

## BASIC TURNKEY M-FUNCTIONS (8025M)

	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	
<b>M00:</b>	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	
<b>M02:</b>	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	
<b>M03:</b>	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	
<b>M04:</b>	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	
<b>M05:</b>	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	0	1	
<b>M08:</b>	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	
<b>M09:</b>	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	0	1	
<b>M30:</b>	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:** [P605(5) = 0] CNC doesn't wait for M-DONE signal.  
**= 1:** [P605(5) = 0] CNC waits for M- DONE signal for ***THIS*** M function only.  
[P605(5) = 1] CNC waits for M-DONE signal for all M functions and will ignore the value of bit 17.