

The objective of these questions is to provide an exercise in the usage of miscellaneous functions - Part 1 of 2.

#	Question	Answer
1	Describe briefly the purpose of <i>Miscellaneous Functions</i>	
2	Name at least three M-functions that are activated at the end of block (when axis motion is completed) and explain their meaning	
3	Name at least three M-functions that control operation of various machine accessories and explain their meaning	
4	What is the difference between M02 and M30?	
5	Which M-functions will stop a rotating spindle? Name as many standard functions as possible	
6	Identify typical situations that would justify using M00 function in the program	

7	Identify typical situations that would justify using M01 function in the program	
8	Which M-functions will cancel coolant flow? Name as many standard functions as possible	
9	Which M-function is used to program <b>Optional Stop</b> ?	
10	Name at least two M-functions that are activated at the start of block (simultaneously with axis motion)	
11	If the CNC machine accepts functions M07, M08 and M09 - what is the purpose of each function?	
12	If three gear ranges are available on a CNC lathe, what would be the common M-functions for each?	