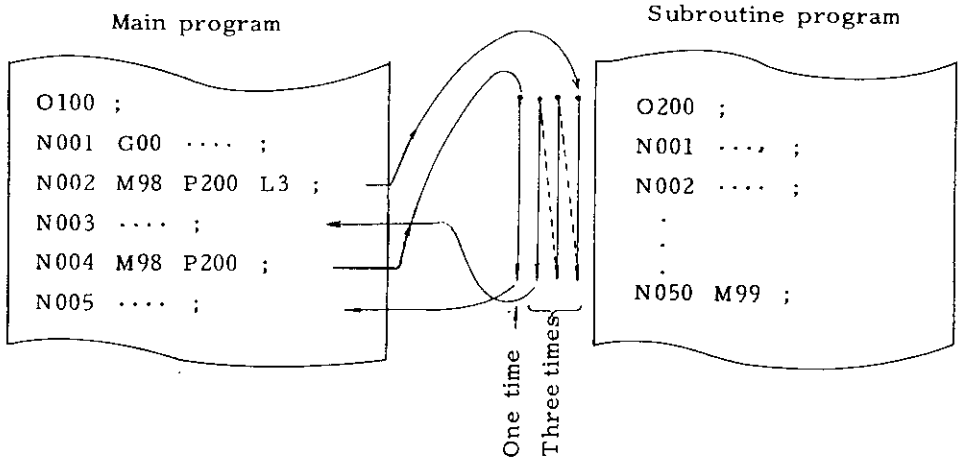
2.8.7 SUBROUTINE PROGRAM (M98, M99) (CONT'D)

EXAMPLE

Call of subroutine program and execution of it are made in the sequence shown below.



· Special use of M99

M99 P··· ;

With this command, the main program does not return to the block following the M98 block after executing the subroutine program, but returns to the block with a sequence No. specified by the P code.

NOTES:

· If the program number specified by the P code is not found, this is regarded as an error "041."

· While a subroutine program is repeated L times, the number of remaining repetitions may be displayed. For details, refer to 4.3 DISPLAY AND WRITING OPERATION.

· This function is usable when subroutine programs are stored in the part program memory. The main program can either be commanded from NC tape or the part program memory.

· When the nesting of subroutine programs is attempted more than 4 times, an error state is caused.

· Commanding M99; in main program will return the execution of the program to the head of the main program and control endless operation.

2.8.8 OTHER M CODES

For using M codes, other than those mentioned above, refer to the machine tool builder's manual.

Table 2.20 Typical Examples of M codes for Machine

M code	Meanings	Remarks
M03	Spindle forward running	M03 and M04 are not switchable. M05 (stop) must be intermediated.
M04	Spindle reverse running	
M05	Spindle stop	
M08	Coolant on	
M09	Coolant off	

When these M codes are given in a block together with move command, whether the M commands are executed simultaneously or after completion of move command, are determined by the type of machine. Refer to the machine tool builder's manual.

2.8.9 2ND MISCELLANEOUS FUNCTION (B-FUNCTION)†

B-function and T 4-digit† commands cannot be used simultaneously.

Three digits following the address B give index table positions.