

## Haas M codes

M00 PROGRAM STOP (SETTING 42, 101)  
M01 OPTIONAL PROGRAM STOP (SETTING 17)  
M02 PROGRAM END  
M03 SPINDLE ON FORWARD (S) (SETTING 144)  
M04 SPINDLE ON REVERSE (S) (SETTING 144)  
M05 SPINDLE STOP  
M08 COOLANT ON (SETTING 32)  
M09 COOLANT OFF  
M10 CHUCK CLAMP (SETTING 92)  
M11 CHUCK UNCLAMP (SETTING 92)  
M12 AUTO AIR JET ON (P)  
M13 AUTO AIR JET OFF  
M14 MAIN SPINDLE CLAMP  
M15 MAIN SPINDLE UNCLAMP  
M17 ROTATE TURRET FORWARD (T) (SETTING 97)  
M18 ROTATE TURRET REVERSE (T) (SETTING 97)  
M19 ORIENT SPINDLE (P,R)  
M21 TAILSTOCK ADVANCE (SETTING 93, 94, 106, 107, 121, 145)  
M22 TAILSTOCK RETRACT (SETTING 105)  
M23 ANGLE OUT OF THREAD ON (SETTING 95, 96)  
M24 ANGLE OUT OF THREAD OFF  
M30 PROGRAM END AND RESET (SETTING 2, 39, 56, 83)  
M31 CHIP AUGER FORWARD (SETTING 114, 115)  
M32 CHIP AUGER REVERSE (SETTING 114, 115)  
M33 CHIP AUGER STOP  
M36 PARTS CATCHER ON  
M37 PARTS CATCHER OFF  
M41 SPINDLE LOW GEAR OVERRIDE  
M42 SPINDLE HIGH GEAR OVERRIDE  
M43 TURRET UNLOCK (FOR SERVICE USE ONLY)  
M44 TURRET LOCK (FOR SERVICE USE ONLY)  
M51-M58 OPTIONAL USER M CODE SET  
M59 OUTPUT RELAY SET (N)  
M61-M68 OPTIONAL USER M CODE CLEAR  
M69 OUTPUT RELAY CLEAR (N)  
M76 PROGRAM DISPLAYS INACTIVE  
M77 PROGRAM DISPLAYS ACTIVE  
M78 ALARM IF SKIP SIGNAL FOUND  
M79 ALARM IF SKIP SIGNAL NOT FOUND  
M85 AUTOMATIC DOOR OPEN (SETTING 51, 131)

M86 AUTOMATIC DOOR CLOSE (SETTING 51, 131)  
M88 HIGH PRESSURE COOLANT ON (SETTING 32)  
M89 HIGH PRESSURE COOLANT OFF  
M93 AXIS POSITION CAPTURE START (P,Q)  
M94 AXIS POSITION CAPTURE STOP  
M95 SLEEP MODE (hh:mm)  
M96 JUMP IF NO SIGNAL (P,Q)  
M97 LOCAL SUB-ROUTINE CALL (P,L)  
M98 SUB-PROGRAM CALL (P,L)  
M99 SUB-PROGRAM/ROUTINE RETURN OR LOOP (P) (SETTING 118)  
M109 INTERACTIVE USER INPUT (P)  
M110 TAILSTOCK CHUCK CLAMP (SETTING 122)  
M111 TAILSTOCK CHUCK UNCLAMP (SETTING 122)  
M119 SUB-SPINDLE ORIENT (P,R)  
M121-M128 OPTIONAL USER M CODE INTERFACE WITH M-FIN SIGNAL  
M133 LIVE TOOL DRIVE FORWARD (P)  
M134 LIVE TOOL DRIVE REVERSE (P)  
M135 LIVE TOOL DRIVE STOP  
M143 SUB-SPINDLE FORWARD (P)  
M144 SUB-SPINDLE REVERSE (P)  
M145 SUB-SPINDLE STOP  
M154 C AXIS ENGAGE (SETTING 102)  
M155 C AXIS DISENGAGE  
M164 ROTATE APL GRIPPERS TO "n" POSITION (Pn)  
M165 OPEN APL GRIPPER 1 (RAW MATERIAL)  
M166 CLOSE APL GRIPPER 1 (RAW MATERIAL)  
M167 OPEN APL GRIPPER 2 (FINISHED MATERIAL)  
M168 CLOSE APL GRIPPER 2 (FINISHED MATERIAL)