



Overview - Auto Air Jet Blast - Operation

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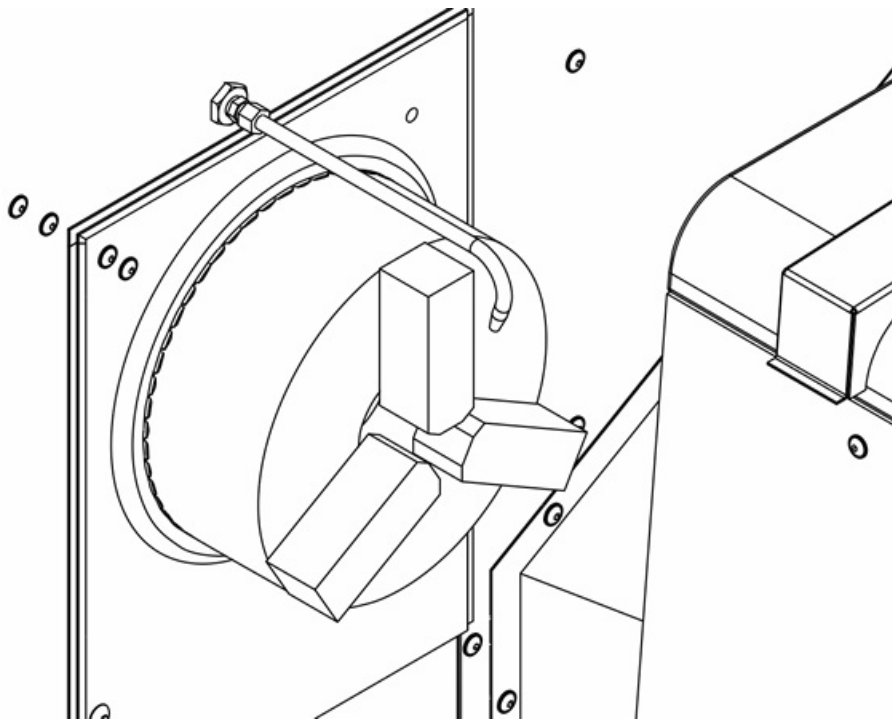


Translation Available



Machines shipped after June 2013 have different inputs to use the Auto-Air-Jet-Blast option. The inputs are different for the main and secondary spindles.

Main Spindle Operation



- Main Spindle Air Jet Blast On: M12
- Main Spindle Air Jet Blast Off: M13



Note: You can use the **P** code to control the time that the Air Jet Blast stays on.

Example 1: The Air Jet Blast stays on for 2 seconds.

```
%  
M12 P2.;  
%
```

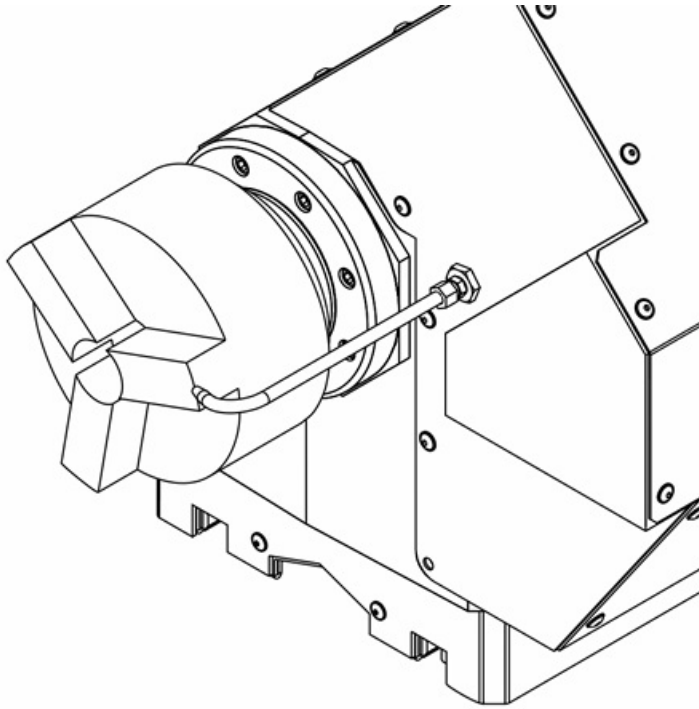
Example 2: The Air Jet Blast stays on for 0.5 seconds.

%


M12 P500;

%

Secondary Spindle Operation



- Secondary Spindle Air Jet Blast On: M112
- Secondary Spindle Air Jet Blast Off: M113

 **Note:** You can use the **P** code to control the time that the Air Jet Blast stays on.

Example 1: The Air Jet Blast stays on for 2 seconds.

%

M112 P2.;

%

Example 2: The Air Jet Blast stays on for 0.5 seconds.

%

M112 P500;

%