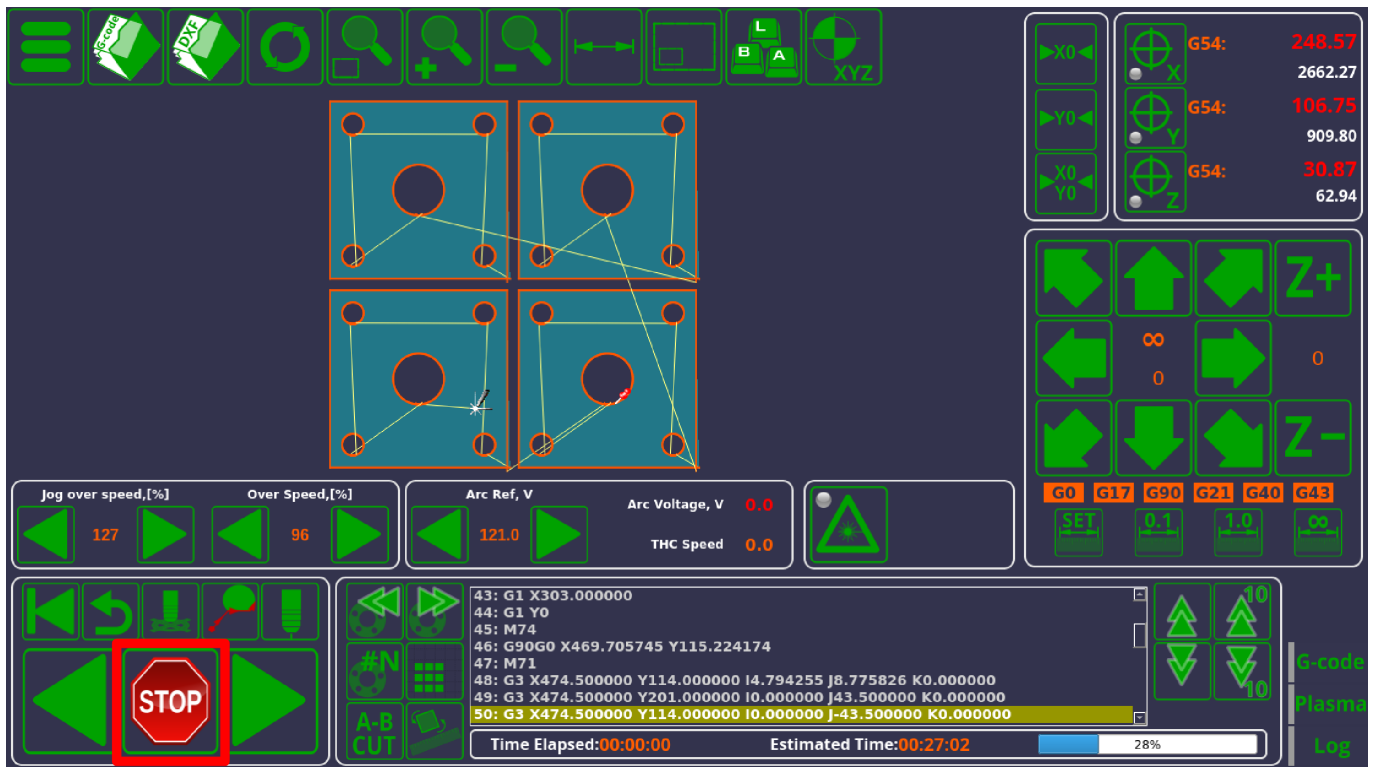


# Stop/End program button commands



When using myCNC, the actions performed by the program when the Stop button is pressed are defined in the following files:

- M02.plc (Settings > Config > PLC > Hardware PLC)
- OFF.plc (Settings > Config > PLC > Hardware PLC)
- \_\_HANDLER\_GCODE\_STOP (Settings > Config > PLC > Software PLC)

The actions taken upon pressing the button differ depending on the sequence of events. If pressing ONCE, the M02.plc procedure is started (below is the M02.plc for the Plasma profile X1366P):

## M02.plc

```
#include pins.h
#include vars.h
#include func_plasma.h

main()
{
    timer=0;

    portclr(OUTPUT_DRILL_VALVE_DOWN);
    portset(OUTPUT_DRILL_VALVE_UP);
    portclr(OUTPUT_DRILL_POWER);

    stop_thc();
    stop_trigger1();
}
```

```
//turn off power source
portclr(OUTPUT_PLASMA);

portclr(OUTPUT_PROBE);
test_lift_after_cut();
do_lift_after_cut();
proc=plc_proc_idle;

start_trigger2();
exit(99);
};
```

If the Stop button is pressed twice, the OFF.plc procedure will be utilized:

#### OFF.plc

```
#include pins.h
#include vars.h
#include func_plasma.h

main()
{

    portclr(OUTPUT_DRILL_VALVE_DOWN);
    portset(OUTPUT_DRILL_VALVE_UP);
    portclr(OUTPUT_DRILL_POWER);


    //stop_thc();
    //stop_trigger1();


    //turn off power source
    portclr(OUTPUT_PLASMA);
    portclr(OUTPUT_PROBE);
    //proc=plc_proc_idle;

    exit(99);
};
```

Additionally, whenever the player stops running G-code, the `__HANDLER_GCODE_STOP` Software PLC which is continuously running in the background will be activated. By default, the `__HANDLER_GCODE_STOP` simply consists of the following code:

#### `__HANDLER_GCODE_STOP`

```
main()
{
    exit(99);
}
```

```
};
```

Therefore, in a default configuration, this handler will simply activate, do nothing and then close. However, in situations where it is necessary to add a command which will activate whenever the G-code run has stopped, `__HANDLER_GCODE_STOP` can be used.

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