

Subroutines in myCNC



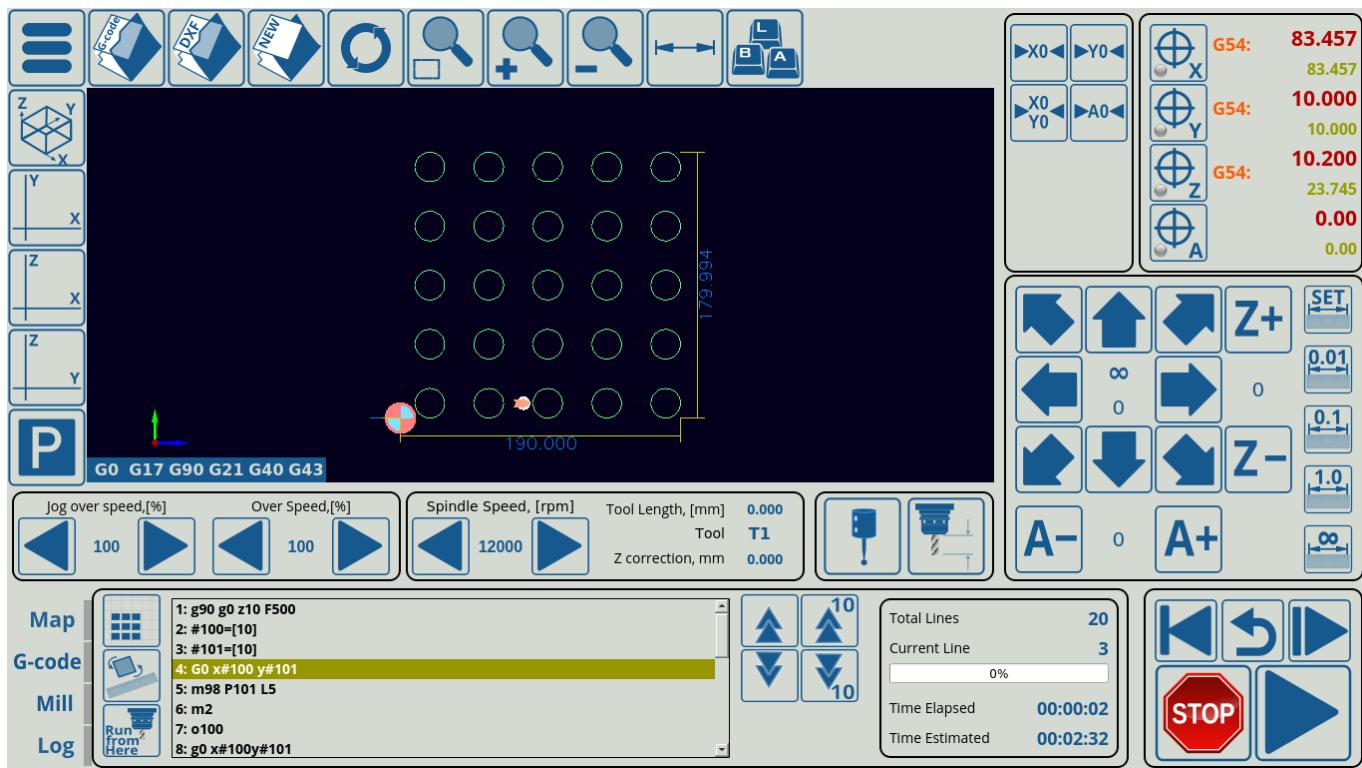
Video

Subroutines in myCNC are done in a manner similar to other industrial CNC systems.

Sample code of a G-code program containing subroutines #100 and #101:

```
G90 G0 Z10 F500
#100=[10]
#101=[10]
G0 X#100 Y#101
M98 P101 L5
M2
0100
G0 X#100Y#101
G1Z0
G2 X#100 Y#101 I10
#100=[#100+40]
G0 Z10
M99
0101
M98 P100 L5
#100=[10]
#101=[#101+40]
M99
```

The resultant program will look the following way:



Subroutines are called using the following syntax:

M98 P[SUBROUTINE NUMBER] L[NUMBER OF REPETITIONS]

As can be seen in the code above, this takes the form of

M98 P100 L5

The M99 code is used inside the subroutine that is being called to indicate the end of that subroutine.

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