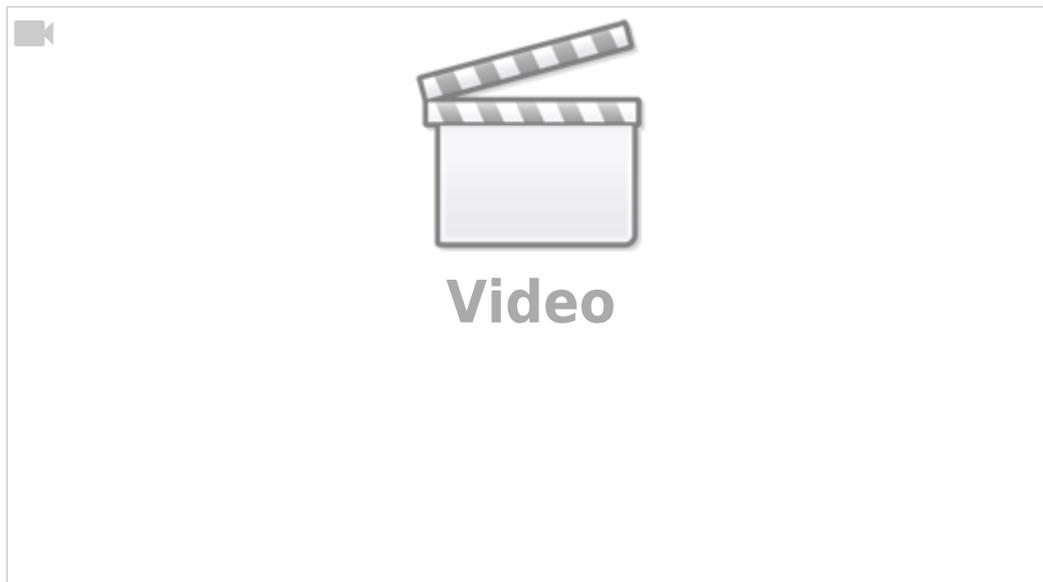


Servo ON/OFF



Summary: It is necessary to have the following 4 Software PLC commands: `__HANDLER_INIT` to start the servo when the myCNC software is turned on, `__HANDLER_EXIT` to turn the servo off when the software is shut down, `__HANDLER_SERVO_ON` to manually turn on the servo, and `__HANDLER_SERVO_OFF` to manually turn it off. This is done through the use of the 60000 and 60001 global variables.

The Servo ON and Servo OFF commands allow the user to create an automatic PID ON/OFF (for example, when opening/closing the myCNC software), as well as a manual set of buttons or commands to turn on and off the servo motor(s).

The automatic turning on and off of the servo motor on software start/close can be done by going into Settings > Config > PLC > Software PLC and creating `__HANDLER.INIT` and `__HANDLER_EXIT` files (if they do not yet exist) with the following code:

[__HANDLER_INIT.PLC](#)

```
main()
{
  gvarset(60000,1); //turn Servo PIDs On
  exit(99);
};
```

[__HANDLER_EXIT.PLC](#)

```
main()
{
  gvarset(60001,1); //turn Servo PIDs Off
  exit(99);
};
```

The screenshot shows the myCNC control software interface. The top navigation bar includes tabs for SYS, PLC, Log, Config, Info, Support, and Camera. The main window is titled "myCNC control software. Ver:1.88.3580- [/home/mycnc/DNC//Height Mapping/678.gbr_iso_cnc.txt]". The left sidebar shows a tree view of CNC Settings, with "Software PLC" selected. The main area is divided into three sections: "PLC Sources", "PLC Includes", and a code editor. The "PLC Sources" section lists various handlers, with "_HANDLER_INIT" selected. The "PLC Includes" section lists several OK status messages. The code editor shows the following code:

```

main()
{
  gvarset(60000,1); //run Servo ON procedure

  // gvarset(8131, 1000000); //set Frequency acceleration
  // gvarset(8132, 1359); //set Ratio
  // gvarset(8133, 0); //Off the Generator.

  exit(99);
};

```

As can be seen, writing 1 to the register 60000 will turn the PIDs on, while writing 1 to register 60001 will turn the servo PIDs off. This will also be used in manual servo control, where an on-screen button can be utilized to quickly switch the motor on and off.

In order to do so, it is necessary to have the `__HANDLER_SERVO_ON` and `__HANDLER_SERVO_OFF` commands in the Software PLC section. These can be extremely similar to the INIT and EXIT commands shown above, as they effectively perform the same task (differences begin to crop up only when additional actions are required on servo startup, or on program start, etc). By default, the following code is required for each respective PLC command:

[__HANDLER_SERVO_ON.PLC](#)

```

main()
{
  gvarset(60000,1); //turn Servo PIDs On
  exit(99);
};

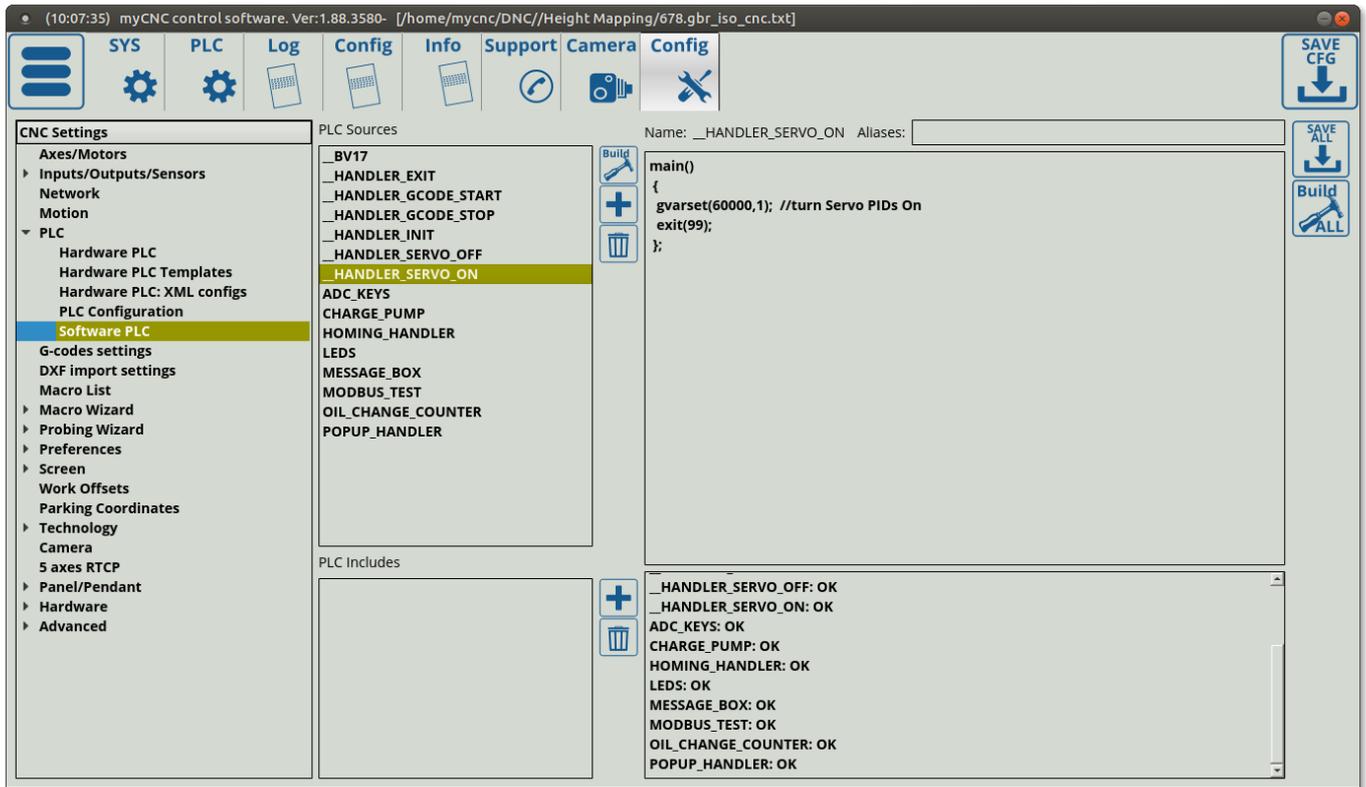
```

[__HANDLER_SERVO_OFF.PLC](#)

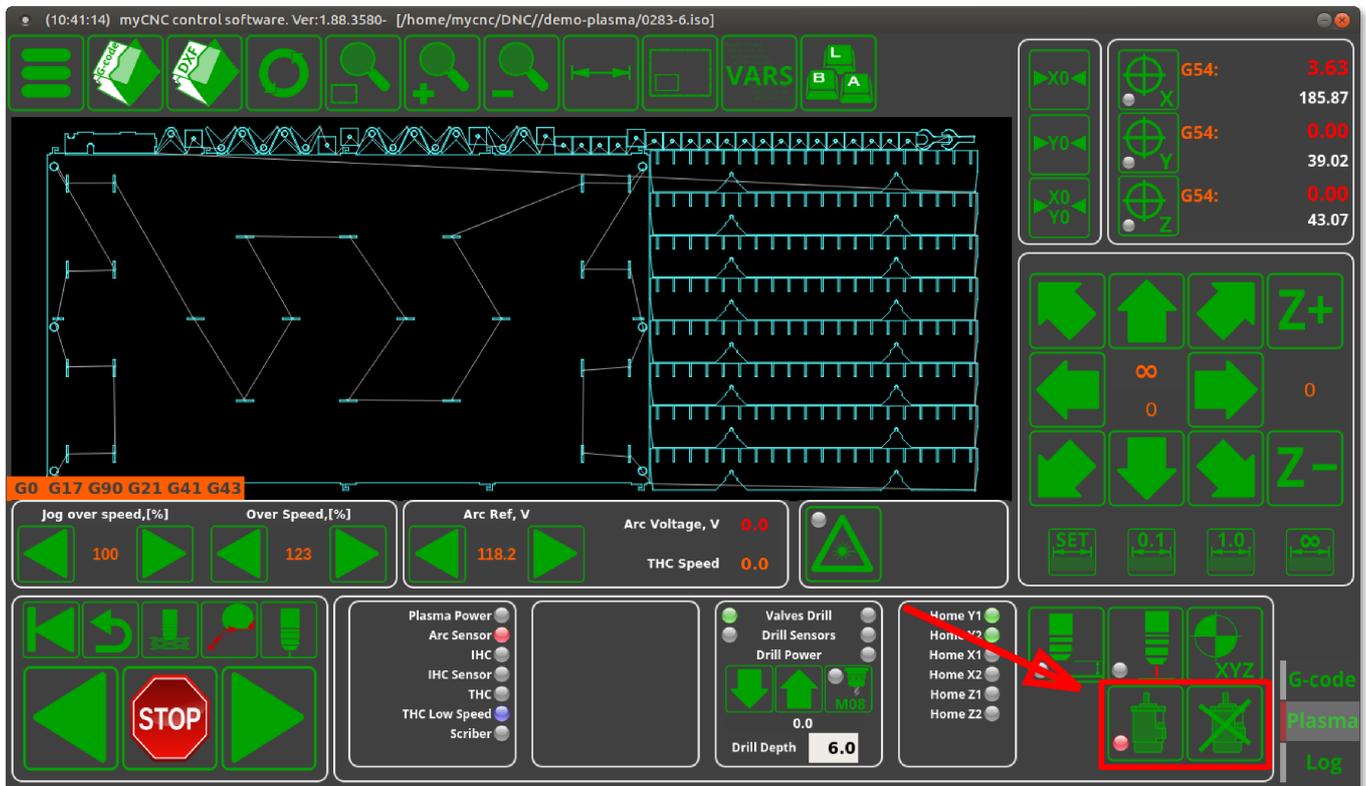
```

main()
{
  gvarset(60001,1); //turn Servo PIDs Off
  exit(99);
};

```

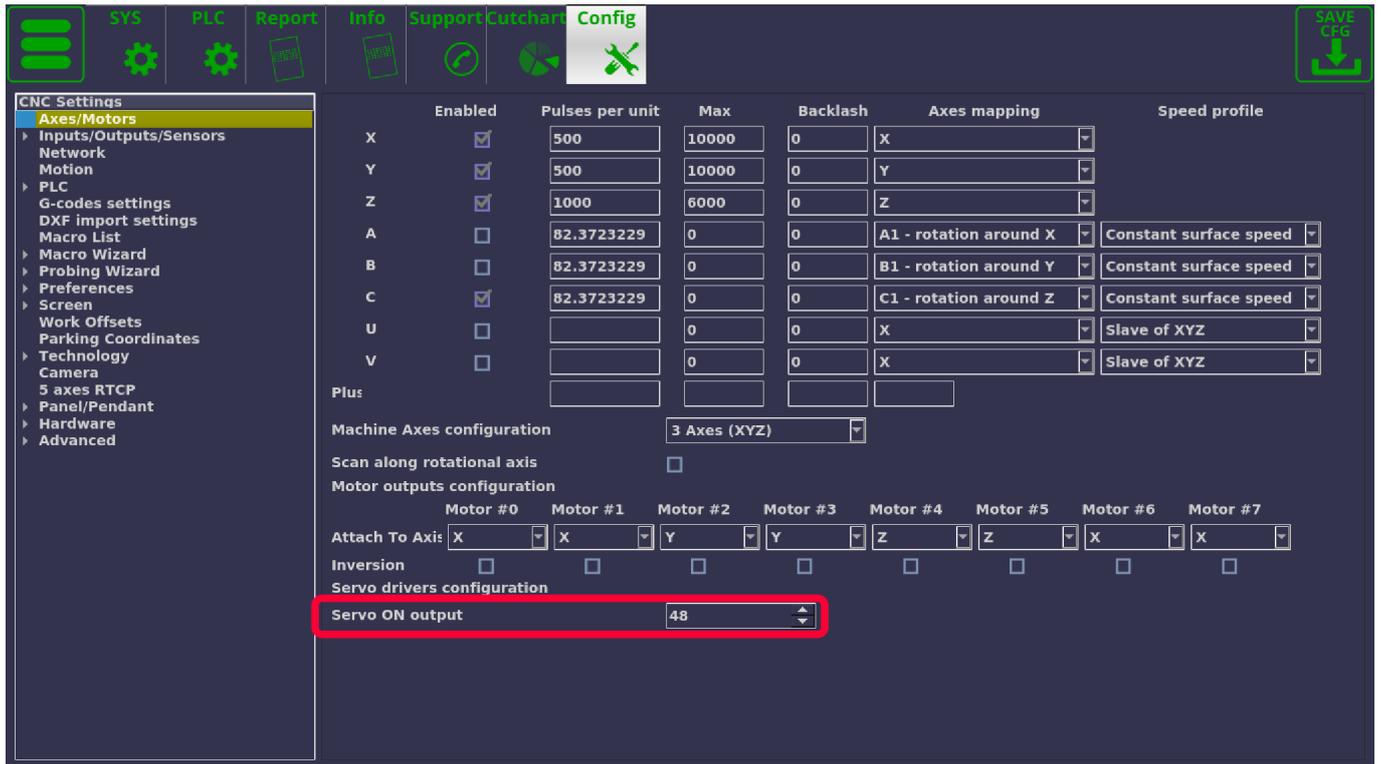


The manual code allows to use buttons to turn on and off the servo motor such as seen in the X1366P Plasma profile:



! Please note that on a number of default myCNC profiles, these button have a “pressed-delay-500” event assigned to them. This means that the buttons need 500ms of delay when clicking to be activated, to prevent accidental misclicks. If you do want to toggle the servos on via these buttons, make sure that you click and hold them for at least half a second.

The Servo ON output for enabling/disabling the servo should be set in Settings > Config > Axes/Motors:



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Permanent link: http://docs.pv-automation.com/mycnc/servo_on_off

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