2.8.2 M CODES FOR INTERNAL PROCESSING (M90 TO M199)

M90 through M199 are used only for internal processing. Even when they are programmed, no external output signal (BCD and decoded output) is sent.

M90†: Program interrupt off

M91†: Program interrupt on

M92†: Multi-active register off

M93†: Multi-active register on

M94: Mirror image off

M95: Mirror image on

M96†: Tool radius compensation C: circular path mode

M97†: Tool radius compensation C: intersection computing mode

M98: Subroutine program call

M99: Subroutine program end

M100 to 199: Used for enhansed codes

2.8.3 PROGRAM INTERRUPTION ON/OFF (M90, M91)†

The following M codes are used for the program interruption function.

M code	Meaning
M90 ◥	Program interrupt function OFF
M91	Program interrupt function ON

Note: When power is applied or the control is reset, the control is in the state of M code marked with ◥.

· M91 P ····· ;

During the time from this command to an M90 command, whenever a program interruption signal is received, the program under execution is interrupted (if the machine is in motion, it is stopped after deceleration), and the a jump is made to the program the number of which is written after the P.

· M90

With this command, the program interrupt function is cancelled.

2.8.4 MULTI-ACTIVE REGISTERS ON/OFF (M93, M92)†

M code	Meaning
M92 ◥	Multi-active register off
M93	Multi-active register on

Note: When power is applied or the control is reset, the control is in the state of M code marked with ◥.

· M93:

During the time from this command to M92, the control assumes the 5 blocks-advance-reading mode. Namely, up to 5 blocks of data are read in advance for the following operation.

Inter-block stoppage can be eliminated when the program is so made that the operation time of advance reading of 5 blocks is longer than processing time of advance reading of next 5 blocks of data.

· M92:

This command cancels 5 blocks-advance-reading mode.

NOTE: In tool radius compensation C mode, the blocks without move command can be contained(up tc two blocks). Under this condition, 7 blocks, including the two blocks, may be read in advance.

2.8.5 MIRROR IMAGE·ON/OFF (M95, M94)

M code	Meaning
M94 ◥	Mirror image OFF
M95	Mirror image ON

Note: When power is applied or the control is reset, the control is in the state of M code marked with ◥.

· With these codes, mirror image operation can be started and stopped at any desired point in the program. These commands must always be made on a single block.

· M94 and M95 are modal. When the power supply is turned on, M94 (OFF) is in effect.

· The axis on which mirror image is to be effected is specified by setting #6000D0 to D3 (or mirror image axis designation switch.) For this procedure, refer to 6.1.25 MIRROR IMAGE AXIS SELECT SWITCH.