

BASIC TURNKEY M-FUNCTIONS (8025T)

	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	
M00:	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	- PROGRAM STOP
	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1	1	
M02:	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	- PROGRAM END, EVERTHING OFF,
	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	
M03:	0	0	0	0	0	0	1	0	0	0	0	0	0	0	0	0	0	- SPINDLE CW
	0	0	0	0	0	0	0	1	0	0	0	0	0	0	0	0	1	
M04:	0	0	0	0	0	0	0	1	0	0	0	0	0	0	0	0	0	-SPINDLE CCW
	0	0	0	0	0	0	1	0	0	0	0	0	0	0	0	0	1	
M05:	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	- SPINDLE OFF
	0	0	0	0	0	0	1	1	0	0	0	0	0	0	0	1	1	
M08:	0	0	0	0	0	0	0	0	1	0	0	0	0	0	0	0	0	-COOLANT ON
	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1	
M09:	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	- COOLANT OFF
	0	0	0	0	0	0	0	0	1	0	0	0	0	0	0	1	1	
M30:	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	- PROGRAM END, EVERTHING OFF, RETURN TO BEGINING
	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	

BIT 16 = 0: M function executed at beginning of block.
= 1: M function executed at end of block.

BIT 17 = 0: [P602(7) = 0] CNC doesn't wait for M-DONE signal.
= 1: [P602(7) = 0] CNC waits for M- DONE signal for ***THIS*** M function only.
[P602(7) = 1] CNC waits for M-DONE signal for all M functions and will ignore the value of bit 17.