

## Haas Mill M Codes

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

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