

PLC Predefined (Reserved) Procedure names

Most of PLC procedure names represent miscellaneous code. However there are a few reserved PLC names used as a standard event handlers.

Table. List of reserved PLC Procedures

PLC name	PLC description
EST	Emergency Stop Handler - procedure executed if Emergency Stop Button pressed. Emergency Stop Input is General purpose binary input assigned as Emergency in Alarms configuration dialog
OFF	OFF moving procedure executed when Stop button pressed. Procedure may contain Stop Handler - stop motion program, clear motion buffer, lift tool to safe height, Off spindle (plasma power source, laser, gas cutting or so)
SPN	Spindle Speed Control - Procedure executed if on-screen Spindle button pressed (Spindle speed +, -, set) or single "S" code executed when g-code program running
TRIG01 - TRIG08	Trigger #1-#8 Activated Handler procedures. Procedure executed when if corresponding trigger activated. Trigger is General purpose input defined in Triggers configuration dialog and activated in PLC procedure.

Additionally, different M-codes are typically reserved for certain procedures. It's recommended to use codes M101-M999 for custom procedures.

Name	M-code number
G_M_USER_BEGIN_1	75
G_M_USER_END_1	88
G_M98_SUB_RUN	98
G_M99_SUB_END	99
G_M_USER_BEGIN	101
G_M_USER_END	199
G_M_MYUSER_BEGIN	200
G_M_MYUSER_END	999

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Last update: **2021/08/26 15:18**