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G98 - Per minute feed; Lathe G99 - Per revolution feed; Lathe.
CNC M Codes. M00 - Program stop; Mill and Lathe M01 -
Optional program stop; Lathe and Mill M02 - Program end; Lathe
and Mill M03 - Spindle on clockwise; Lathe and Mill M04 -
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M19 Orient Spindle (Optional) M19 adjusts the spindle to a fixed position. The spindle only orients to the zero position without the optional M19 orient spindle feature.. The orient spindle function

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allows P and R address codes. For example, M19 P270. orients the spindle to 270 degrees. The R value allows the programmer to specify up to two decimal places; for example, M19 R123.45.

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