M Code	Turning	Milling
MOO	Compulsory program stop	Compulsory program stop
MOI	Optional program stop	Optional program stop
M02	End of program (usually with reset no rewind)	End of program (usually with reset no rewind)
M03	Spindle rotation normal	Spindle rotation normal
M04	Spindle rotation reverse	Spindle rotation reverse
M05	Spindle stop	Spindle stop
M06	Tool change	Automatic tool change (ATC)
M07	High-pressure Coolant mist ON	High-pressure Coolant mist ON
M08	Coolant ON (coolant pump motor ON)	Coolant ON (coolant pump motor ON)
M09	Coolant OFF (coolant pump motor OFF)	Coolant OFF (coolant pump motor OFF)
MIO	Chuck open	
M11	Chuck close	
M12	Tailstock quill IN	
M13	Tailstock quill OUT	
M19	Spindle orientation (optional)	Spindle orientation
M21	Tailstock forward	
M22	Tailstock backward	
M28	Return to origin	
M29	Rigid tap	
M30	Program end (always with reset and rewind)	Program end (always with reset and rewind)
M41	Low gear select	Low gear select
M42	High gear select	High gear select
M68	Hydraulic chuck close	
M69	Hydraulic chuck open	
M78	Tailstock advancing	
M79	Tailstock reversing	
M94	Cancel mirrorimage	Cancel mirrorimage
M95	Mirrorimage of X axis	Mirrorimage of X axis
M96	Mirrorimage of Y axis	Mirrorimage of Y axis
M98	Subprogram call	Sub program call
M99	Subprogram end	Subprogram end

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Pawan Negi, Mangey Ram, Om Prakash Yadav

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