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468 Section 19: Miscellaneous April 2003 Fadal User Manual Note: An M20 Code Is  
Used To Close The Doors When The Machine Tool Is Not Equipped With A General  
Indexer. Note: When The Doors Are Closed And The M20 Is Coded, The Machine Will  
Wait For A Signal. To Override This Condition, Open And Close The Doors Manually.  
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Rigid Tapping With Fadal Cnc Format 1 N1m6t1(4-40tap) N2 G0g80 G90s1500.2 M5  
(select Correct Spindle Range) ( DOnot Turnthe Spindleon!) N3 G0 E1 X1. Y1.  
(rapidto First Holelocation.) N4 H1 Z.4 M8 (rapid To .4above Part And Turn On  
Coolant) N5 G84.1 G98 X1. Y1. Z-.5 R.4q.025 F1500 (rigid Tap Cycle, See Variables  
Below) N6 X2. Y2. (next Hole) N7 ... 4th, 2020

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Subroutine A Subroutine Ends With The L Word That Starts The Next Subroutine Or  
With An M17. The M17 Must Be The Only Word In The Block In Which It Appears.  
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Combination With The M92 Code. • This Code Is Modal And Will Remain In Effect Until The G9 Code Is Used. 4th, 2020

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April 2003 Section 2: M Functions 23 Fadal User Manual G53 Z0 M6 T1 E0 X0 Y0 M2 (This Is The End Of The Main Program). M3 Spindle CW M3 Is Used To Start Spindle Rotation In A Clockwise Direction. EXAMPLE: M6 T7 (TOOL #7, #1 C'DRILL M1 G90 G0 S300 M3 E1 X0 Y0 (The Spindle Will Turn On CW At This Line). 5th, 2020

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Fadal Normally Supplied M-Functions Fadal Supplies M-Functions M60 Thru M69 With All Machines. They Are Output On The 1100-1 Board. The Even Numbered M-code Activates The Relay And The Odd Number Deactivates The Relay. Each Set Of M-codes Has A Relay And A Fuse. On The Terminal Block (TB), Each M-function Set Has Two Connections With A 4th, 2020

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