

CODE LIST OF M COMMANDS ○-STANDARD ☆-OPTION

M CODE	FUNCTION	ZL-15S		ZL-15SH		ZL-15SHC	
		MAIN	SUB	MAIN	SUB	MAIN	SUB
M00	PROGRAM STOP	○	○	○	○	○	○
M01	OPTIONAL STOP	○	○	○	○	○	○
M02	END OF PROGRAM	○	○	○	○	○	○
M03	NORMAL SPINDLE POSITION	○	○	○	○	○	○
M04	REVERSE SPINDLE POSITION	○	○	○	○	○	○
M05	SPINDLE STOP	○	○	○	○	○	○
M06	COOLANT PUMP ON	○	○	○	○	○	○
M08	COOLANT PUMP OFF	○	○	○	○	○	○
M10	ORICE CLAMP	○	○	○	○	○	○
M11	ORICE UNCLAMP	○	○	○	○	○	○
M13	NORMAL KILLING POSITION			○		○	
M14	REVERSE KILLING POSITION			○		○	
M17	NORMAL TRIST POSITION	○	○	○	○	○	○
M18	REVERSE TRIST POSITION	○	○	○	○	○	○
M19	SPINDLE ORIENTATION	☆	☆	○	☆	☆	☆
M20	SPINDLE ORIENTATION CANCEL	○	○	○	○	○	○
M23	CHANGING IN	○	○	○	○	○	○
M24	CHANGING OFF	○	○	○	○	○	○
M26	IN-POSITION CHECK ON	○	○	○	○	○	○
M28	IN-POSITION CHECK OFF	○	○	○	○	○	○
M30	RESET & REWIND	○	○	○	○	○	○
M31	INTERLOCK IN-PAGE ON	○	○	○	○	○	○
M32	INTERLOCK IN-PAGE OFF	○	○	○	○	○	○
M35	SYNCHRONOUS OPERATION IN		○		○		○
M36	SYNCHRONOUS OPERATION OFF		○		○		○

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