

5.12 M CODES

Table 5-2: M code list

CODE	FUNCTION	NOTES
M0	Unconditional NC stop	
M1	Conditional NC stop	
M2	NC program end	
M3	Spindle CW	
M4	Spindle CCW	
M5	Spindle Stop	
M6	Execute tool change	
M7	Activate Coolant 1	
M8	Activate Coolant 2	
M9	Stop all coolant	
M11	Set current tool pocket number to 1	Used to re-synchronize tool magazine
M19	Orient tool and lock	
M31	Exchange pallet	Reserved
M32	Call pallet A	Reserved
M33	Call pallet B	Reserved
M34	Unload pallet	Reserved
M40	Spindle auto gear range change	
M41	Spindle change to low gear	
M42	Spindle change to high gear	
M52	Air/Oil oil P timing	Air/Oil oil pump cycled once
M60	Set M60/M61 output	Misc. M Function. Apply A axis brake.
M61	Reset M60/M61 output	Misc. M Function. Release A axis brake.
M62	Set M62/M63 output	Misc. M Function. Apply B axis brake.
M63	Reset M62/M63 output	Misc. M Function. Release B axis brake.
M64	Set M64/M65 output	Misc. M Function. Also probe 1
M65	Reset M64/M65 output	Misc. M Function. Also probe 2
M66	Set M66/M67 output	Misc. M Function
M67	Reset M66/M67 output	Misc. M Function

Siemens 840d M Codes

**Lihui Wang, National Research Council
Canada, International Conference on
Flexible Automation and Intelligent
Manufacturing (14th : 2004 : Ryerson
University)**

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Designing Small Weapons Jose Herrera-Ramirez, Luis Zuñiga-Aviles, 2022-06-09 This book focuses on developing small weapons following the lifecycle of a firearm from design to manufacture. It demonstrates how modern technologies can be used at every stage of the process such as design methodologies CAD CAE CAM software rapid prototyping test benches materials heat and surface treatments and manufacturing processes. Several case studies are presented to provide detailed considerations on developing specific topics. Small weapons are designed to be carried by one person; examples are pistols, revolvers, rifles, carbines, shotguns, and submachine guns. Beginning with a review of the history of weapons from ancient to modern times, this book builds on this by mapping out recent innovations and state-of-the-art technologies that have advanced small weapon design. Presenting a comprehensive guide to computer design tools used by weapon engineers, this book demonstrates the capabilities of modern software at all stages of the process, looking at the computer-aided design, engineering, and manufacturing. It also details the materials used to create small weapons, notably steels, engineering polymers, composites, and emerging materials. Manufacturing processes, both conventional and unconventional, are discussed, for example, casting, powder metallurgy, additive manufacturing, and heat and surface treatments. This book is essential reading to those in the field of weapons, such as designers, workers in research and development, engineering and design students, students at military colleges, sportsmen, hunters, and those interested in firearms. Dr. Jose Martin Herrera Ramirez is a military engineer with experience in the field of weapon and ammunition development. After receiving his PhD in Materials Science and Engineering from the Paris School of Mines in France, he was the head of the Applied Research Center and Technology Development for the Mexican Military Industry CIADTIM. He now researches the development of metallic alloys and composites at the Research Center for Advanced Materials CIMAV in Chihuahua, Mexico. Dr. Luis Adrian Zuñiga Aviles is a military engineer with wide experience in the field of weapon and ammunition development. He was head of the prototypes and simulation departments at the Applied Research Center and Technology Development for the Mexican Military Industry CIADTIM and head of engineering of the Production Directorate. He received his PhD in Science and Technology on Mechatronics from the Center for Engineering and Industrial Development CIDESI in Queretaro, Mexico. He now researches the new product design and development for military application, machinery, robotics, and medical devices in the Faculty of Medicine at the Autonomous University of Mexico State UAEMex and the Faculty of Engineering at UAEMex as part of the Researchers for Mexico program CONACYT.

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Twin-Control Mikel Armendia, Mani Ghassempouri, Erdem Ozturk, Flavien Peysson, 2019-01-05 This open access book summarizes the results of the European research project Twin model based virtual manufacturing for machine tool process simulation and control Twin Control The first part reviews the applications of ICTs in machine tools and manufacturing from a scientific and industrial point of view and introduces the Twin Control approach while Part 2 discusses the development of a digital twin of machine tools The third part addresses the monitoring and data management infrastructure of machines and manufacturing processes and numerous applications of energy monitoring Part 4 then highlights various features developed in the project by combining the developments covered in Parts 3 and 4 to control the manufacturing processes applying the so called CPSs Lastly Part 5 presents a complete validation of Twin Control features in two key industrial sectors aerospace and automotive The book offers a representative overview of the latest trends in the manufacturing industry with a focus on machine tools

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