

Siemens M Codes

M codes are sometimes known as auxiliary or miscellaneous functions.

Code	Description
M00-----	Machine Stop
M01-----	Optional Stop (<i>Must be activated to function</i>)
M23-or-TAPMODE-----	Tap/Drill ON
M25-or-TAPCANCEL-----	Tap/Drill OFF
M30-----	End of program with rewind to beginning
M36-----	Lower torch with counterbalance (<i>MDA ONLY</i>)
M37-----	Lower torch without counterbalance (<i>MDA ONLY</i>)
M40-or-MARKINGMODEON---	Marking pressure ON (<i>modal</i>)(3400 Heavy Only)
M41-or-FORMINGMODEON---	Forming pressure ON (<i>modal</i>)
M42-or-FORMINGMODEOFF--	Forming pressure OFF (<i>modal</i>)
M46-----	Punch lube ON (<i>modal</i>)
M47-----	Punch lube OFF (<i>modal</i>)
M54-----	Medium stripper height
M55-----	Normal stripper height
M56-----	Full up stripper height
M61-----	Light material acceleration rate (<i>up to 200 lbs. / 90 kgs.</i>)
M62-----	Medium material acceleration rate (<i>201 lbs. to 660 lbs. / 90.1 kgs. to 300 kgs.</i>)
M63-----	Heavy material acceleration rate (<i>661 lbs. to 1000 lbs. / 300.1 kgs. to 450 kgs.</i>)
M73-----	Use steel dust collector (default on power up)
M74-----	Use aluminum dust collector
M75-or-PUNCHON-----	Punch ON
M77-----	Bypass small parts detection (<i>one time shot</i>) <i>Must be followed by an M80 command</i>
M80-or-PARTDOOR-----	Drop door cycle
M85-or-PUNCHOFF-----	Punch OFF
M87-----	Manual sheet load cycle
M94-----	Opens skeleton removal table (<i>optional</i>)
M95-----	Closes skeleton removal table (<i>optional</i>)
M97-or-CLAMPCONTROL-----	Opens clamps without load pin or material stops
M170-----	PlatePARTNER™ auto load cycle (<i>optional</i>)
M270-----	PlatePARTNER™ unload cycle (<i>optional</i>)

Note: Any commands marked “MDA only” should not be used in standard programs. They are for recovery or adjustment purposes only.

Tool Caddy Specific M Codes

Note: These commands are for use in MDA only. They should not be used in programs and are for reference in case of tool change recovery or adjustment.

CAUTION: These commands will execute **regardless** of X axis position. Verify alignment to allow the arm to go up and down safely to prevent machine damage.

M160-----	Lower Tool Caddy (MDA ONLY)
M161-----	Raise Tool Caddy (MDA ONLY)
M162-----	Open both grippers (MDA ONLY)
M163-----	Close both grippers (MDA ONLY)
M164-----	Rotate arm (MDA ONLY)

Part Handler II™ Specific M Codes

M101-----	Programmed magnets to low power
M102-----	Programmed magnets to medium power
M103-----	Programmed magnets to high power
M104-----	All magnets on at full strength
M105-----	De-magnetize all magnets
M106-----	Activates magnets at programmed strength
M110-----	Releases the squaring cylinder (MDA ONLY)
M111-----	Engages the squaring cylinder (MDA ONLY)
M112 H1=XX H2=XX H3=XX--	Magnet selections <i>Refer to Programming Manual for more detail</i>
M113 H1=XX.XX H2=XX.XX H3=XX.XX	Unload cycle pick and drop <i>Refer to Programming Manual for more detail</i>
M114 H1=XX.XX H2=XX.XX H3=XX.XX	Unload cycle pick and stack <i>Refer to Programming Manual for more detail</i>
M171-or-RAWLOAD-----	Raw material load command