

## M-Codes

M00	Program stop
M01	Optional program stop
M03	Spindle on clockwise
M04	Spindle on counterclockwise
M05	Spindle off
M06	Tool change
M08	Coolant on
M09	Coolant off
M30	Program end, return to start;

```
:0005 (M-CODE EXAMPLE);  
N1 T0101 (10MM ENDMILL);  
G90 G21;  
G42 P5.0;  
S700 M03;  
G00 X175.0 Y25.0 Z10.0 M06;  
Z-6.0;  
G01 X125.0 F100.0;  
Y60.0;  
G03 X95.0 Y60.0 I150.0 J60.0;  
G01 Y25.0 F0.2;  
X80.0;  
X40.0 Y65.0;  
X-15.0;  
G40;  
G00 Z10.0 M09;  
G28 X0.0 Y0.0;  
M05;  
M01;  
N2 T0202 (5MM DRILL);  
M06;  
S500 M03;  
G00 X60.0 Y60.0 Z10.0 M06;  
G81 Z-10.0 F50.0;  
X-40.0;  
Y-40.0;  
X40.0;  
X-20.0 Y20.0;  
G80;  
G28 X0.0 Y0.0 M09;  
M05;  
M30;
```

# M Codes For Cnc Laser

**Wenbin Ji**



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