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We do it with a manual program (MNP) that's about 3 lines long. 1)G0 X8. Z-.5 M19 2) M31 3)G0 X8. Z2. M31 I think is the TS advance. On my machine, we change the Z-.5 in the first line to wherever we need to have the turret to trip the TS to extend. The X position can be whatever you want.

tailstock programming - Practical Machinist

5. Always keep this manual near the machinery for immediate use. 6. If a new manual is required, please order from the nearest Technical Center or TechnologyCenter with the manual No. or the machine name, serial No. and manual name. Issued by Manual Publication Section, Yamazaki Mazak Corporation, Japan. 01. 2006. MANUAL No. : H740HA0030E ...

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Mazak

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