

Supported M-codes

M_codes are generally change the state of the machine including the run status of the G code interpreter. All M_code string substitutions are case insensitive.

M0 (mandatory)stop

A stop will pause the interpreter and display an alert dialog giving the user the option to either continue or abort the current interpretation.

M1 optional stop

M1 will perform a stop only if optional code execution is enabled.

M2 (program)end

M2 will end the current interpretation. The user is not given the option to continue. Program end is not required to be the last line in the program. Program end is implied if the end of the program is reached.

M3 spindle (on|run) (cw|clockwise)?

M3 will start the spindle running clockwise at the current spindle speed setting (if variable speed).

M4 spindle (on|run) (ccw|counter-clockwise)?

M4 will start the spindle running counter-clockwise at the current spindle speed setting (if variable speed).

M5 spindle (off|stop)

Spindle off will stop the spindle if running.

M7 coolant (#)(A|1)(on)

M7 will set coolant 1 on if enabled.

M8 coolant (#)(B|2)(on)

M8 will set coolant 2 on if enabled.

M9 coolants off

M9 will stop both coolants if running.

M30 exit

M30 is process the same as M2.

M97 Jump(to)

M97 will transfer the interpretation to the specified target label. The M97 command line is not required to have a label of its own.

M98 Call(to)

M98 will transfer the interpretation to the specified target label similar to the M97 command except that the interpreter records the following command as the target of a subsequent M99 return command. The M98 command does not require a label of its own or a label for the following command.

M99 return

M99 will transfer the interpretation to the command recorded as a return target by a prior M98 command execution. The M99 command does not require a label of its own.

M100 user pause

M100 will pause the interpretation having the same effect as if the user pressed one of the pause buttons. The effect is similar to a stop command except that no alert dialog is raised. The user can either continue or abort by pressing one of the corresponding buttons.

