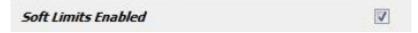
## Limits

μ (22:46	19) myCNC control software. Ver:1.88.2176- [lib-sh	ape-012.nc]	Soft limits on/of		
	CNC Settings Axes/Motors Network	Soft Limits Enabled Soft Limits	Limit Switch -	Limit Switch +	
	Hardware PLC     Software PLC     G-codes settings     DXF inport settings     Macro List     Macro Wizard     Proferences     Sorcean     Work Offsets     Parking Coordinates     Inputs/outputs/Sensors     Alarmos     Inputs/outputs/Sensors     Alarmos     Hore Strongh hanay inputs     Jog through ADC inputs     Jog through ADC inputs     ADC Mapping     Connections     Technology     Camera	Min Limit         Max Limit           X         I         0         3010           Y         I         0         1510         2           Z         I         -300         0         A           B         I         I         I         I           U         I         I         I         I           V         I         I         I         I           Jog slow down         I         I         I         I	Image: state	Image: Second	Hard limits activation
.11 ~ fit.		Slow down distance	X 50 Y 50 Z 20	A 5 B 5	C 5
	Advanced	Slow down value, %	X 20 🕂 Y 20 🕂 Z 20	🔂 A 20 🔂 B 20	<u></u>
	n on and off r each axis	Percentage reduction Setting the coordinates a			
0	Enabling function «Jog slow down» when limits are triggered	•			*

## Soft Limits Enabled

- "Soft Limits Enabled" this function allows you to set a software limit on the movement of the machine, as well as install and configure hard limit switches for each of the axes.
- To activate the function "Soft Limits Enabled" , it is necessary to check the box next to its name:



• To set the limits for each of the axes, you must check the selected axis. The photo shows an example of the choice of this function for the "X". With the parameters MihLimit = 0 and MaxLimit = 3010, the machine will move along the X axis only within the specified coordinates, i.e. from 0 to 3010.

Soft Limit	, LINDICO	Soft Limit	he-	-
		Son Linin	3	
		Min Limit	Max Limi	t
				_
х	V 0		3010	

• If there are mechanical limits on the machine, the type of the limit switch and the input number for this switch on the controller is set as shown in the example below.

Soft Limits Enabled		V		
	Soft Limits		Limit Switch -	Limit Switch +
	Min Limit	Max Limit		
x 💟 0	3010			sed 🔻 📝 8 🌩 Normally closed 🔻

For example, the minus limit sensor is applied to the controller input 5, and the positive limit sensor is applied to the 8 input of the controller. Both shoots are normally closed.

• The sensor type is selected as shown below.

Soft Limit	s Enab	led			V								
		6	oft Limits				Lii	mit Switch -			Lim	nit Switch +	
			Min Limit	Max Limit									
x		0	301	.0	V	5	* *	Normally closed		8	*	Normally closed	ł
Y		0	] [151	.0		6	A V	Normally opened		10	A V	Normally opened	
	-	10000	1.6		-	-	1223			 1	1220	<b>A B B B B</b>	-
z he sett	ing o	- <sub>300</sub> f severa	l axes (X,	Y, Z) is giv	ven be	4 Iow	*	Normally closed	*	4	A W	Normally closed	
	0.00	f severa			ven be			Normally closed	Ŧ	4	-	Normally closed	
he sett	0.00	f severa <i>led</i>					,	Normally closed	Ŧ			Normally dosed	
he sett	0.00	f severa Ied	l axes (X,				,		*				
he sett	0.00	f severa led	l axes (X,	Max Limit			Lim		•	1	imit	t Switch +	
he sett Soft Limit	<del>s Enabl</del>	f severa	l axes (X, o <b>ft Limits</b> Min Limit	Max Limit	<b>V</b>	low	Lim	nit Switch -		L	imit	t Switch +	-

## Jog slow down

- Function "Jog slow down" when this function is activated, the machine during the movement will reduce the speed at the entrance to the above specified software limits. The distance at which the speed decreases and the percentage reduction in speed is set in the corresponding table.
- To activate the function "Jog slow down", it is necessary to check the box next to its name:

Jog slow de	own	e.								V							
• The example below shows the se	etti	ng of the	f	unct	tion fo	r	seve	ral a	IХ	es (X, `	Y,	Ζ,	A, B	8)			
Jog slow down	V																
Slow down distance	Х	50	Y	50		z	20		A	5		в	5		С	5	
Slow down value, %	х	20	Y	20	<b></b>	Z	20	*	A	20	*	в	20	<b>*</b>	с	20	*

• Taking into account the settings of software limits and settings of the function, the machine will move with a speed reduced to 20% in the coordinates from 0 to 50 (0 + 50) and from 2960 to 3010 (2960 + 50 = 3010). Similarly, when moving along the coordinate Y in coordinates from 0 to 50 (0 + 50) and from 1460 to 1510 (1460 + 50 = 1510) it will move with a speed reduced to 20%. In the same way, when moving along the coordinate Z, in the coordinates from -300 to -280 (-300 + 20 = -280) and from -20 to 0 (0-20 = -20) it will move with a speed reduced to 20%.

Soft Limit	s Enabl	led											
			Soft Limits			Lin	nit Switch -			nit Switch +			
			Min Limit	Max Limit									
x		0	3010		5	(A) (V)	Normally closed	•	<b>V</b>	8	* *	Normally closed	•
Y		0	1510		6	<b>A</b> <b>V</b>	Normally closed	•		10	(A) (V)	Normally opened	•
Z	V	-300	0		4	<b>A</b>	Normally closed	•	V	4	4	Normally closed	•

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