steady rest air blow OFF	Multus-B750
p	cool	M1165	2nd Steady rest air blow ON	Multus-B750
p	cool	M1166	3rd Steady rest air blow OFF	Multus-B750
p	cool	M1167	3rd Steady rest air blow ON	Multus-B750
p	vtr	M1168	Spindle round conveyer STOP	VTR
p	vtr	M1169	Spindle round conveyer ON CW	VTR
p	vtr	M1170	Spindle round conveyer ON CCW	VTR
p	list	M1171	Tailstock Setting 2nd Spindle	
p	list	M1172	Tailstock Setting 1st Spindle	
p	vtr	M1173	Angle Head Coolant OFF	
p	vtr	M1174	Angle Head Coolant ON	VTR
p	vtr	M1175	Angle Head Air Blow OFF	VTR
p	vtr	M1176	Angle Head Air Blow ON	VTR
p	6193	M1177	Unloader Carrier Positioning (L-spindle IN)	Unloader option
p	6193	M1178	Unloader Carrier Positioning (L-spindle OUT)	Unloader option
p	6193	M1179	Unloader Carrier Positioning (R-spindle IN)	Unloader option
p	6193	M1180	Unloader Carrier Positioning (R-spindle OUT)	Unloader option
p	6193	M1181	Unloader Carrier Positioning (Retract Point)	Unloader option
p	6193	M1182	Unloader Hand Upper	Unloader option
p	6193	M1183	Unloader Hand Lower	Unloader option
p	6193	M1184	Unloader Hand Middle	Unloader option
p	6193	M1185	Unloader Call Enable Confirmation 2	Unloader option
		M1186		
		M1187		
p	cool	M1188	AJC Coolant OFF	
p	cool	M1189	AJC Coolant ON	
p	list	M1190	Tailstock Tool Chucking Error Detect Air OFF	
p	list	M1191	Tailstock Tool Chucking Error Detect Air ON	
p	2spH	M1192	Waiting Exclusive ON	2SP-H
p	2spH	M1193	Waiting Exclusive cancel	2SP-H
p	list	M1194	Tailstock Mode Check Interlock Release	
p	list	M1195	Measurement Sensor Unit Advance	
p	list	M1196	Measurement Sensor Unit Retract	
p	list	M1197	Coolant Pressure Select	
p	list	M1198	Air Drill 2 ON	
p	list	M1199	Air Drill 2 OFF	
p	list	M1200	M-spindle Variation control OFF	
p	list	M1201	M-spindle Variation control ON	
p	YB	M1202	APC Pallet Unclamp	APC
p	YB	M1203	APC Pallet Clamp	APC
p	YB	M1204	APC Pallet Taper Cone Unclamp	APC
p	YB	M1205	APC Pallet Taper Cone Clamp	APC
p	YB	M1206	APC Pallet Table Down	APC
p	YB	M1207	APC pallet Table Up	APC
p	cool	M1208	3rd Coolant 1 ON	
p	cool	M1209	3rd Coolant 1 OFF	
p	spc	M1210	Change Spindle Speed in Thread mode OFF	VSST
p	spc	M1211	Change Spindle Speed in Thread mode ON	VSST
	vtr	M1212	Tool Cleaning Air Blow ON	VTR
	vtr	M1213	Tool Cleaning Air Blow ON	VTR

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Man	Code	Functional explanation	Option Specification
p	list	M1214 Ceiling Telescopic Cover Close	
p	list	M1215 Ceiling Telescopic Cover Open	
	YB	M1216 Spindle Unclamp	APC
	YB	M1217 Spindle Clamp	APC
		M1218	
		M1219	
		M1220	
	6322	M1221 Coolant pressure High Level A	LT-3T spec, HP 7 level
	6322	M1222 Coolant pressure High Level B	LT-3T spec, HP 7 level
	6322	M1223 Coolant pressure High Level C	LT-3T spec, HP 7 level
	6322	M1224 Coolant pressure High Level D	LT-3T spec, HP 7 level
	6322	M1225 Coolant pressure High Level E	LT-3T spec, HP 7 level
	6322	M1226 Coolant pressure High Level F	LT-3T spec, HP 7 level
	6322	M1227 Coolant pressure High Level G	LT-3T spec, HP 7 level
p	air	M1228 3rd Air Blow E OFF	
p	air	M1229 3rd Air Blow E ON	
		M1230	
		M1231	
		M1232	
		M1233	
		M1234	
		M1235	
		M1236	
		M1237	
		M1238	
		M1239	
		M1240	
		M1241	
		M1242	
		M1243	
		M1244	
		M1245	
		M1246	
		M1247	
		M1248	
		M1249	
		M1250	
		M1251	
		M1252	
		M1253	
p	air	M1254 3rd Air Blow C OFF	
p	air	M1255 3rd Air Blow C ON	
		M1256	
		M1257	
		M1258	
		M1259	
		M1260	
		M1261	
		M1262	
		M1263	
		M1264	
		M1265	
<b>Reference Manuals</b>			
p	List	5946 P300 Programming Appendix	
h	Lst2	n/a P300 Control Help list	
	Pgm	5946 P300 Programming	
	Spc	5948 P300 Special Function	
	Sub	6146 P300 Sub-spindle function	
	Yax	6147 P300 Y-axis function	
	Gag	5908 P300 Gauging function (inc. Y)	
	GagA	5972 P300 Gauging- Application	
	SlY	6082 P300 Slant Y-axis Gauging	
	Cas	5881 CAS- Basic	
	Oper	5895 P300-L/S Operation (basic)	
	LT	6074 P300 LT-EX Operation	
	Lvt	6170 P300 LVT Oper.	
	Cam	6344 P300 Cam Lathe	
	lawV	6332 P300 Law-V and ACC	

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Man	Code	Functional explanation	Option Specification
2spH	6244	P300 2SP-H Oper (inc-OGL)	
Mult	5947	P300S Multus (H1) Oper	
YB	6055	P300S VTM-YB	
VTR	6336	P300S VTR Oper	
LBB	6120	P300 B750 Long Boring Bar	