

Haas Mill M Codes

M-Code	Description
M00	Program Stop
M01	Optional Program Stop
M02	Program End (Setting 39)
M03	Spindle On, Clockwise (S) (Setting 144)
M04	Spindle On, Counterclockwise (S) (Setting 144)
M05	Spindle Stop
M06	Tool Change (T) (Setting 42, 87, 155)
M08	Coolant On (Setting 32)
M09	Coolant Off
M10	4th Axis Brake On
M11	4th Axis Brake Release
M12	5th Axis Brake On
M13	5th Axis Brake Release
M16	Tool Change (T) (Same as M06)
M17	APC Pallet Unclamp and Open APC Door
M18	APC Pallet Clamp and Close APC Door
M19	Orient Spindle (P,R values optional)
M21-M28	Optional User M Code Interface with M-Fin Signals
M30	Program End and Reset (Setting 2, 39, 56, 83)
M31	Chip Auger Forward (Setting 114,115)
M33	Chip Auger Stop
M34	Coolant Spigot Position Down, Increment (+1)
M35	Coolant Spigot Position Up, Decrement (-1)
M36	Pallet Part Ready (P)

M39	Rotate Tool Turret (T#) (Setting 86)
M41	Spindle Low Gear Override
M42	Spindle High Gear Override
M50	Execute Pallet Change (P) (Setting 121 thru,129)
M51-M58	Optional User M Code Set
M59	Output Relay Set (N)
M61-M68	Optional User M Code Clear
M69	Output Relay Clear (N)
M75	Set G35 or G136 Reference Point
M76	Control Display Inactive
M77	Control Display Active
M78	Alarm if Skip Signal Found
M79	Alarm if Skip Signal Not Found
M80	Automatic Door Open (Setting 131)
M81	Automatic Door Close (Setting 131)
M82	Tool Unclamp
M83	Auto Air Jet On
M84	Auto Air Jet Off
M86	Tool Clamp
M88	Coolant Through the Spindle On
M89	Coolant Through the Spindle Off
M93	Axis POS Capture Start (P, Q)
M94	Axis POS Capture Stop
M95	Sleep Mode
M96	Jump if No Input (P, Q)
M97	Local Sub-Program Call (P, L)
M98	Sub Program Call (P, L)

M99	M97 Local Sub-Program or M98 Sub-Program Return or Loop Program (Setting 118)
M101	MOM (Minimum Oil Machining) CANNED CYCLE MODE (I)
M102	MOM (Minimum Oil Machining) MODE (I,J)
M103	MOM (Minimum Oil Machining) MODE CANCEL
M109	Interactive User Input (P)